



RÖNTGEN®

GERMAN QUALITY - ENDURING PRECISION

BAND SAW BLADES PROGRAM

Product overview



HM-Titan

CONTENTS

HM-Titan MU 810.....	3
HM-Titan forteC 815.....	3
HM-Titan Profile 860.....	4
HM-Titan Profile forteC 865.....	4
HM-Titan SET 850.....	4
HM-Titan nSET 851.....	4
HM-Titan B0 840.....	5
HM-Titan B0 forteC 845.....	5
HM-Titan MUSN 842.....	5
HM-Titan MUSN forteC 846.....	5
HM-Titan ALU2 822.....	6
HM-Titan ALU SET 824.....	6
HM-Titan Engine 826.....	6
HM-Titan Carbon 829.....	7
HM-Titan TCO 886.....	7
HM-Titan FIT 830.....	7
HM-Titan IncoSet 853.....	7

APPLICATION AREAS

EXPLANATION OF ICONS

Due to the variety of our band saw blades, we are able to cover a wide range of applications. The following icons indicate which band saw blade fits best to your individual cutting job.



Thick-walled tube



Thick-walled tubes & solid bar



Round solids



Plates



Wall and floor tiles



Back wave



Engine block



Riser & Sprues



Square solids



Saw stones



Aerated concrete/fibreboard



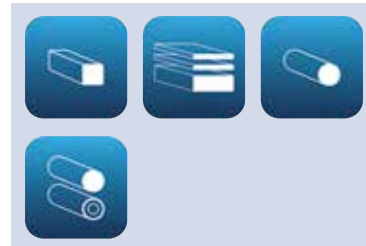
Graphite

HM-Titan

MU | 810

- multi-chip geometry
- universal use, cutting of all common steel types up to a hardness of 1700 N/mm²
- tooth tips made of high-quality carbide
- backing material made of high alloyed spring steel
- particularly quiet and vibration free cutting with an optimized cutting surface due to precise ground geometry

APPLICATION AREAS



Product changeover:

HM-Titan MU is being gradually replaced by the new, improved geometry HM-Titan ST | 813

Teeth per inch

	0,85/1,15	1,1/1,6	1,5/2	1,8/2,2	2/3	3/4	
27 x 0,90						■	1 x .035
34 x 1,10					■	■	1 1/4 x .042
41 x 1,30			■		■	■	1 1/2 x .050
54 x 1,30			■		■	■	2 x .050
54 x 1,60	■	■	■	■	■	■	2 x .063
67 x 1,60	■	■	■	■			2 5/8 x .063
80 x 1,60	■	■					3 1/8 x .063

Width x thickness (mm) ■ multi-chip geometry | 810

Width x thickness (inch)

HM-Titan

forteC | 815

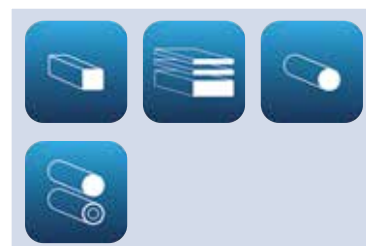
- multi-chip geometry for increasing cutting parameters
- increase in performance of 10-30 % with the same tool life
- pre-honed cutting edges

Other sizes with forteC-coating available upon request.

Product changeover:

HM-Titan forteC is being gradually replaced by the new, improved geometry HM-Titan ST forttec | 816.

APPLICATION AREAS



Teeth per inch

	0,85/1,15	1,1/1,6	1,5/2	1,8/2,2	2/3	3/4	
27 x 0,90						■	1 x .035
34 x 1,10					■	■	1 1/4 x .042
41 x 1,30			■		■	■	1 1/2 x .050
54 x 1,30			■		■	■	2 x .050
54 x 1,60	■	■	■	■	■	■	2 x .063
67 x 1,60	■	■	■	■			2 5/8 x .063
80 x 1,60	■	■					3 1/8 x .063

Width x thickness (mm) ■ forteC | 815

Width x thickness (inch)

HM-Titan

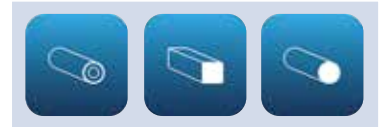
Profile | 860

Profile forteC | 865

- VF-geometry
- cutting of all common steel types up to a hardness of 1900 N/mm²
- particularly suitable for thick-walled tubes/tough materials/special alloys
- Profile forteC | 865: increase in performance of 10-30 % with the same tool life with an additional forteC-coating
- Profile forteC | 865: pre-honed cutting edges

Other sizes with forteC-coating available upon request.

