

KREISSÄGEBLÄTTER AUS
VOLLHARTMETALL
SOLID CARBIDE SLITTING SAWS

**dress**[®]



QUALITÄT UND ZUVERLÄSSIGKEIT SEIT 1969
QUALITY AND RELIABILITY SINCE 1969

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Kreissägeblätter aus Vollhartmetall nach DIN 1837 und DIN 1838
Solid carbide slitting saws according DIN 1837 und DIN 1838

| Abmessung/Size mm | Zähnezahlen/No. of teeth | | Art.-Nr. | | |
|----------------------|--------------------------|----------|----------|--------|--------|
| | DIN 1837 | DIN 1838 | | | |
| 20 | x 0,20 x 5 | 80 | 602003 | 32 | 602050 |
| | x 0,25 x 5 | 64 | 602004 | 32 | 602051 |
| | x 0,30 x 5 | 64 | 602005 | 32 | 602052 |
| | x 0,35 x 5 | 64 | 602006 | 32 | 602053 |
| | x 0,40 x 5 | 64 | 602007 | 32 | 602054 |
| | x 0,50 x 5 | 48 | 602008 | 24 | 602055 |
| | x 0,60 x 5 | 48 | 602009 | 24 | 602056 |
| | x 0,70 x 5 | 48 | 602010 | 24 | 602057 |
| | x 0,80 x 5 | 40 | 602011 | 24 | 602058 |
| | x 0,90 x 5 | 40 | 602012 | 20 | 602059 |
| x 1,00 x 5 | 40 | 602013 | 20 | 602060 | |
| x 1,10 x 5 | 40 | 602014 | 20 | 602061 | |
| x 1,20 x 5 | 40 | 602015 | 20 | 602062 | |
| x 1,30 x 5 | 40 | 602016 | 20 | 602063 | |
| x 1,40 x 5 | 40 | 602017 | 20 | 602064 | |
| x 1,50 x 5 | 40 | 602018 | 20 | 602065 | |
| x 1,60 x 5 | 40 | 602019 | 20 | 602066 | |
| x 1,70 x 5 | 32 | 602020 | 20 | 602067 | |
| x 1,80 x 5 | 32 | 602021 | 16 | 602068 | |
| x 1,90 x 5 | 32 | 602022 | 16 | 602069 | |
| x 2,00 x 5 | 32 | 602023 | 16 | 602070 | |
| x 2,50 x 5 | 32 | 602024 | 16 | 602071 | |
| x 3,00 x 5 | 32 | 602025 | 16 | 602072 | |
| x 4,00 x 5 | 24 | 602027 | 16 | 602074 | |
| x 5,00 x 5 | 24 | 602029 | 16 | 602076 | |
| x 6,00 x 5 | 24 | 602031 | 16 | 602078 | |
| 25 | x 0,20 x 8 | 80 | 602503 | 32 | 602550 |
| | x 0,25 x 8 | 80 | 602504 | 32 | 602551 |
| | x 0,30 x 8 | 80 | 602505 | 32 | 602552 |
| | x 0,35 x 8 | 64 | 602506 | 32 | 602553 |
| | x 0,40 x 8 | 64 | 602507 | 32 | 602554 |
| | x 0,50 x 8 | 64 | 602508 | 24 | 602555 |
| | x 0,60 x 8 | 64 | 602509 | 24 | 602556 |
| | x 0,70 x 8 | 48 | 602510 | 24 | 602557 |
| | x 0,80 x 8 | 48 | 602511 | 24 | 602558 |
| | x 0,90 x 8 | 48 | 602512 | 20 | 602559 |
| x 1,00 x 8 | 48 | 602513 | 20 | 602560 | |
| x 1,10 x 8 | 48 | 602514 | 20 | 602561 | |
| x 1,20 x 8 | 48 | 602515 | 20 | 602562 | |
| x 1,30 x 8 | 40 | 602516 | 20 | 602563 | |
| x 1,40 x 8 | 40 | 602517 | 20 | 602564 | |
| x 1,50 x 8 | 40 | 602518 | 20 | 602565 | |
| x 1,60 x 8 | 40 | 602519 | 20 | 602566 | |
| x 1,70 x 8 | 40 | 602520 | 20 | 602567 | |
| x 1,80 x 8 | 40 | 602521 | 16 | 602568 | |

