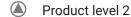


# **MARATHON® M42**

### The All-Rounder for Small and Large Cross Sections





Hook tooth

Solid materials

Band width 13 x 0.65 - 80 x 1.6mm Band width 1/2 x 0.025 - 3-1/8 x 0.063 Inch

### **Product Information**

## MARATHON® M42 – The All-Rounder for Small and Large Cross Sections

The MARATHON® M42 is the epitome of the economical band saw blade and stands for a broad application spectrum with consistently high quality.

The bimetal band saw blade for service-oriented customers is optimized for more complex performance and support requirements in the sawing process, such as those required for industrial applications.

The high quality features of MARATHON® M42 are now even more flexible in applications thanks to the expansion of the product line and are thus available for small cross-sections up to large solid materials.

The superfinishing of the band saw blade and the sharp cutting edges increase the blade-life and improve the quality of the cut. The fine band surface protects the machine's guides and increases fatigue strength.

### **Application Range**

#### **Application**

industrial applications

- · medium-sizedto large workpieces
- All metals up to 1000 N/mm² tensile strength
- · Solid material
- · Single, layer and bundle cutting
- · Mixed operation

#### **Advantages**

- Long blade-life and high productivity due to excellent product characteristics
- Less frequent blade changes due to broad application spectrum
- Low noise levels due to highly smooth and quiet running
- Lower material allowances required due to straight cuts/li>
- Reduced post-processing due to finer cutting surface
- · Significant costs per cut savings

#### **Features**

- · M42 cutting edge
- rake angle:positive (hooktooth)
- Constant or variable tooth pitch with standard setting



 High precision in straightness and planeness of the strip



# **Technical Data (1/2)**

Dimensions		Tooth pitch in ZpZ							
Width x thickness		variable							
mm	Inch	5-8	4-6	3-4	2-3	1.4-2	1-1.4		
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								
20 x 1.10	3/4 x 0.042								
27 x 0.90	1-1/16 x 0.035	К	К	K	K				
34 x 1.10	1-3/8 x 0.042	К	К	K	K	K			
41 x 1.10	1-5/8 x 0.042		К	K	K	K			
41 x 1.30	1-5/8 x 0.050	К	К	K	K	К			
54 x 1.30	2-1/8 x 0.050		К	K	K	К			
54 x 1.60	2-1/8 x 0.063		К	K	K	K	K		
67 x 1.60	2-5/8 x 0.063		K	K	K	K	K		
80 x 1.60	3-1/8 x 0.063				K	К	K		
Contact length	[mm] [Inch]	30-60 1.2-2.4	50-100 2-3.9	80-170 3.1-6.7	150-300 5.9-11.8	250-550 9.8-21.6	500-1000 19.7-39.4		

K = Hook tooth

With immediate effect, this dimension is now also converted to the new inline production. As a result, the saw band gains a high quality in the form of a glossy, smooth surface. The fine band surface protects the band guides of the machine and increases the fatigue strength.

<sup>\*</sup>Optimised superfinish:

#### **Bimetal Band Saw Blades**

# **Technical Data (2/2)**

Dimensions		Tooth pitch in ZpZ							
Width x thickness		variable	constant						
mm	Inch	0.75-1.25	6	4	3	1.25			
13 x 0.65	1/2 x 0.025		K*	K*					
13 x 0.90	1/2 x 0.035		K*	K*	K*				
20 x 0.90	3/4 x 0.035		К	K	K				
20 x 1.10	3/4 x 0.042				K				
27 x 0.90	1-1/16 x 0.035								
34 x 1.10	1-3/8 x 0.042					K			
41 x 1.10	1-5/8 x 0.042								
41 x 1.30	1-5/8 x 0.050								
54 x 1.30	2-1/8 x 0.050								
54 x 1.60	2-1/8 x 0.063								
67 x 1.60	2-5/8 x 0.063	K							
80 x 1.60	3-1/8 x 0.063	К							
Contact length	[mm] [Inch]	700-1400 27.6-55.1	50-80 2-3.1	80-120 3.1-4.7	120-200 4.7-7.9	300-800 11.8-31.5			

K = Hook tooth

With immediate effect, this dimension is now also converted to the new inline production. As a result, the saw band gains a high quality in the form of a glossy, smooth surface. The fine band surface protects the band guides of the machine and increases the fatigue strength.

<sup>\*</sup>Optimised superfinish:





# **Materials Overview**



- Case-hardening steels, spring steels and ball-bearing steels
- Rust-proof and acid-resistant steels (ferretic)
- Nitrided steel, high-speed steel and tool steel
- · Construction, deep-drawn and machining steels
- Carbon steels, and quenched and tempered steels
- Cast iron
- Aluminium / aluminium alloys
- Non-ferrous metals