Arntz

Made in Germany

PRODUCT CATALOGUE

BAND SAW BLADES

Edition 2024.1

HIGH PERFORMANCE BAND SAW BLADES

SAWING TECHNOLOGY IS OUR PASSION

We are an internationally positioned manufacturer and trend-setting technologist of high-end Band Saw Blades. We specialise in customised solutions for cutting metals and all common construction and insulating materials.

For 230 years, ARNTZ has been a plannable partner for a wide range of industries – from steel construction and light metal casting to aerospace. Being a 7th generation family-owned company, we speak from experience and use our technical know-how for cutting-edge product developments, always standing by our customers' side.

Our sales team and engineers know the special features and requirements of themost diverse band saw machines and solve your sawing tasks with passion. Three modern production sites and an international sales network guarantee our comprehensive service, even in your vicinity.

The ARNTZ expert team provides you with close support at all levels of the purchasing process and beyond. We regularly provide training on basic questions all the way to fine-tuning your cutting process.

Your goal is our motivation!

Facts and figures

- Established in 1793 by Johann Wilhelm Arntz
- 7th generation ownership
- Over 230 years of tooling production
- Manufacturer of high-performance Band Saw Blades
- Manufacturing locations in Germany and USA
- Global distribution network covers 80 countries
- Supplier of Power Tool Accessories

At your side worldwide


Johann Wilhelm Arntz
*1736 † 1834


Johann Ferdinand Arntz
*1806 † 1867


Johann Wilhelm Arntz
*1846 † 1908


Johann Wilhelm Arntz
*1873 † 1932


Johann Wilhelm Arntz
*1908 † 1957


Johann Wilhelm Arntz
*1939 † 2021

1793 Company founded as a hammer mill

1900 Saw blade production

1944 Production of segmental circular saw blades

1966 Entry Johann Wilhelm Arntz

1978 Production of carbide circular saw blades

1981 Foundation ARNTZ, Inc. in Summerville, USA

1988 Start production of Bi-Metal Band Saw Blades

1990 Foundation of ARNTZ Sägetechnik GmbH Schmölln

1996 Entry Jan Wilhelm Arntz

1999 Foundation ARNTZ Netherlands

2001 Start of Carbide Tipped Band Saw Blade production

2010 Foundation of the welding centre Schmölln

2015 Relocation / site expansion ARNTZ SLN

2017 Expansion of Bi-Metal and carbide production capacity

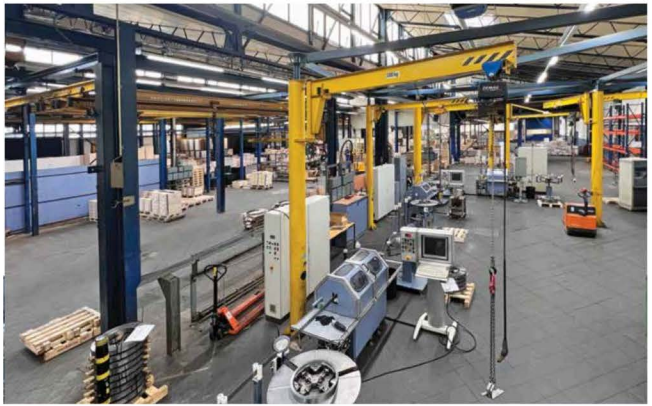
2022 Capacity expansion to one of the largest welding centres in Europe

2023 230 years ARNTZ

PRODUCTION

Bi-Metal and Carbide Tipped Band Saw Blades

Our state-of-the-art facility is equipped with cutting-edge technology along with innovative design to optimize efficiency and precision while raising production and service standards. This ensures that every product reflects our craftsmanship, consistency as well as reliability to ensure customer satisfaction.



THE RIGHT BREAK-IN

Guarantee for extended blade life

Breaking in a Band Saw Blade is essential to ensure its optimal performance and longevity. This process involves gradually acclimating the blade to tension, temperature, running the machine at slower cutting rates to ensure proper functionality before full operation.

Why is Break-in important?

- New teeth are very sharp and fragile
- Prevents premature tooth edge fracturing
- Break-in improves overall blade life and cut finish

Instructions

- Reduce band speed by 20% (if you have vibration continue to reduce)
- Reduce feed rate by 20% to 50% depending on material machinability (Harder material requires a higher feed rate reduction)
- Small adjustments to blade speed or feed rate may be necessary if noise or vibration occurs
- Gradually increase feed rate until normal cutting rate are achieved

MISSION STATEMENT – THE **ARNTZ 3S**

SIMPLIFY

We have a complete product range that offers a competitive and concise solution to the most diverse sector needs on the market

SUPPORT

We have a dedicated, skilled and qualified team to support on-site as well as on the phone

SERVICE

We are dedicated to offer efficient and consistent service solutions to an increasingly demanding market

R-TEC
Faster, Straighter, Longer!