APPLICATION AREAS



Teeth per inch

	0,85/1,15	1,1/1,6	1,5/2	1,8/2,2	2/3	3/4	
27 x 0,90					■	■	1 x .035
34 x 1,10					■ ●	■	1 1/4 x .042
41 x 1,30			■ ●		■ ●	■ ●	1 1/2 x .050
54 x 1,30					■	■ ●	2 x .050
54 x 1,60		■ ●	■ ●		■ ●	■ ●	2 x .063
67 x 1,60			■ ●	■ ●			2 5/8 x .063
80 x 1,60							3 1/8 x .063

Width x thickness (mm) ■ Profile | 860 ● Profile forteC | 865

Width x thickness (inch)

HM-Titan

SET | 850

nSET | 851

- universal use, cutting of all common steel types up to a hardness of 1700 N/mm²
- the special set pattern causes a larger cutting channel, prevents the saw blade from binding in materials with residual stress (i.e. Inconel, Hastelloy or forged materials)
- also suitable for powerful sawing machines not specially equipped for TCT-blades
- particularly suitable for large contact lengths
- available in step set (SET) and normal set (nSET)
- high performance band saw blade with special geometry

APPLICATION AREAS



Teeth per inch

	0,7/1,0	0,85/1,15	1,1/1,6	1,5/2	2/3	3/4	
27 x 0,90					●	●	1 x .035
34 x 1,10					●	●	1 1/4 x .042
41 x 1,30				■ ●	■ ●	●	1 1/2 x .050
54 x 1,30				■ ●	●	●	2 x .050
54 x 1,60			●	■ ●	■ ●	●	2 x .063
67 x 1,60		■ ●	■ ●	■ ●			2 5/8 x .063
80 x 1,60	■	■ ●	■ ●				3 1/8 x .063
100 x 1,60	■						4 x .063

Width x thickness (mm) ■ SET | 850 ● nSET | 851

Width x thickness (inch)

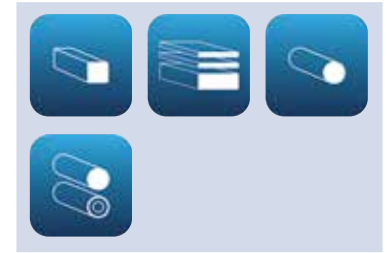
HM-Titan

B0 | 840

B0 forteC | 845

- high performance band saw blade with special geometry
- cutting of hardened/induction-hardened and extremely hard materials > 50 HRC
- B0-geometry is also suitable for use on machines with limited performance
- B0 forteC | 845: performance increase with forteC coating of 10-30% at same tool life
- B0 forteC | 845: with pre-honed cutting edges

APPLICATION AREAS



Teeth per inch

2/3		3/4	
27 x 0,90		■ ●	1 x .035
34 x 1,10	■	■ ●	1 1/4 x .042
41 x 1,30	■	■ ●	1 1/2 x .050
54 x 1,30		■	2 x .050
54 x 1,60	■ ●	■	2 x .063

Width x thickness (mm) ■ B0 | 840 ● B0 forteC | 845

Width x thickness (inch)

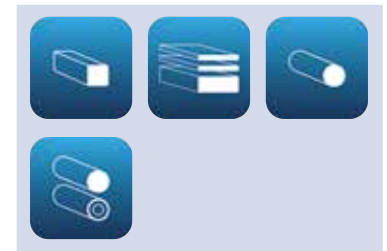
HM-Titan

MUSN | 842

MUSN forteC | 846

- high performance band saw blade with special geometry
- cutting of hardened/induction-annealed and extremely hard materials > 50 HRC
- MUSN requires the use of heavy-duty sawing machines
- multi-chip geometry for increasing cutting parameters
- MUSN forteC | 846: performance increase with forteC coating of 10-30% at same tool life
- MUSN forteC | 846: with pre-honed cutting edges

APPLICATION AREAS



Teeth per inch

2/3		3/4	
27 x 0,90		■	1 x .035
34 x 1,10	■	■ ●	1 1/4 x .042
41 x 1,30	■	■ ●	1 1/2 x .050

Width x thickness (mm) ■ MUSN | 842 ● MUSN forteC | 846

Width x thickness (inch)

HM-Titan

ALU2 | 822

- VN-geometry
- tooth tips made of wear resistant special carbide
- high alloyed spring steel strip for high blade speeds and feeds
- particularly suitable for blocks, plates, sprues, risers and manual feeds
- optimized cutting surfaces for plates- and block cutting applications
- optimized chip chamber profile for long engagement lengths

APPLICATION AREAS



Teeth per inch									
	2	3	0,85/1,15	0,9/1,2	1,1/1,6	1,5/2	2/3	3/4	
13 x 0,90								■	1/2 x .035
20 x 0,90		■							3/4 x .035
27 x 0,90		■					■		1 x .035
34 x 1,10	■	■				■	■		1 1/4 x .042
41 x 1,30					■	■	■		1 1/2 x .050
54 x 1,30				■		■			2 x .050
54 x 1,60			■	■	■	■			2 x .063
80 x 1,60			■	■					3 1/8 x .063

