

POWER HACK SAW BLADES

HSS Bi-Metal

Standard tooth; 0° rake angle

Manufactured from High Speed Steel, electron beam welded to a spring back, these bimetal blades are able to withstand heavy feed pressures, giving economical, high cutting rates. Because these blades are virtually unbreakable in normal use, they are particularly safe and therefore suitable for use by unskilled operators or on older machines. They will cut through most types of material including alloy and stainless steels.

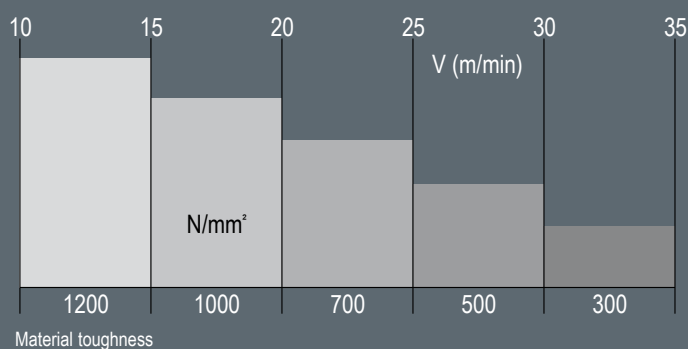
Other dimensions available on special production.

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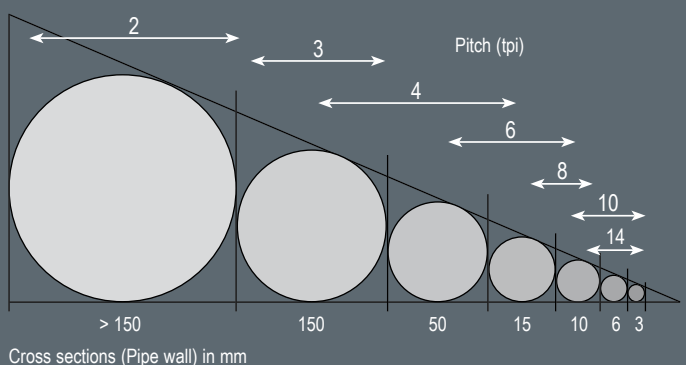
- length from centre pin hole to centre pin hole
- diameter of pin holes,
- width (from the top of the teeth to the backer)
- thickness of the blade, tooth spacing
(Number of teeth in a distance of 25.4 mm – or 1 inch)
- number of pin holes and their position (Kasto machines do not have central pin holes.)

Ref.	Dimension l-w-t (mm)	KASTO	Inch	Hole (mm)	Teeth per inch
F.MSBi 12-25	300 x 25 x 1.25		12	8.5	10 14
F.MSBi 12-32	300 x 32 x 1.60		12	8.5	6 8 10 14
F.MSBi 14-25	350 x 25 x 1.25		14	8.5	6 10 14
F.MSBi 14-32	350 x 32 x 1.60		14	8.5	4 6 8 10 14 18
F.MSBi 14-38	350 x 38 x 2.00		14	8.5	4 8 14
F.MSBi 16-32	400 x 32 x 1.60		16	8.5	4 6 8 10 14 18
F.MSBi 16-38	400 x 38 x 2.00	KASTO	16	8.5	6 10 14
F.MSBi 16-38	400 x 38 x 2.00		16	8.5	4 6 8 10 14
F.MSBi 17-32	425 x 32 x 1.60		17	8.5	6 8 10
F.MSBi 18-32	450 x 32 x 1.60		18	10.5	4 6 8 10 14
F.MSBi 18-38	450 x 38 x 2.00	KASTO	18	8.5	4 6 8 10 14
F.MSBi 18-38	450 x 38 x 2.00		18	10.5	4 6 8 10 14
F.MSBi 18-45	450 x 45 x 2.25		18	10.5	4 6 10
F.MSBi 20-38	500 x 38 x 2.00	KASTO	20	8.5	4 6
F.MSBi 20-38	500 x 38 x 2.00		20	10.5	4 6 10
F.MSBi 20-45	500 x 45 x 2.25		20	10.5	4 6 8 10
F.MSBi 20-50	500 x 50 x 2.50	KASTO	20	10.5	3 4 6 8 10
F.MSBi 20-50	500 x 50 x 2.50		20	13	3 4 6 8 10
F.MSBi 21-45	525 x 45 x 2.25		21	10.5	4 6 10
F.MSBi 22-45	550 x 45 x 2.25		22	10.5	4 6 10
F.MSBi 22-50	550 x 50 x 2.50	KASTO	22	10.5	3 4 6 8 10
F.MSBi 22-50	550 x 50 x 2.50		22	13	3 4 6 8 10
F.MSBi 23-45	575 x 45 x 2.25		23	13	4 6 10
F.MSBi 23-50	575 x 50 x 2.50	KASTO	23	10.5	3 4 6 8 10
F.MSBi 23-50	575 x 50 x 2.50		23	13	3 4 6 8 10
F.MSBi 24-45	600 x 45 x 2.25		24	13	6
F.MSBi 24-50	600 x 50 x 2.50	KASTO	24	10.5	3 4 6 8
F.MSBi 24-50	600 x 50 x 2.50		24	13	3 4 6 8
F.MSBi 26-50	650 x 50 x 2.50	KASTO	26	10.5	3 4 6 8 10
F.MSBi 26-50	650 x 50 x 2.50		26	13	3 4 6 8 10
F.MSBi 28-50	700 x 50 x 2.50	KASTO	28	10.5	3 4 6 8 10
F.MSBi 28-50	700 x 50 x 2.50		28	13	3 4 6 8 10

