YAMACUT

WHERE SOLUTIONS MEET PRODUCTION

Engineered for versatility and endurance, Yamacut bandsaw blades can be used across a wide range of materials.

YAMACUT
BANDSAW BLADE

WHAT PRODUCTS DO YOU PREFER?

CARBIDE TIPPED BANDSAW BLADE

- High Nickel Chrome Alloys
- Ti/Titanium Alloys
- Heat Resistant Steels
- High Temperature Alloy Steels
- Aluminum and for high speed cutting of Aluminum Alloys
- Other cutting application that M42 blade cannot be used

M51 BI-METAL BANDSAW BLADE

- Titanium / Titanium Alloys
- Alloy Tool Steels
- Stainless Steels
- High Speed Steels

M42 BI-METAL BANDSAW BLADE

- Stainless Steels
- Alloy Tool Steels
- Die Steels
- Spring Steels
- Bearing Steels
- Structural Steels
- Copper, Graphite, Aluminum
- Quality Carbon Steels

WHICH KIND OF MATERIALS DO YOU CUT?

STEEL NAME	NORMAL GRADE FOR CUTTING MATERIALS	BRAND
Carbon Steel	20#, 25#, 45#, 50#, 60#, 70#, 75#, 80#, 90#..	**M42**
Structural Steel	Q235(A3), Q345..	**M42**
Alloy Steel	20Cr, 40Cr, 35CrMo, 42CrMo, 16Mn, 25Mn..	**M42**
Tool Steel	W16, W10, W18..	**M42**
Die Steel	Cr12, 9SiCr, 5CrMnMo, SM45, H13..	**M42**
Stainless Steel	304, 316, 2Cr13, 3Cr13..	**M51, M42**
High-temperature Alloy Steel and Hard Cutting Materials	GH1015, GH1035, GH2018..	**Carbide Tipped Band Saw Blade**
	Titanium Alloy, Nickel-base Alloy, Process Hardening Stainless Steel, Surface Hardened Steel	

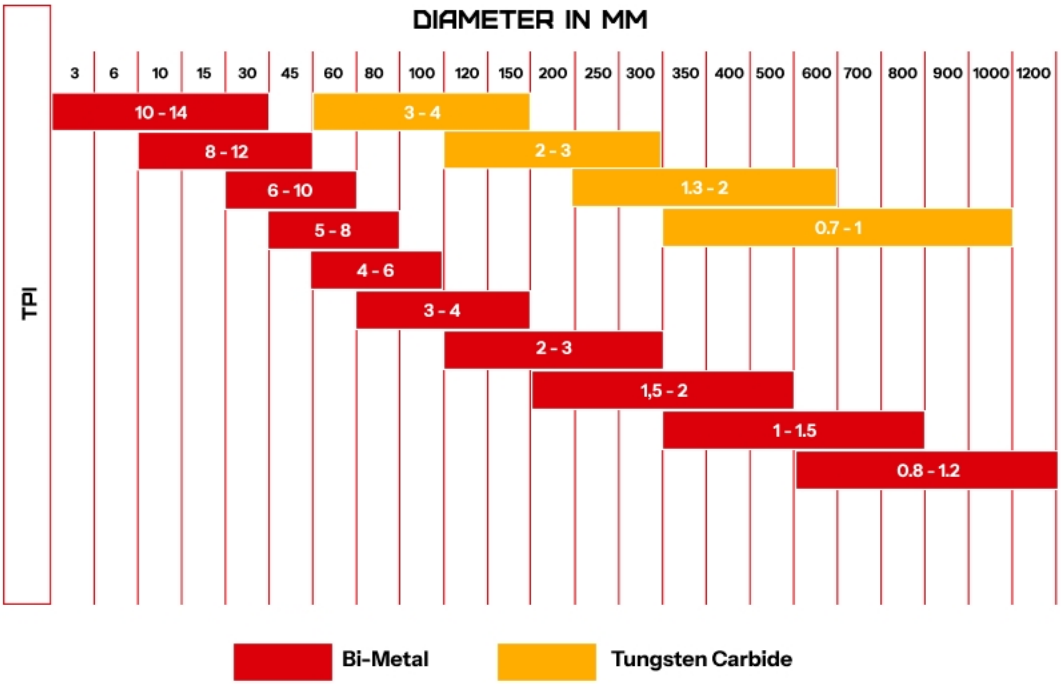
MATERIALS VERSATILITY
OF YAMACUT BANDSAW BLADE