| | Abmessung/Size mm | Zähnezahlen/No. of teeth | | | | |
|------------|----------------------|--------------------------|----------|----------|----------|--------|
| | | DIN 1837 | Art.-Nr. | DIN 1838 | Art.-Nr. | |
| 25 | x 1,90 x 8 | 40 | 602522 | 16 | 602569 | |
| | x 2,00 x 8 | 40 | 602523 | 16 | 602570 | |
| | x 2,50 x 8 | 40 | 602524 | 16 | 602571 | |
| | x 3,00 x 8 | 32 | 602525 | 16 | 602572 | |
| | x 4,00 x 8 | 32 | 602527 | 16 | 602574 | |
| | x 5,00 x 8 | 32 | 602529 | 16 | 602576 | |
| | x 6,00 x 8 | 32 | 602531 | 16 | 602578 | |
| | 32 | x 0,20 x 8 | 100 | 603203 | 32 | 603250 |
| | | x 0,25 x 8 | 100 | 603204 | 32 | 603251 |
| | | x 0,30 x 8 | 80 | 603205 | 32 | 603252 |
| x 0,35 x 8 | | 80 | 603206 | 32 | 603253 | |
| x 0,40 x 8 | | 80 | 603207 | 32 | 603254 | |
| x 0,50 x 8 | | 80 | 603208 | 24 | 603255 | |
| x 0,60 x 8 | | 64 | 603209 | 24 | 603256 | |
| x 0,70 x 8 | | 64 | 603210 | 24 | 603257 | |
| x 0,80 x 8 | | 64 | 603211 | 24 | 603258 | |
| x 0,90 x 8 | | 64 | 603212 | 24 | 603259 | |
| x 1,00 x 8 | | 64 | 603213 | 24 | 603260 | |
| x 1,10 x 8 | | 48 | 603214 | 24 | 603261 | |
| x 1,20 x 8 | | 48 | 603215 | 24 | 603262 | |
| x 1,30 x 8 | | 48 | 603216 | 20 | 603263 | |
| x 1,40 x 8 | | 48 | 603217 | 20 | 603264 | |
| x 1,50 x 8 | | 48 | 603218 | 20 | 603265 | |
| x 1,60 x 8 | | 48 | 603219 | 20 | 603266 | |
| x 1,70 x 8 | | 48 | 603220 | 20 | 603267 | |
| x 1,80 x 8 | | 48 | 603221 | 20 | 603268 | |
| x 1,90 x 8 | | 48 | 603222 | 20 | 603269 | |
| x 2,00 x 8 | | 48 | 603223 | 20 | 603270 | |
| x 2,50 x 8 | | 40 | 603224 | 20 | 603271 | |
| x 3,00 x 8 | | 40 | 603225 | 20 | 603272 | |
| x 4,00 x 8 | | 40 | 603227 | 18 | 603274 | |
| x 5,00 x 8 | | 32 | 603229 | 18 | 603276 | |
| x 6,00 x 8 | | 32 | 603231 | 18 | 603278 | |
| 40 | | x 0,20 x 10 | 128 | 604003 | 48 | 604050 |
| | | x 0,25 x 10 | 100 | 604004 | 48 | 604051 |
| | x 0,30 x 10 | 100 | 604005 | 48 | 604052 | |
| | x 0,35 x 10 | 100 | 604006 | 48 | 604053 | |
| | x 0,40 x 10 | 100 | 604007 | 48 | 604054 | |
| | x 0,50 x 10 | 80 | 604008 | 40 | 604055 | |
| | x 0,60 x 10 | 80 | 604009 | 40 | 604056 | |
| | x 0,70 x 10 | 80 | 604010 | 40 | 604057 | |
| | x 0,80 x 10 | 80 | 604011 | 40 | 604058 | |
| | x 0,90 x 10 | 64 | 604012 | 32 | 604059 | |
| | x 1,00 x 10 | 64 | 604013 | 32 | 604060 | |
| | x 1,10 x 10 | 64 | 604014 | 32 | 604061 | |
| | x 1,20 x 10 | 64 | 604015 | 32 | 604062 | |
| | x 1,30 x 10 | 64 | 604016 | 32 | 604063 | |
| | x 1,40 x 10 | 64 | 604017 | 32 | 604064 | |
| | x 1,50 x 10 | 64 | 604018 | 32 | 604065 | |