Width x thickness (mm) ■ ALU2 | 822

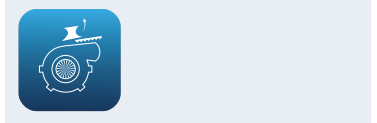
Width x thickness (inch)

HM-Titan

ALU SET | 824

- the special set pattern causes a larger cutting channel, prevents the saw blade from binding in materials with residual stress
- high alloyed spring steel strip for high blade speeds and feeds
- particularly suitable for manual feed

APPLICATION AREAS



Teeth per inch									
	2					3			
20 x 0,90						■			3/4 x .035
27 x 0,90						■			1 x .035
34 x 1,10		■				■			1 1/4 x .042

Width x thickness (mm) ■ ALU SET | 824

Width x thickness (inch)

HM-Titan

Engine | 826

- VN-geometry
- tooth tips made of wear resistant special carbide
- high alloyed spring steel strip for high blade speeds and feeds
- optimized tooth profile for silted parts
- carbide cutting material optimized for alloys with high SI-content
- highly flexible spring steel for high number of bending loads
- designed for abrasive, high-silicon alloys

APPLICATION AREAS



Teeth per inch									
	2					1,5/2		2/3	
34 x 1,10								■	1 1/4 x .042
41 x 1,30		■				■		■	1 1/2 x .050
54 x 1,30						■		■	2 x .050

Width x thickness (mm) ■ Engine | 826

Width x thickness (inch)

HM-Titan

Carbon | 829

- specially developed for cutting carbon materials
- fitted with a carbide body specifically designed for carbon
- sharp cutting edges reduce cutting forces and ensure a smooth cut
- optimized clearance angles minimise friction and tool wear
- positive rake angle improves the cutting quality and reduces heat build-up
- high process reliability thanks to clean chip removal
- excellent surface finish and precise cutting results

APPLICATION AREAS



Teeth per inch					
0,9/1,2		1,5/2		2/3	
34 x 1,10					1 1/4 x .042
41 x 1,30					1 1/2 x .050
54 x 1,60					2 x .063
67 x 1,60					2 5/8 x .063

Width x thickness (mm) ■ Carbon | 829

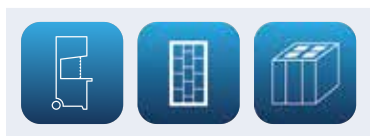
Width x thickness (inch)

HM-Titan

TCO | 886

- low cutting pressure, to ensure fatigue-free working with predominantly manual feed
- highly wear-resistant carbide bodies increase tool life
- for highly abrasive materials (e.g. aerated concrete/fibreboard, Poroton, perforated bricks or insulation boards)
- especially for the use in the construction industry with the size 27 x 0.9 mm 3 tpi for sawing machines e.g. Zagro (UVB series); Lissmac (MBS series); Norton Clipper (CB series)

APPLICATION AREAS



Teeth per inch					
3					
27 x 0,90					1 x .035

Width x thickness (mm) ■ TCO | 886

Width x thickness (inch)

HM-Titan

FIT | 830

IncoSet | 853

- multi-chip geometry
- high-performance band saw blade especially for sawing difficult-to-cut materials in the following material groups: stainless steel, nickel-based alloys and titanium
- newly developed, highly wear resistant carbide body in order to increase the performance features (tool life, cutting quality, performance, and cutting precision)
- optimization of cutting costs
- backing strip made of high-alloyed spring steel

APPLICATION AREAS



Teeth per inch											
0,85/1,15		1,1/1,6		1,5/2		1,8/2,2		2/3		3/4	
34 x 1,10											1 1/4 x .042
41 x 1,30											1 1/2 x .050
54 x 1,30											2 x .050
54 x 1,60											2 x .063
67 x 1,60											2 5/8 x .063
80 x 1,60											3 1/8 x .063

Width x thickness (mm) ■ FIT | 830 ■ IncoSet | 853

Width x thickness (inch)

SAFETY INSTRUCTIONS

Endlessly welded RÖNTGEN saw bands are under tension when delivered. When opening the packaging and placing the saw band on the sawing machine, the following safety measures must be observed:

- wear safety glasses
- wear safety gloves
- wear safety shoes



Detailed safety instructions can be found in the operating instructions of the respective machine manufacturer or are available upon request from RÖNTGEN.

SOLUTIONS FOR SPECIAL APPLICATIONS:

RÖNTGEN BACK WAVE (RW)

The RÖNTGEN „RW“ is brought on the back edge of the ready welded loop. The wave reduces the effective contact length in the cutting channel. The shorter contact length reduces the cutting force required, resulting in increased saw blade tool life.



ROBERT RÖNTGEN GMBH & CO. KG

AUF DEM KNAPP 44 | 42855 REMSCHEID

TEL.: +49-(0)-2191 373-01

info@roentgen-saw.com

www.roentgen-saw.com

OVER
125 YEARS
EXPERIENCE

YOU CAN'T
BEAT IT!



RÖNTGEN®

GERMAN QUALITY - ENDURING PRECISION