Cutting Speed



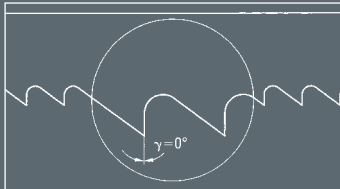
Range of applications



HSS Universal (AISI M2) ALLHARD; Standard tooth 0°

Universal saw blade

- Our universal saw blade for most cutting areas.
- Uncomplicated design, robust and reliable, but with maximum tool life even in the top toughness range.
- Produced from excellent high-speed steel.
- Manufactured with modern equipment, vacuum heat treated and steam tempered.



Ref.	Dimension l-w-t (mm)	Length (Zoll)	Teeth per inch	Weight (g)
F.MU 12-25N	300 x 25 x 1.25	12	8, 10, 14, 24	81
F.MU 12-25.1N	300 x 25 x 1.50	12	4, 6, 8, 10, 14	97
F.MU 12-30N	300 x 30 x 1.50	12	4, 6, 8, 10, 14, 24	117
F.MU 12-30.1N	300 x 30 x 2.00	12	4, 6, 8, 10, 14	156
F.MU 12-32N	300 x 32 x 1.50	12	4, 6, 10	125
F.MU 13-30N	325 x 30 x 1.50	13	4, 6, 8, 10, 14	126
F.MU 14-25N	350 x 25 x 1.25	14	6, 8, 10, 14, 24	94
F.MU 14-25.1N	350 x 25 x 1.50	14	6, 8, 10, 14, 24	113
F.MU 14-30N	350 x 30 x 1.50	14	4, 6, 8, 10, 14, 24	135
F.MU 14-30.1N	350 x 30 x 2.00	14	4, 6, 8, 10, 14	180
F.MU 14-32N	350 x 32 x 1.50	14	4, 6, 10	144
F.MU 14-32.1N	350 x 32 x 2.00	14	4, 6, 8, 10, 14	193
F.MU 14-35N	350 x 35 x 2.00	14	3, 4, 6, 8, 10, 14	211
F.MU 14-36N	350 x 36 x 1.50	14	4, 6, 10	163
F.MU 14-36.1N	350 x 36 x 2.00	14	4, 6, 8, 10	217
F.MU 15-30N	375 x 30 x 1.50	15	4, 6, 8, 10, 14	144
F.MU 16-25N	400 x 25 x 1.25	16	6, 8, 10, 14, 24	107
F.MU 16-25.1N	400 x 25 x 1.50	16	6, 10, 14, 24	128
F.MU 16-30N	400 x 30 x 1.50	16	4, 6, 8, 10, 14, 18, 24	153
F.MU 16-30.1N	400 x 30 x 2.00	16	3, 4, 6, 8, 10, 14	205
F.MU 16-32N	400 x 32 x 1.50	16	4, 6, 10	164
F.MU 16-32.1N	400 x 32 x 1.60	16	4, 6, 8, 10	175
F.MU 16-32.2N	400 x 32 x 2.00	16	4, 6, 8, 10, 14	218
F.MU 16-35N	400 x 35 x 2.00	16	3, 4, 6, 8, 10, 14	240
F.MU 16-36N	400 x 36 x 2.00	16	2, 3, 4, 6, 8, 10, 14	245
F.MU 16-38N	400 x 38 x 2.00	16	3, 4, 6, 10	259
F.MU 16-40N	400 x 40 x 2.00	16	3, 4, 6, 8, 10, 14	274
F.MU 17-30N	425 x 30 x 2.00	17	3, 4, 6, 8, 10, 14	218
F.MU 17-35N	425 x 35 x 2.00	17	3, 4, 6, 8, 10	254