SAFETY & STORAGE PROTOCOL
OF YAMACUT BANDSAW BLADE

For your safety, observe these essential instructions when handling or storing Yamacut metal saw blades:

- Exercise caution when opening welded bands, as they are shipped under high tension.
- Always wear safety shoes, gloves, a helmet, and goggles during unpacking and assembly.
- Do not remove tooth guards until the blade is fully mounted on the machine.
- Keep all covers closed during operation and use the main switch to power down before blade changes.
- Always follow the machine manufacturer's specific safety operating instructions.

PITCH SELECTOR
SOLID MATERIALS

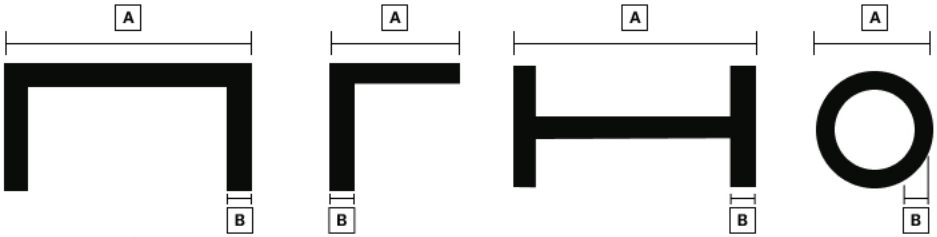


This selector can be used to easily find the correct pitch for cutting profiles and tubing. Select the maximum dimension of the part to be cut on the horizontal scale. Then check on the vertical column the wall thickness measured and find the advised pitch in the table. For faster cutting, the next larger pitch can be used. It is not advised to use a finer pitch as the overfilling gullets will break the teeth.

Cutting in Bundles :

- For round tubing double the single wall thickness and find the correct pitch.
- For square and rectangular tubing, take in consideration the maximum distance to cut in the bundle and the combined wall thickness.

PITCH SELECTOR
STRUCTURAL MATERIALS



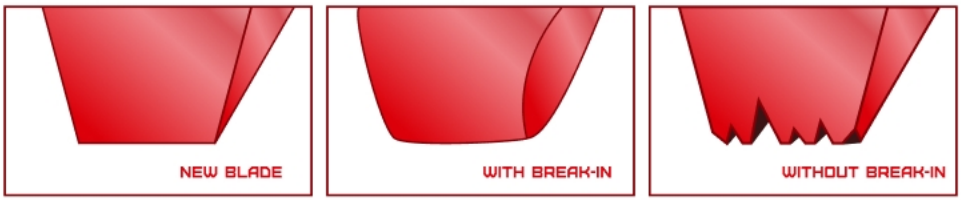
Wall Thickness in mm B	TPI (Teeth Per Inch) Dimension in mm B											
	20	40	60	80	100	150	150	200	300	500	750	1000
2	10 - 14	10 - 14	10 - 14	10 - 14	10 - 14	10 - 14	10 - 14	10 - 14	8 - 12	6 - 10	5 - 8	5 - 8
3							8 - 12	8 - 12	6 - 10	5 - 8	4 - 6	4 - 6
4					8 - 12	8 - 12	6 - 10	6 - 10	5 - 8	4 - 6		
5				8 - 12	6 - 10	6 - 10	5 - 8	5 - 8	4 - 6		3 - 4	3 - 4
6		8 - 12	8 - 12							3 - 4		
8		6 - 10	6 - 10	6 - 10	5 - 8	5 - 8	4 - 6	4 - 6	3 - 4		2 - 3	2 - 3
10				5 - 8			3 - 4	3 - 4		2 - 3		
12		5 - 8	5 - 8		4 - 6	4 - 6			2 - 3		1.5 - 2	1.5 - 2
15				4 - 6			3 - 4	2 - 3		1.5 - 2		
20			4 - 6		3 - 4	3 - 4	2 - 3		1.5 - 2		1 - 1.5	1 - 1.5
30				3 - 4				1.5 - 2		1 - 1.5		
50												
75												
100												
150												
200												