| Abmessung/Size mm | Zähnezahlen/No. of teeth | | | | | |
|----------------------|--------------------------|-------------|----------|----------|--------|--------|
| | DIN 1837 | Art.-Nr. | DIN 1838 | Art.-Nr. | | |
| 40 | x 1,60 x 10 | 64 | 604019 | 32 | 604066 | |
| | x 1,70 x 10 | 48 | 604020 | 32 | 604067 | |
| | x 1,80 x 10 | 48 | 604021 | 24 | 604068 | |
| | x 1,90 x 10 | 48 | 604022 | 24 | 604069 | |
| | x 2,00 x 10 | 48 | 604023 | 24 | 604070 | |
| | x 2,50 x 10 | 48 | 604024 | 24 | 604071 | |
| | x 3,00 x 10 | 48 | 604025 | 24 | 604072 | |
| | x 4,00 x 10 | 40 | 604027 | 20 | 604074 | |
| | x 5,00 x 10 | 40 | 604029 | 20 | 604076 | |
| | x 6,00 x 10 | 40 | 604031 | 20 | 604078 | |
| | 50 | x 0,20 x 13 | 128 | 605002 | 48 | 605050 |
| | | x 0,25 x 13 | 128 | 605003 | 48 | 605051 |
| | | x 0,30 x 13 | 128 | 605004 | 48 | 605052 |
| | | x 0,35 x 13 | 100 | 605005 | 48 | 605053 |
| | | x 0,40 x 13 | 100 | 605006 | 48 | 605054 |
| x 0,50 x 13 | | 100 | 605007 | 48 | 605055 | |
| x 0,60 x 13 | | 100 | 605008 | 48 | 605056 | |
| x 0,70 x 13 | | 80 | 605009 | 40 | 605057 | |
| x 0,80 x 13 | | 80 | 605010 | 40 | 605058 | |
| x 0,90 x 13 | | 80 | 605011 | 40 | 605059 | |
| x 1,00 x 13 | | 80 | 605012 | 40 | 605060 | |
| x 1,10 x 13 | | 80 | 605013 | 40 | 605061 | |
| x 1,20 x 13 | | 80 | 605014 | 40 | 605062 | |
| x 1,30 x 13 | | 64 | 605015 | 32 | 605063 | |
| x 1,40 x 13 | | 64 | 605016 | 32 | 605064 | |
| x 1,50 x 13 | 64 | 605017 | 32 | 605065 | | |
| x 1,60 x 13 | 64 | 605018 | 32 | 605066 | | |
| x 1,70 x 13 | 64 | 605019 | 32 | 605067 | | |
| x 1,80 x 13 | 64 | 605020 | 32 | 605068 | | |
| x 1,90 x 13 | 64 | 605021 | 32 | 605069 | | |
| x 2,00 x 13 | 64 | 605022 | 32 | 605070 | | |
| x 2,50 x 13 | 64 | 605023 | 32 | 605071 | | |
| x 3,00 x 13 | 48 | 605024 | 24 | 605072 | | |
| x 4,00 x 13 | 48 | 605026 | 24 | 605074 | | |
| x 5,00 x 13 | 48 | 605028 | 24 | 605076 | | |
| x 6,00 x 13 | 40 | 605030 | 20 | 605078 | | |
| 63 | x 0,20 x 16 | 160 | 606301 | 64 | 606348 | |
| | x 0,25 x 16 | 128 | 606302 | 64 | 606349 | |
| | x 0,30 x 16 | 128 | 606303 | 64 | 606350 | |
| | x 0,35 x 16 | 128 | 606304 | 64 | 606351 | |
| | x 0,40 x 16 | 128 | 606305 | 64 | 606352 | |
| | x 0,50 x 16 | 128 | 606306 | 64 | 606353 | |
| | x 0,60 x 16 | 100 | 606307 | 48 | 606354 | |
| | x 0,70 x 16 | 100 | 606308 | 48 | 606355 | |
| | x 0,80 x 16 | 100 | 606309 | 48 | 606356 | |
| | x 0,90 x 16 | 100 | 606310 | 48 | 606357 | |
| | x 1,00 x 16 | 100 | 606311 | 48 | 606358 | |
| | x 1,10 x 16 | 80 | 606312 | 40 | 606359 | |
| | x 1,20 x 16 | 80 | 606313 | 40 | 606360 | |