F.MU 18-30N	450 x 30 x 1.50	18	6, 10, 14	174
F.MU 18-30.1N	450 x 30 x 2.00	18	4, 6, 8, 10, 14	231
F.MU 18-32N	450 x 32 x 1.50	18	4, 6, 10	185
F.MU 18-32.1N	450 x 32 x 2.00	18	4, 6, 8, 10, 14	247
F.MU 18-35N	450 x 35 x 2.00	18	4, 6, 8, 10	270
F.MU 18-38N	450 x 38 x 2.00	18	3, 4, 6, 8, 10, 14	293
F.MU 18-40N	450 x 40 x 2.00	18	2, 3, 4, 6, 8, 10, 14	308
F.MU 18-45N	450 x 45 x 2.00	18	3, 4, 6	347
F.MU 18-45.1N	450 x 45 x 2.25	18	3, 4, 6	382
F.MU 19-35N	475 x 35 x 2.00	19	4, 6, 8, 10	286
F.MU 20-38N	500 x 38 x 2.00	20	3, 4, 6, 8, 10, 14	325
F.MU 20-40N	500 x 40 x 2.00	20	3, 4, 6, 8, 10, 14	342
F.MU 20-40.1N	500 x 40 x 2.50	20	4, 6, 8, 10	428
F.MU 20-45N	500 x 45 x 2.00	20	3, 4, 6, 8	385
F.MU 20-48N	500 x 48 x 2.50	20	2, 3, 4, 6, 8, 10	523
F.MU 20-50N	500 x 50 x 2.50	20	3, 4, 6, 10	542
F.MU 21-38N	525 x 38 x 2.00	21	4, 6, 8, 10	341
F.MU 21-40N	525 x 40 x 2.00	21	4, 6, 8, 10	359
F.MU 21-45N	525 x 45 x 2.50	21	3, 4, 6, 8, 10	505
F.MU 21-45.1N	525 x 45 x 2.25	21	3, 4, 6	455
F.MU 21-50N	525 x 50 x 2.50	21	2, 3, 4, 6, 8	567
F.MU 22-40N	550 x 40 x 2.00	22	4, 6, 8, 10	375
F.MU 22-40.1N	550 x 40 x 2.50	22	4, 6	468
F.MU 22-45N	550 x 45 x 2.00	22	2, 3, 4, 6, 8, 10	421
F.MU 22-45.1N	550 x 45 x 2.50	22	3, 4, 6, 8, 10	527
F.MU 22-50N	550 x 50 x 2.50	22	2, 3, 4, 6, 8, 10	592
F.MU 23-45N	575 x 45 x 2.50	23	2, 3, 4, 6, 8, 10	555
F.MU 23-50N	575 x 50 x 2.50	23	2, 3, 4, 6, 8, 10	617
F.MU 24-50N	600 x 50 x 2.50	24	2, 3, 4, 6, 8, 10	636
F.MU 25-60N	625 x 60 x 2.50	25	2, 3, 4, 6, 8	800
F.MU 26-50N	650 x 50 x 2.50	26	2, 3, 4, 6, 8, 10	692
F.MU 26-55N	650 x 55 x 2.50	26	2, 3, 4, 6, 8, 10	761
F.MU 26-60N	650 x 60 x 3.00	26	2, 3, 4, 6	996
F.MU 28-50N	700 x 50 x 2.50	28	2, 3, 4, 6, 8, 10	742
F.MU 28-55N	700 x 55 x 2.50	28	2, 3, 4, 6, 8, 10	816
F.MU 28-60N	700 x 60 x 3.00	28	2, 3, 4, 6	1068
F.MU 30-50N	750 x 50 x 2.50	30	2, 3, 4, 6	800
F.MU 30-60N	750 x 60 x 3.00	30	2, 3, 4, 6	1152
F.MU 30-63N	750 x 63 x 2.50	30	2, 3, 4, 6	1008
F.MU 32-70N	800 x 70 x 3.00	32	2, 3, 4, 6, 8, 10	1428