Second generation ramping technology with improved design capability to give custom made solutions to the most challenging applications.

Benefits

- Increases tooth penetration without adding more machine feed pressure
- Allows the blade to cut a wider range of dimensions
- Precise edge radius control to reduce backer fatigue and improve blade life
- A newly developed sawing concept that supports coolant and filtration systems to increase speed, keeping production costs low
- Newly designed propriety software gives us maximum versatility in ramp design

The choice of the correct toothing for the material cross section to be cut is decisive for the optimum use of a Bi-Metal Band Saw Blade.
The combi-tooth with variable tooth pitch is recommended for low-vibration sawing. Vibration resonances are reduced.

Toothing recommendation for solid material

Cross section mm	Teeth per inch tpi
from 550	0,75/1,25
380 - 750	1/1,3
250 - 550	1,4/2
120 - 350	2/3
80 - 140	3/4
60 - 110	4/6
40 - 70	5/7 | 5/8
30 - 60	6/10
20 - 40	8/11 | 8/12
to 25	10/14

Toothing recommendation for thin-walled profiles

Wall thickness in mm	Profile outer diameter in mm 20	40	60	80	100	120	150
2	14	14	14	14	14	14	10/14
3	14	14	14	14	10/14	10/14	8/11 | 8/12
4	14	14	10/14	10/14	8/11 | 8/12	8/11 | 8/12	6/10
5	14	10/14	10/14	8/11 | 8/12	8/11 | 8/12	6/10	6/10
6	14	10/14	8/11 | 8/12	8/11 | 8/12	6/10	6/10	5/7 | 5/8
8	14	8/11 | 8/12	6/10	6/10	5/7 | 5/8	5/7 | 5/8	5/7 | 5/8
10	-	6/10	6/10	5/7 | 5/8	5/7 | 5/8	5/7 | 5/8	–

Especially when cutting profiles, the choice of toothing has a decisive influence on the sawing result. The variable tooth pitch has proven to be the ideal toothing. The required tooth pitch depends on the wall thickness and diameter of the profiles to be cut. The tables apply to single cuts. If two or more profiles are cut next to each other, the tables apply taking into account two times the wall thickness with a single profile outer diameter.

Toothing recommendation for thick-walled profiles

Wall thickness in mm	Profile outer diameter in mm 80	100	120	150	200	300	500	750
10	-	-	-	4/6	4/6	4/6	3/4	2/3
15	4/6	4/6	4/6	4/6	4/6	3/4	2/3	2/3
20	4/6	4/6	4/6	4/6	3/4	3/4	2/3	2/3
30	4/6	4/6	4/6	3/4	3/4	2/3	2/3	2/3
50	-	-	3/4	3/4	2/3	2/3	2/3	1,4/2
80	-	-	-	-	2/3	2/3	1,4/2	1,4/2
100	-	-	-	-	-	2/3	1,4/2	1,4/2

ARNTZ Bi-Metal Band Saw Blades are supplied as endless welded loops to fit your band saw machines, or in coils.
Coils can be delivered in different coil length. Please notice that the minimum order quantities refer to the production length.

6-13 mm in length of approx 30+76 m | 20-34 mm in length of approx 100 m | 41 mm in length of approx 80 m
54-67 mm in length of approx 90 m | 80 mm in length of approx 40 m

EHS: Wide set for larger cutting width

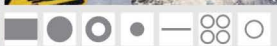
- Band Saw Blades in this special design have a particularly wide tooth restriction and thus a larger cutting width
- Prevents jamming of the saw blade in the cutting channel for wide and thick-walled steel profiles, bundle cuts, and materials with residual stress

Article group 431

BI-METAL

SPRINT-PLUS

- Classic tooth geometry to suit all your general-purpose needs
- Variable tooth design for a wider range of material sizes
- M42 HSS tooth tip for long and reliable performance