| Abmessung/Size mm | DIN 1837 | Zähnezahlen/No. of teeth | | Art.-Nr. | | |
|----------------------|-------------|--------------------------|----------|----------|--------|--------|
| | | Art.-Nr. | DIN 1838 | | | |
| 63 | x 1,30 x 16 | 80 | 606314 | 40 | 606361 | |
| | x 1,40 x 16 | 80 | 606315 | 40 | 606362 | |
| | x 1,50 x 16 | 80 | 606316 | 40 | 606363 | |
| | x 1,60 x 16 | 80 | 606317 | 40 | 606364 | |
| | x 1,70 x 16 | 80 | 606318 | 40 | 606365 | |
| | x 1,80 x 16 | 80 | 606319 | 40 | 606366 | |
| | x 1,90 x 16 | 80 | 606320 | 40 | 606367 | |
| | x 2,00 x 16 | 80 | 606321 | 40 | 606368 | |
| | x 2,50 x 16 | 64 | 606322 | 32 | 606369 | |
| | x 3,00 x 16 | 64 | 606323 | 32 | 606370 | |
| | x 4,00 x 16 | 64 | 606325 | 32 | 606372 | |
| | x 5,00 x 16 | 48 | 606327 | 24 | 606374 | |
| | x 6,00 x 16 | 48 | 606329 | 24 | 606376 | |
| | 80 | x 0,40 x 22 | 160 | 608003 | 64 | 608052 |
| | | x 0,50 x 22 | 128 | 608004 | 64 | 608053 |
| | | x 0,60 x 22 | 128 | 608005 | 64 | 608054 |
| x 0,70 x 22 | | 128 | 608006 | 64 | 608055 | |
| x 0,80 x 22 | | 128 | 608007 | 64 | 608056 | |
| x 0,90 x 22 | | 100 | 608008 | 48 | 608057 | |
| x 1,00 x 22 | | 100 | 608009 | 48 | 608058 | |
| x 1,10 x 22 | | 100 | 608010 | 48 | 608059 | |
| x 1,20 x 22 | | 100 | 608011 | 48 | 608060 | |
| x 1,30 x 22 | | 100 | 608012 | 48 | 608061 | |
| x 1,40 x 22 | | 100 | 608013 | 48 | 608062 | |
| x 1,50 x 22 | | 100 | 608014 | 48 | 608063 | |
| x 1,60 x 22 | | 100 | 608015 | 48 | 608064 | |
| x 1,70 x 22 | | 80 | 608016 | 40 | 608065 | |
| x 1,80 x 22 | | 80 | 608017 | 40 | 608066 | |
| x 1,90 x 22 | | 80 | 608018 | 40 | 608067 | |
| x 2,00 x 22 | | 80 | 608019 | 40 | 608068 | |
| x 2,50 x 22 | | 80 | 608020 | 40 | 608069 | |
| x 3,00 x 22 | | 80 | 608021 | 40 | 608070 | |
| x 4,00 x 22 | | 64 | 608023 | 32 | 608072 | |
| x 5,00 x 22 | | 64 | 608025 | 32 | 608074 | |
| x 6,00 x 22 | | 64 | 608027 | 32 | 608076 | |
| 100 | | x 0,50 x 22 | 160 | 610001 | 80 | 610050 |
| | | x 0,60 x 22 | 160 | 610002 | 80 | 610051 |
| | x 0,70 x 22 | 128 | 610003 | 64 | 610052 | |
| | x 0,80 x 22 | 128 | 610004 | 64 | 610053 | |
| | x 0,90 x 22 | 128 | 610005 | 64 | 610054 | |
| | x 1,00 x 22 | 128 | 610006 | 64 | 610055 | |
| | x 1,10 x 22 | 128 | 610007 | 64 | 610056 | |
| | x 1,20 x 22 | 128 | 610008 | 64 | 610057 | |
| | x 1,30 x 22 | 100 | 610009 | 48 | 610058 | |
| | x 1,40 x 22 | 100 | 610010 | 48 | 610059 | |
| | x 1,50 x 22 | 100 | 610011 | 48 | 610060 | |
| | x 1,60 x 22 | 100 | 610012 | 48 | 610061 | |
| | x 1,70 x 22 | 100 | 610013 | 48 | 610062 | |
| | x 1,80 x 22 | 100 | 610014 | 48 | 610063 | |