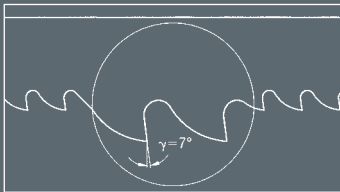
Other dimensions are also available.

HSS Positive

(AISI M2) ALLHARD; Hook tooth 7° positive

For tough materials and materials which produce long chips.

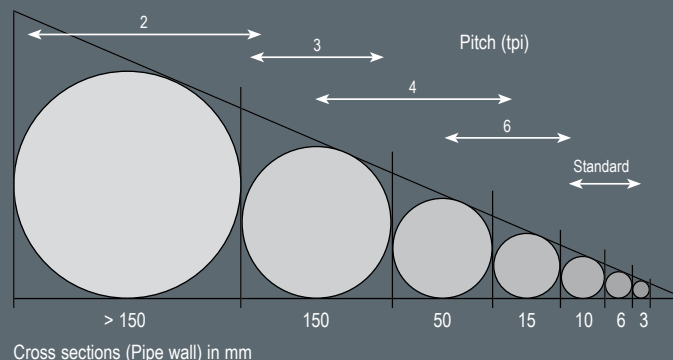
- HSS-DMo5-Aisi M2 is filling the space between the universal saw blade and the special saw blade.
- Optimum results for cutting structural steels, case hardened steels and tempered steels up to a toughness of about 800 N/mm².
- An addition for stainless steels with a cross section of less than 50 mm or a pipe wall of less than 10 mm with appropriate tooth spacing.



Ref.	Dimension l/w/t (mm)	Inch Ø	Teeth per inch	Weight (g)
F.MU 12-30VG7	300 x 30 x 2.00	12	6	156
F.MU 14-30VG7	350 x 30 x 2.00	14	3, 4, 6	180
F.MU 14-35VG7	350 x 35 x 2.00	14	3, 4, 6	211
F.MU 14-36VG7	350 x 36 x 2.00	14	3, 4, 6	217
F.MU 16-30VG7	400 x 30 x 1.50	16	6	153
F.MU 16-30.1VG7	400 x 30 x 2.00	16	6	205
F.MU 16-35VG7	400 x 35 x 2.00	16	3, 4, 6	240
F.MU 16-40VG7	400 x 40 x 2.00	16	3, 4, 6	274
F.MU 17-35VG7	400 x 35 x 2.00	17	3, 4, 6	254
F.MU 18-35VG7	450 x 35 x 2.00	18	3, 4, 6	270
F.MU 18-40VG7	450 x 40 x 2.00	18	3, 4, 6	308
F.MU 18-45VG7	450 x 45 x 2.00	18	2, 3, 4, 6	347
F.MU 20-40VG7	500 x 40 x 2.00	20	3, 4, 6	342
F.MU 20-40.1VG7	500 x 40 x 2.50	20	3, 4, 6	428
F.MU 20-48VG7	500 x 48 x 2.50	20	2, 3, 4, 6	523
F.MU 20-50VG7	500 x 50 x 2.50	20	2, 3, 4, 6	542
F.MU 21-40VG7	525 x 40 x 2.00	21	2, 3, 4, 6	359
F.MU 21-45VG7	525 x 45 x 2.50	21	2, 3, 4, 6	505
F.MU 21-50VG7	525 x 50 x 2.50	21	2, 3, 4, 6	567
F.MU 22-45VG7	550 x 45 x 2.00	22	4, 6	421
F.MU 22-50VG7	550 x 50 x 2.50	22	2, 3, 4, 6	592
F.MU 23-45VG7	575 x 45 x 2.50	23	2, 3, 4, 6	555
F.MU 23-50VG7	575 x 50 x 2.50	23	2, 3, 4, 6	617
F.MU 24-50VG7	600 x 50 x 2.50	24	2, 3, 4, 6	636
F.MU 25-60VG7	625 x 60 x 2.50	25	2, 3, 4	800
F.MU 26-50VG7	650 x 50 x 2.50	26	3, 4, 6	692
F.MU 26-55VG7	650 x 55 x 2.50	26	2, 3, 4, 6	761
F.MU 26-60VG7	650 x 60 x 3.00	26	2, 3, 4	996
F.MU 28-50VG7	700 x 50 x 2.50	28	2, 3	742
F.MU 28-55VG7	700 x 55 x 2.50	28	2, 3, 4, 6	816
F.MU 28-60VG7	700 x 60 x 3.00	28	2, 3, 4	1068
F.MU 32-70VG7	800 x 70 x 3.00	32	2, 3	1428
F.MU 34-63VG7	850 x 63 x 3.50	34	2, 3	1577
F.MU 34-75VG7	850 x 75 x 3.00	34	2, 3	1620
F.MU 38-110VG7	950 x 110 x 3.00	38	2, 3	2666
F.MU 40-126VG7	1000 x 126 x 3.50	40	2, 3	3662
F.MU 47-144VG7	1160 x 144 x 3.50	47	2, 3, 4	4838