ADJUSTING PARAMETERS
ACCORDING TO CHIP FORM

Chip Form								
Condition	Burn and Heavy	Burn and Heavy	Thick Hard Springy	Thin Hard Springy	Thin Curly Springy	Thin Straight Springy	Powdery	Thin Tightly Curled
Color	Blue or brown	Blue or brown	Silver	Silver	Silver	Silver	Silver	Silver
Band Speed	Decrease	Decrease	Maintain	Decrease Slightly	Maintain	Maintain	Decrease	Maintain
Feed Rate	Decrease	Decrease	Decrease Slightly	Increase Slightly	Maintain	Increase	Increase	Decrease

BREAKING-IN A BANDSAW BLADE

When manufacturing a band saw blade, the tooth edges are initially extremely sharp. To ensure the teeth can withstand the cutting forces encountered during operation, the tips must be honed to develop a controlled, small edge radius. This honing process is achieved through a proper break-in procedure. If the break-in is not performed correctly, the sharp tooth edges may chip or deform under load, resulting in premature wear, reduced cutting performance, and significantly shorter blade life.



Breaking in The Blade

Bi-Metal *Procedure*

- Start at 50% feed for the first 20 minutes.
- Increase to 100% feed over the following 10 minutes (in 4 stages).
- Keep band speed at normal levels at all times.

Tension for Bi-Metal Bandsaw Blade

YAMACUT Bi-Metal blades are designed to handle up to 30.000PSI. The ideal tension range is around 25,000–35,000 PSI.

Minimum	**~25.000 PSI**
Ideal / Optimal	**30.000 PSI**
Maximum	**~35.000 PSI**

*If the tension is not set correctly, the blade may twist while cutting the material, which can lead to angled cuts, blade splitting, and premature breakage.

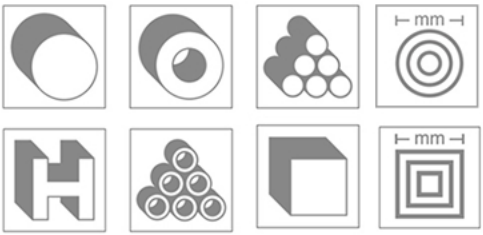
SPECIFICATIONS
OF YAMACUT BANDSAW BLADE

BLADE PRO M42

WIDTH X THICKNESS			TPI			
mm	1.0/1.3	1.5/2.0	2/3	3/4	4/6	5/8
20 x 0.90					✔	
27 x 0.90				✔	✔	✔
34 x 1.07			✔	✔	✔	✔
41 x 1.27			✔	✔	✔	
54 x 1.60		✔	✔	✔	✔	
67 x 1.60	✔	✔	✔	✔		
80 x 1.60	✔	✔				

The bi-metal bandsaw blade stands out as a leading steel-cutting tool due to its advanced material composition.
It features a sharp tooth tip made from high- performance high-speed steel, perfectly complemented by a saw blade body crafted from tough and elastic low-alloy spring steel.
As the products have passed ISO 9001:2015 Quality management system certificate Conformity.

APPLICATIONS
OF YAMACUT BANDSAW BLADE



- All metals in tubing, profile and small solids.
- Best choice for manual or semi-automatic machine.