M42

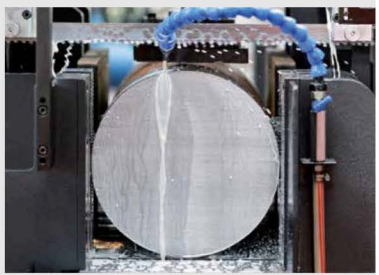
Dimensions		Tooth													
mm	inch	0,75/1,25	1,4/2	2/3	3	3/4	4	4/6	6	5/8	6/10	8/12	10/14	14	18
6 x 0,90	1/4 x 0,035												■		
10 x 0,90	3/8 x 0,035						■						■		
13 x 0,65	1/2 x 0,025						■		■	■	■	■	■	■	■
13 x 0,90	1/2 x 0,035				■		■		■	■	■	■	■		
20 x 0,90	3/4 x 0,035				■			■		■	■	■	■	■	■
27 x 0,90	1 x 0,035			■	■	■	■	■		■	■	■	■	■	
34 x 1,10	1 1/4 x 0,042		■	■		■		■		■	■	■			
41 x 1,30	1 1/2 x 0,050		■	■		■		■		■	■				
54 x 1,30	2 x 0,050		■	■		■									
54 x 1,60	2 x 0,063	■	■	■		■		■							
67 x 1,60	2 5/8 x 0,063	■	■	■											
80 x 1,60	3 x 0,063	■	■												

Article group 544

BI-METAL

BLIZZARD-PRO

- Classic tooth geometry to suit all your general-purpose needs
- Variable tooth design for a wider range of material sizes
- M51 HSS tooth tip for improved wear resistance



M51

Dimensions		Tooth						
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3	3/4	4/6	5/8
27 x 0,90	1 x 0,035				■	■	■	■
34 x 1,10	1 1/4 x 0,042				■	■	■	
41 x 1,30	1 1/2 x 0,050			■	■	■		
54 x 1,60	2 x 0,063		■	■	■			
67 x 1,60	2 5/8 x 0,063	■	■	■	■			
80 x 1,60	3 x 0,063	■	■	■				

Article group 457

BI-METAL

X-FIT

- Robust tooth geometry that provides excellent shock resistance
- Modified guilt design to reduce vibration
- Progressive tooth set pattern to avoid material pinching

M42

Dimensions		Tooth				
mm	inch	2/3	3/4	4/6	5/7	8/11
20 x 0,90	3/4 x 0,035			■	■	■
27 x 0,90	1 x 0,035		■	■	■	■
34 x 1,10	1 1/4 x 0,042	■	■	■	■	
41 x 1,30	1 1/2 x 0,050	■	■			

Article group 445

BI-METAL

PROFILER

- The powerhouse for machining large profiles and beams
- Extended blade life due to robust tooth design even in bundle cutting with chip nests
- Extra wide set prevents jamming in materials with high residual stress

M42

Dimensions		Tooth	
mm	inch	2/3	3/4
41 x 1,30	1 1/2 x 0,050	■	■
54 x 1,30	2 x 0,050	■	■
54 x 1,60	2 x 0,063	■	■
67 x 1,60	2 5/8 x 0,063	■	

Article group 440

BI-METAL

X-CELL

NEW

- Aggressive tooth geometry to improve penetration in work-hardening applications
- Variable set and hi-lo tooth pattern for added penetration while reducing vibration
- High Chrome premium backer for a long blade life

M42

R-TEC OPTIONAL

Dimensions		Tooth			
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3
34 x 1,10	1 1/4 x 0,042				■
41 x 1,30	1 1/2 x 0,050			■	■
54 x 1,60	2 x 0,063		■	■	■
67 x 1,60	2 5/8 x 0,063	■	■	■	
80 x 1,60	3 x 0,063	■	■		

Article group 540

BI-METAL

X-CELL PRO

NEW

- Aggressive tooth geometry to improve penetration in work-hardening applications
- Variable set and hi-lo tooth pattern for added penetration while reducing vibration
- M51 HSS tooth tip for improved wear resistance

M51

R-TEC OPTIONAL

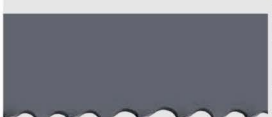
Dimensions		Tooth			
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3
34 x 1,10	1 1/4 x 0,042				■
41 x 1,30	1 1/2 x 0,050			■	■
54 x 1,60	2 x 0,063		■	■	■
67 x 1,60	2 5/8 x 0,063	■	■	■	
80 x 1,60	3 x 0,063	■	■	■	

Article groupe 437

BI-METAL

TYPHOON

- The powerhouse with ground tooth tips for robust performance in versatile applications on steels and non-ferrous metals up to 1400 N/mm² tensile strength
- Excellent cutting surfaces and precise cuts