HSS-DMo5 (AISI M2) – ALLHARD; Hook tooth 7° positive

Range of applications



HSS Vario Positive

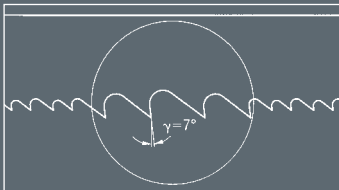
(AISI M2) – ALLHARD; Variable tooth spacing 7° positive

For tough materials and materials with produce long chips.

Variable tooth spacing reduces vibration and the blade lives longer.

For quality cutting with maximum performance

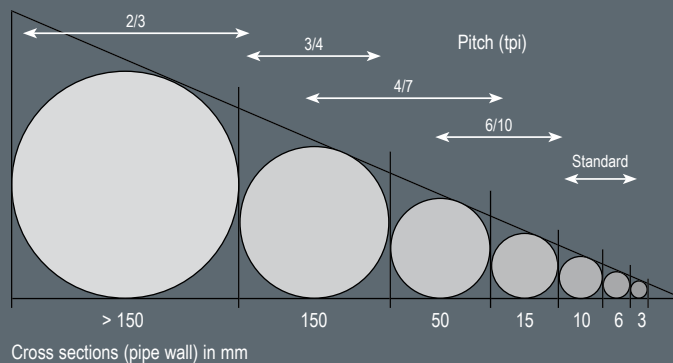
- The toothing with a positive rake of 7 degrees allows most materials to be cut more quickly.
- Pilot teeth produce a straight cut. Variable tooth spacing means that the saw blades need to be changed less frequently as a result of the large range of applications.
- Optimum tooth geometry with variable spacing ensures a clean low-vibration cut at minimum noise level.