SPECIFICATIONS
OF YAMACUT BANDSAW BLADE

BLADE MAX M42

WIDTH X THICKNESS	TOOTH PITCH IN TPI													
mm	10/14 0°	8/12 0°	6/10 0°	5/8 0°	4/6 7°	3/4 7°	3/4 9°	3/4 10°SH	2/3 7°	2/3 9°	2/3 10°SH	1.4/2 10°	1/1.5 10°	0.75/1.25 10°
19 x 0.9	✔	✔	✔	✔	✔	✔								
27 x 0.9	✔	✔	✔	✔	✔	✔		✔	✔		✔			
34 x 1.1		✔	✔	✔	✔		✔	✔		✔	✔	✔		
41 x 1.3			✔	✔	✔		✔	✔		✔	✔	✔		
54 x 1.6					✔		✔			✔		✔	✔	✔
67 x 1.6										✔		✔	✔	✔
13 x 0.65	4	6	8	10	14	18	24	6/10	8/12	8/10	10/14	14/18	18/24	

The BLADE MAX M42 is a highly versatile blade, featuring diverse tooth profiles for cutting all common materials. It utilizes a high-quality combination of high-strength M42 HSS teeth and high-alloy spring steel backing. Enhanced by a tooth hardening process for superior wear resistance, its distinct, special tooth design ensures a clear cutting advantage in standard and high-difficulty general-purpose sawing. As the products have passed ISO 9001:2015 Quality management system certificate Conformity.

68 HRc

Bi M42

BLADE MAX M42
[7 SPECIAL VARIABLE TEETH]

Compared with Blade Pro(Normal 3/4T)

- Higher sharpness and greater cutting power.
- Better durability without losing cutting efficiency.
- Superior chip removal and longer blade life.

APPLICATIONS
OF YAMACUT BANDSAW BLADE

- Aluminum/Non-ferrous Metals
- Carbon Steel
- Alloy Steel
- Stainless Steel
- Die Steel
- Tool Steel
- Structural Steel

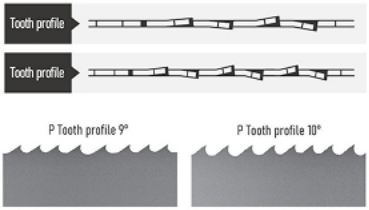
SPECIFICATIONS
OF YAMACUT BANDSAW BLADE

M51 ULTRA

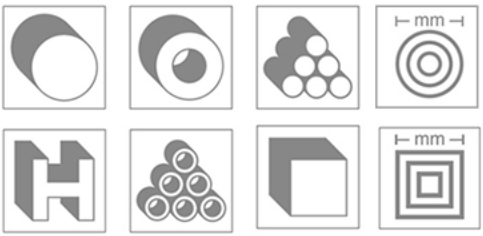
WIDTH X THICKNESS	TOOTH PITCH IN TPI								
mm	5/8 0°	4/6 7°	3/4 9°	3/4 10°SH	2/3 9°	2/3 10°SH	1.4/2 10°	1/1.5 10°	0.75/1.25 10°
27 x 0.9	✔	✔		✔		✔			
34 x 1.1	✔	✔	✔	✔	✔	✔			
41 x 1.3		✔	✔	✔	✔	✔	✔		
54 x 1.6			✔		✔		✔	✔	✔
67 x 1.6		✔					✔	✔	✔
80 x 1.6								✔	✔

The M51 Ultra is engineered for cutting challenging metals by featuring specialized, hardened M51 steel teeth for extreme durability and wear resistance, set on a tough, flexible body of high-alloy spring steel to ensure stability and reliable cutting performance across a wide range of high-hardness materials. The performance of our bandsaw blade using special teeth different from the others provides a clear cutting advantage.

As the products have passed ISO 9001:2015 Quality management system certificate Conformity.



APPLICATIONS
OF YAMACUT BANDSAW BLADE



- Aluminum/Non-ferrous Metals
- Carbon Steel
- Alloy Steel
- Stainless Steel
- Die Steel
- Tool Steel
- Structural Steel
- High Speed Steels
- Other Hard Cutting Materials

YAMACUT

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