M42

Dimensions		Tooth				
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3	3/4
27 x 0,90	1 x 0,035				■	■
34 x 1,10	1 1/4 x 0,042			■	■	■
41 x 1,30	1 1/2 x 0,050			■	■	■
54 x 1,30	2 x 0,050			■	■	■
54 x 1,60	2 x 0,063	■		■	■	■
67 x 1,60	2 5/8 x 0,063	■	■	■	■	■
80 x 1,60	3 x 0,063	■	■	■		

Article groupe 537

BI-METAL

TYPHOON-MAXIMA

- The top-tier of high-performance Band Saw Blades with ground teeth and extremely aggressive tooth geometry for materials up to 1700 N/mm² tensile strength
- Bi-Metal Band Saw Blade delivering carbide-level performance for heavy-duty cutting tasks on machines without carbide package
- Straight cuts with increased throughput, impressive machining rates and faster feeds

M51

Dimensions		Tooth			
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3
27 x 0,90	1 x 0,035				■
34 x 1,10	1 1/4 x 0,042				■
41 x 1,30	1 1/2 x 0,050			■	■
54 x 1,60	2 x 0,063		■	■	■
67 x 1,60	2 5/8 x 0,063	■	■	■	■
80 x 1,60	3 x 0,063	■	■	■	

Article group 401

BI-METAL

VL-PLUS

- The budget-friendly choice with a wide range of tooth profiles
- Versatile application for thin-walled profiles up to large solid material workpieces

M42

Dimensions		Tooth									
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14
13 x 0,65	1/2 x 0,025							■	■	■	■
13 x 0,90	1/2 x 0,035							■	■	■	■
20 x 0,90	3/4 x 0,035						■	■	■	■	■
27 x 0,90	1 x 0,035				■	■	■	■	■	■	■
34 x 1,10	1 1/4 x 0,042			■	■	■	■	■	■	■	■
41 x 1,30	1 1/2 x 0,050			■	■	■	■				
54 x 1,30	2 x 0,050			■	■	■	■				
54 x 1,60	2 x 0,063	■		■	■	■	■				
67 x 1,60	2 5/8 x 0,063	■	■	■	■	■					
80 x 1,60	3 x 0,063	■	■	■							

Article group 402

BI-METAL

VL-GP

- The budget-friendly multitool with a robust tooth design for varying cutting tasks
- Saves inventory costs with extended tool life in mixed operations
- Reduced blade changes

M42

Dimensions		Tooth					
mm	inch	2/3	3/4	4/6	5/7	8/11	12/16
20 x 0,90	3/4 x 0,035				■	■	■
27 x 0,90	1 x 0,035		■	■	■	■	■
34 x 1,10	1 1/4 x 0,042		■	■	■		
41 x 1,30	1 1/2 x 0,050	■	■	■	■		
54 x 1,60	2 x 0,063	■	■	■			
67 x 1,60	2 5/8 x 0,063	■	■				

Article group 626

CARBIDE TIPPED

BLACK-LINE TC

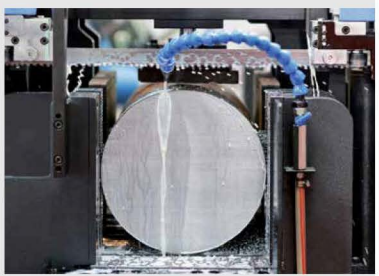
- Robust Triple chip geometry for consistent performance
- Positive tooth angle with hi-lo tooth design for increased penetration
- Carbide grade developed for robust performance

Dimensions		Tooth			
mm	inch	0,75/1,25	1/1,5	1,4/2	2/3
41 x 1,30	1 1/2 x 0,050			■	■
54 x 1,60	2 x 0,063		■	■	■
67 x 1,60	2 5/8 x 0,063	■	■	■	■
80 x 1,60	3 x 0,063	■		■	

Article group 622 CARBIDE TIPPED

BLACK-LINE S

- Modified triple chip geometry combined with set teeth
- Wide kerf to create excellent cut stability
- Robust performance in all machine types



Dimensions		Tooth				
mm	inch	0,75/1,25	1,4/2	2/3	3	3/4
20 x 0,90	3/4 x 0,035				■	
27 x 0,90	1 x 0,035			■	■	■
34 x 1,10	1 1/4 x 0,042		■	■		■
41 x 1,30	1 1/2 x 0,050		■	■		■
54 x 1,30	2 x 0,050		■	■		
54 x 1,60	2 x 0,063	■	■	■		
67 x 1,60	2 5/8 x 0,063	■	■			
80 x 1,60	3 x 0,063	■	■			