Ref.	Dimension l/w/t (mm)	Inch Ø	Teeth per inch	Weight (g)
F.MU 12-30VP7	300 x 30 x 2.00	12	3-4, 4-7, 6-10	156
F.MU 14-30VP7	350 x 30 x 2.00	14	3-4, 4-7, 6-10	180
F.MU 14-35VP7	350 x 35 x 2.00	14	3-4, 4-7, 6-10	211
F.MU 14-36VP7	350 x 36 x 2.00	14	3-4, 4-7, 6-10	217
F.MU 16-30VP7	400 x 30 x 1.50	16	3-4, 4-7, 6-10	153
F.MU 16-30.1VP7	400 x 30 x 2.00	16	3-4, 4-7, 6-10	205
F.MU 16-35VP7	400 x 35 x 2.00	16	3-4, 4-7, 6-10	240
F.MU 16-40VP7	400 x 40 x 2.00	16	3-4, 4-7, 6-10	274
F.MU 17-35VP7	400 x 35 x 2.00	17	3-4, 4-7, 6-10	254
F.MU 18-35VP7	450 x 35 x 2.00	18	3-4, 4-7, 6-10	270
F.MU 18-40VP7	450 x 40 x 2.00	18	2-3, 3-4, 4-7, 6-10	308
F.MU 18-45VP7	450 x 45 x 2.00	18	2-3, 3-4, 4-7, 6-10	347
F.MU 20-40VP7	500 x 40 x 2.00	20	2-3, 3-4, 4-7	342
F.MU 20-40.1VP7	500 x 40 x 2.50	20	2-3, 3-4, 4-7	428
F.MU 20-48VP7	500 x 48 x 2.50	20	2-3, 3-4, 4-7	523
F.MU 20-50VP7	500 x 50 x 2.50	20	2-3, 3-4, 4-7	542
F.MU 21-40VP7	525 x 40 x 2.00	21	3-4	359
F.MU 21-45VP7	525 x 45 x 2.50	21	3-4	505
F.MU 21-50VP7	525 x 50 x 2.50	21	3-4	567
F.MU 22-45VP7	550 x 45 x 2.00	22	2-3, 3-4, 4-7	421
F.MU 22-50VP7	550 x 50 x 2.50	22	2-3, 3-4, 4-7	592
F.MU 23-45VP7	575 x 45 x 2.50	23	2-3, 3-4, 4-7	555
F.MU 23-50VP7	575 x 50 x 2.50	23	2-3, 3-4, 4-7	617
F.MU 24-50VP7	600 x 50 x 2.50	24	2-3, 3-4, 4-7	636
F.MU 25-60VP7	625 x 60 x 2.50	25	2-3, 3-4	800
F.MU 26-50VP7	650 x 50 x 2.50	26	2-3, 3-4, 4-7	692
F.MU 26-55VP7	650 x 55 x 2.50	26	2-3, 3-4, 4-7	761
F.MU 26-60VP7	650 x 60 x 3.00	26	2-3, 3-4, 4-7	996
F.MU 28-50VP7	700 x 50 x 2.50	28	2-3, 3-4	742
F.MU 28-55VP7	700 x 55 x 2.50	28	2-3, 3-4, 4-7	816
F.MU 28-60VP7	700 x 60 x 3.00	28	2-3, 3-4, 4-7	1068
F.MU 32-70VP7	800 x 70 x 3.00	32	2-3, 3-4	1428
F.MU 34-63VP7	850 x 63 x 3.50	34	2-3, 3-4	1577
F.MU 34-75VP7	850 x 75 x 3.00	34	2-3	1620
F.MU 38-110VP7	950 x 110 x 3.00	38	2-3	2666
F.MU 40-126VP7	1000 x 126 x 3.50	40	2-3	3662
F.MU 47-144VP7	1160 x 144 x 3.50	47	2-3	4838

Universal HSS-DMo5 (AISI M2) – ALLHARD; Variable tooth spacing 7° positive

Range of applications



HSS Super Positive

(AISI M2); Hook tooth 13° positive

For cutting stainless and acid-resisting steel

- The increased use of stainless and acid-resisting steels (e. g. VA steels) requires an appropriate saw blade for cutting these difficult materials.
- As a result of the perfect cutting edge geometry, excellent cutting results are achieved.
- With 13 degrees positive rake produces optimum penetration of the material to be sawn.
- The economical cutting of VA pipes with walls from 10 mm is no problem.

Direction for application:

Tooth spacing

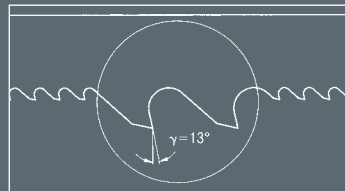
3 teeth/inch for cross sections from 50 • 200 mm

(pipes with walls from 10 mm)

2 teeth/inch for cross sections from 150 mm

Cutting speed

Stainless and acid-resisting steels: 10 to 20 m/min



Ref.	Dimension l/w/t (mm)	Inch	Hole Ø (mm)	Teeth per inch
F.MU 14-35G13	350 x 35 x 2.00	14	8.5	3
F.MU 16-35G13	400 x 35 x 2.00	16	10.5	3
F.MU 16-35G13	400 x 35 x 2.00	16	8.5	3
F.MU 17-35G13	425 x 35 x 2.00	17	8.5	3
F.MU 18-35G13	450 x 35 x 2.00	18	8.5	3
F.MU 18-40G13	450 x 40 x 2.00	18	10.5	2 3
F.MU 18-40G13	450 x 40 x 2.00	18	Kasto	2 3
F.MU 18-45G13	450 x 45 x 2.00	18	10.5	2 3
F.MU 20-40G13	500 x 40 x 2.00	20	10.5	2 3
F.MU 20-40G13	500 x 40 x 2.00	20	Kasto	2 3
F.MU 20-40G13	500 x 40 x 2.50	20	10.5	2 3
F.MU 20-48G13	500 x 48 x 2.50	20	Kasto	2 3
F.MU 20-50G13	500 x 50 x 2.50	20	10.5	3
F.MU 21-40G13	525 x 40 x 2.00	21	10.5	2 3
F.MU 21-45G13	525 x 45 x 2.50	21	10.5	2 3
F.MU 22-45G13	550 x 45 x 2.00	22	Kasto	2 3
F.MU 22-50G13	550 x 50 x 2.50	22	10.5	2 3
F.MU 23-45G13	575 x 45 x 2.50	23	10.5	2 3
F.MU 23-50G13	575 x 50 x 2.50	23	Kasto	2 3
F.MU 24-50G13	600 x 50 x 2.50	24	10.5	2 3
F.MU 24-50G13	600 x 50 x 2.50	24	Kasto	2 3
F.MU 25-60G13	625 x 60 x 2.50	25	10.5	2 3
F.MU 26-50G13	650 x 50 x 2.50	26	13	2 3
F.MU 26-50G13	650 x 50 x 2.50	26	Kasto	2 3
F.MU 26-55G13	650 x 55 x 2.50	26	Kasto	2 3
F.MU 26-60G13	650 x 60 x 3.00	26	13	2 3
F.MU 26-60G13	650 x 60 x 3.00	26	Kasto	2 3
F.MU 27-55G13	675 x 55 x 2.50	27	Kasto	2 3
F.MU 28-50G13	700 x 50 x 2.50	28	13	2 3
F.MU 28-50G13	700 x 50 x 2.50	28	Kasto	2 3
F.MU 28-55G13	700 x 55 x 2.50	28	Kasto	2 3
F.MU 28-55G13	700 x 55 x 2.50	28	Behr. 12.5	2 3
F.MU 28-60G13	700 x 60 x 3.00	28	16.5	2 3
F.MU 32-70G13	800 x 70 x 3.00	32	16.5	2 3
F.MU 34-70G13	850 x 70 x 3.00	34	16.5	3
F.MU 34-75G13	850 x 75 x 3.00	34	Behringer	2
F.MU 34-63G13	850 x 63 x 3.50	34	Kasto	2 3
F.MU 36-70G13	900 x 70 x 3.00	36	16.5	3
F.MU 38-70G13	950 x 70 x 3.00	38	16.5	3
F.MU 38-110G13	950 x 110 x 3.00	38	16.5	2 3

Cobalt HSS-Co.

Blade for special application.

Made of HSS-Cobalt M35 steel.

A hardness of 67 degree Rockwell and 8% Cobalt allows user to cut extreme hard materials of more than 120 kp/mm² toughness.

Ref.	Dimension l/w/t (mm)	Inch	Hole Ø (mm)	Teeth per inch
F.MK 18-40	450 x 40 x 2.0	18	10.5	4; 6
F.MK 20-40	500 x 40 x 2.0	20	10.5	4; 6
F.MK 24-50	600 x 50 x 2.5	24	10.5	4; 6
F.MK 28-50	700 x 50 x 2.5	28	13	3; 4; 6
F.MK 30-50	750 x 50 x 2.5	30	13	3; 4; 6

Manufactured only by customer's order.