Article group 643 CARBIDE TIPPED

ALU-LINE

- Triple chip design
- Carbide grade designed for high abrasion
- Developed for high-speed nonferrous applications

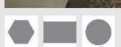
Dimensions		Tooth					
mm	inch	0,65/0,95	0,75/1,25	1,4/2	2/3	3	3/4
20 x 0,90	3/4 x 0,035					■	
27 x 0,90	1 x 0,035				■	■	■
34 x 1,10	1 1/4 x 0,042			■	■	■	■
41 x 1,30	1 1/2 x 0,050			■	■		■
54 x 1,30	2 x 0,050			■	■		
54 x 1,60	2 x 0,063		■	■	■		
67 x 1,60	2 5/8 x 0,063			■			
80 x 1,60	3 x 0,063	■	■	■			

Article group 660 CARBIDE TIPPED

SL-9

NEW

- High performance chrome backer with enhanced carbide grade for maximum performance
- Multi-chip geometry to provide faster cutting times
- High positive rake angle to increase penetration



Dimensions		Tooth				
mm	inch	0,75/1,25	1/1,5	1,4/2	2/3	3/4
34 x 1,10	1 1/4 x 0,035				■	■
41 x 1,30	1 1/2 x 0,050			■	■	
54 x 1,60	2 x 0,063	■	■	■	■	
67 x 1,60	2 5/8 x 0,063	■	■	■		
80 x 1,60	3 x 0,063	■		■		

Article group 650 CARBIDE TIPPED

SILVER-LINE

- Multi-chip design
- Developed for fast band speeds
- High positive rake angle to increase penetration

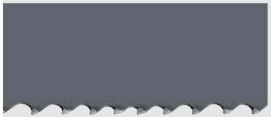
Dimensions		Tooth				
mm	inch	0,75/1,25	1/1,5	1,4/2	2/3	3/4
27 x 0,90	1 x 0,035				■	■
34 x 1,10	1 1/4 x 0,042			■	■	■
41 x 1,30	1 1/2 x 0,050			■	■	■
54 x 1,30	2 x 0,050			■	■	
54 x 1,60	2 x 0,063	■	■	■	■	■
67 x 1,60	2 5/8 x 0,063	■	■	■	■	
80 x 1,60	3 x 0,063	■		■		

Article group 651

CARBIDE TIPPED

SILVER-LINE N

- Multi-chip design
- Developed for fast band speeds
- High positive rake angle to increase penetration



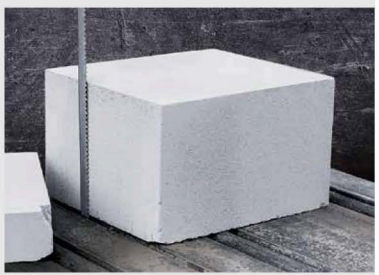
Dimensions		Tooth		
mm	inch	1,4/2	2/3	3/4
27 x 0,90	1 x 0,035		■	■
34 x 1,10	1 1/4 x 0,042		■	■
41 x 1,30	1 1/2 x 0,050	■	■	■
54 x 1,60	2 x 0,050	■	■	■

Article group 623

CARBIDE TIPPED

STONE-LINE S

- The confident choice for softer construction materials like aerated concrete, insulation boards, and insulating materials
- Set Carbide Tipped Band Saw Blade with wide clearance reduces jamming and buildup of deposits



Dimensions		Tooth
mm	inch	3
27 x 0,90	1 x 0,035	■

Article group 621

CARBIDE TIPPED

STONE-LINE RT

- The master for hard and abrasive construction materials like solid, engineered, and perforated bricks
- Vibration-free cutting with reduced force required due to high-performance, precision-ground tooth geometry
- Perfect cutting results

Dimensions		Tooth
mm	inch	2/3
27 x 0,90	1 x 0,035	■
34 x 1,10	1 1/4 x 0,042	■

Article group 490

BI-METAL

PAL-CUT

- The rustic for repair and dismantling of wooden pallets
- Special tooth geometry guarantees constant performance while sawing through nails and staples

Dimensions		Tooth
mm	inch	5/8
34 x 1,10	1 1/4 x 0,042	■

Article group 100

CARBON

CS-1

Flexible band back in pin-point quality with hardened teeth.
Suitable for everyday workshop purposes.

Dimensions		Tooth									
mm	inch	3	4	4	6	6	8	10	14	18	24
6 x 0,65	1/4 x 0,025	■		■		■	■	■	■	■	■
10 x 0,65	3/8 x 0,025	■		■	■	■	■	■	■	■	■
13 x 0,65	1/2 x 0,025	■		■	■	■	■	■	■	■	■
16 x 0,80	5/8 x 0,032	■		■	■		■	■	■	■	■*
20 x 0,80	3/4 x 0,032	■		■	■	■	■	■	■	■	■
25 x 0,90	1 x 0,035	■	■	■	■		■	■	■		

■ Neutral rake angle ■ Positive rake angle * = Special item

Article group 110

CS-2-PLUS

Spring hardened backer with hardened teeth.
For increased wear resistance and long tool life.

Dimensions		Tooth									
mm	inch	3	4	4	6	6	8	10	14	18	24
6 x 0,65	1/4 x 0,025			■		■		■	■	■	■
8 x 0,65	5/16 x 0,025		■	■					■		
10 x 0,65	3/8 x 0,025	■		■		■	■	■	■	■	
13 x 0,65	1/2 x 0,025	■		■	■	■	■	■	■	■	■
16 x 0,80	5/8 x 0,032	■						■	■	■*	
20 x 0,80	3/4 x 0,032	■	■	■	■		■	■*	■	■*	
25 x 0,90	1 x 0,035	■			■		■	■	■*		

■ Neutral rake angle ■ Positive rake angle * = Special item

GRIT EDGE BAND SAW BLADES

› For cutting special abrasive and hard materials

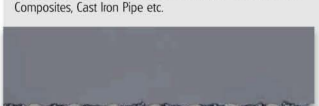
Continuous Edge

Use Continuous edge for material less than 1/4" thick or for hard materials with a tendency to fracture, crack, or chip easily.

Dimensions mm	inch	Coarse	Medium Coarse	Medium
10,0 x 0,64	3/8 x 0,025			■
12,5 x 0,51	1/2 x 0,020		■	■
12,5 x 0,64	1/2 x 0,025		■	■
19,0 x 0,81	3/4 x 0,032			■
25,0 x 0,89	1 x 0,035	■	■	
32,0 x 0,89	1 1/4 x 0,035	■		
32,0 x 1,07	1 1/4 x 0,042	■		

Gulleted Edge

Gulleted Edge recommended for use in Super Alloys, Fiberglass, Honeycomb, Foamed Glass, Hardened Steel, Graphite Composites, Cast Iron Pipe etc.



Dimensions mm	inch	Coarse	Medium Coarse	Medium
6,0 x 0,51	1/4 x 0,020		■	
10,0 x 0,64	3/8 x 0,025		■	■
12,5 x 0,51	1/2 x 0,020		■	■
12,5 x 0,64	1/2 x 0,025		■	■
19,0 x 0,81	3/4 x 0,032	■	■	
25,0 x 0,89	1 x 0,035	■	■	
32,0 x 0,89	1 1/4 x 0,035	■		
32,0 x 1,07	1 1/4x 0,042	■		

Select finer grit for finer finish. Use coarser grit for faster cutting. When the blade slows down in cut, turn blade inside out and continue cutting for up to an additional 25 % life.

PROFESSIONAL ACCESSORIES

Tension measuring device

Wrong tension of band can be the reason for crooked cuts or can cause blade breakage. Therefore, the band tension should be checked frequently.
Detailed instructions explain how to select and control the right tension of the band saw blade.

Refractometer

The correct concentration of cooling liquid is important for optimum life time of ARNTZ Band Saw Blades. To check the right concentration of liquid while operating it is recommended to use the ARNTZ Refractometer.

Application toolkit

Making sure your blade runs under perfect conditions. Featuring: Tension measuring device, refractometer, tacho-meter, accessories and more.

COOLING LUBRICANTS

- Oil-free cooling lubricants
- Reduction of disposal costs
- No fire or explosion hazard
- No oil mist (reduced health risks)
- Grease-free surfaces

NEW

POWER TOOL ACCESSORIES

All-in-one solutions for professionals

Discover our comprehensive range of top-tier machining tools and accessories for the cutting process. Everything in one place!

- Hole saws, annular cutter and intriguing set combinations
- Reciprocating saw blades, circular saw blades
- Hand hacksaw blades, power hacksaw blades

Contact our sales team for the brand new POWER TOOL ACCESSORIES catalogue!

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