| Abmessung/Size mm | Zähnezahlen/No. of teeth | | | |
|----------------------|--------------------------|----------|----------|----------|
| | DIN 1837 | Art.-Nr. | DIN 1838 | Art.-Nr. |
| 100 x 1,90 x 22 | 100 | 610015 | 48 | 610064 |
| x 2,00 x 22 | 100 | 610016 | 48 | 610065 |
| x 2,50 x 22 | 100 | 610017 | 48 | 610066 |
| x 3,00 x 22 | 80 | 610018 | 40 | 610067 |
| x 4,00 x 22 | 80 | 610020 | 40 | 610069 |
| x 5,00 x 22 | 80 | 610022 | 40 | 610071 |
| x 6,00 x 22 | 64 | 610024 | 32 | 610073 |
| 125 x 0,60 x 22 | 160 | 612501 | 80 | 612548 |
| x 0,70 x 22 | 160 | 612502 | 80 | 612549 |
| x 0,80 x 22 | 160 | 612503 | 80 | 612550 |
| x 0,90 x 22 | 160 | 612504 | 80 | 612551 |
| x 1,00 x 22 | 160 | 612505 | 80 | 612552 |
| x 1,10 x 22 | 128 | 612506 | 64 | 612553 |
| x 1,20 x 22 | 128 | 612507 | 64 | 612554 |
| x 1,30 x 22 | 128 | 612508 | 64 | 612555 |
| x 1,40 x 22 | 128 | 612509 | 64 | 612556 |
| x 1,50 x 22 | 128 | 612510 | 64 | 612557 |
| x 1,60 x 22 | 128 | 612511 | 64 | 612558 |
| x 1,70 x 22 | 128 | 612512 | 64 | 612559 |
| x 1,80 x 22 | 128 | 612513 | 64 | 612560 |
| x 1,90 x 22 | 128 | 612514 | 64 | 612561 |
| x 2,00 x 22 | 128 | 612515 | 64 | 612562 |
| x 2,50 x 22 | 100 | 612516 | 48 | 612563 |
| x 3,00 x 22 | 100 | 612517 | 48 | 612564 |
| x 4,00 x 22 | 100 | 612519 | 48 | 612566 |
| x 5,00 x 22 | 80 | 612521 | 40 | 612568 |
| x 6,00 x 22 | 80 | 612523 | 40 | 612570 |
| 150 x 1,00 x 32 | 150 | 615001 | 80 | 615050 |
| x 1,20 x 32 | 150 | 615002 | 80 | 615051 |
| x 1,50 x 32 | 150 | 615003 | 80 | 615052 |
| x 1,60 x 32 | 150 | 615004 | 64 | 615053 |
| x 2,00 x 32 | 128 | 615005 | 64 | 615054 |
| x 2,50 x 32 | 128 | 615006 | 64 | 615055 |
| x 3,00 x 32 | 128 | 615007 | 64 | 615056 |
| x 4,00 x 32 | 100 | 615008 | 48 | 615057 |
| 160 x 1,00 x 32 | 160 | 616001 | 80 | 616050 |
| x 1,20 x 32 | 160 | 616002 | 80 | 616051 |
| x 1,50 x 32 | 160 | 616003 | 80 | 616052 |
| x 1,60 x 32 | 160 | 616004 | 80 | 616053 |
| x 2,00 x 32 | 128 | 616005 | 64 | 616054 |
| x 2,50 x 32 | 128 | 616006 | 64 | 616055 |
| x 3,00 x 32 | 128 | 616007 | 80 | 616056 |
| x 4,00 x 32 | 128 | 616008 | 80 | 616057 |
| 200 x 1,50 x 32 | 160 | 620001 | 80 | 620050 |
| x 2,00 x 32 | 160 | 620003 | 80 | 620051 |
| x 2,50 x 32 | 160 | 620004 | 80 | 620052 |
| x 3,00 x 32 | 128 | 620005 | 64 | 620053 |
| x 4,00 x 32 | 128 | 620006 | 64 | 620054 |



Sonderwerkzeuge aus Vollhartmetall
Special tools made of solid carbide

Die Werkzeuge werden nach Zeichnung oder Muster gefertigt und sind damit exakt auf die Anforderungen der Kunden ausgerichtet.

The tools will be produced as per drawing or sample. For that reason they will exactly meet the requirements of the customers.

Beispiele / Examples

| | |
|--|--|
| | Computerindustrie Computer industry |
| | Elektronikindustrie Electronic industry Elektromotorenindustrie Electric motor industry |
| | Textilindustrie Textile industry |
| | Maschinen- und Werkzeugbau Machine and tool construction |



Kreismesser aus Vollhartmetall
Solid carbide circular knives

Kreismesser aus Vollhartmetall sind kundenspezifische Problemlösungen und werden entsprechend dem Verwendungszweck gefertigt.

Solid carbide circular knives are customized problem solutions and are manufactured according to the intended purpose.

Deshalb bitte wir um detaillierte Anfragen und um Nennung

- genauer Abmessung (Zeichnung oder Muster)
- genauer Bearbeitungszweck
- Menge

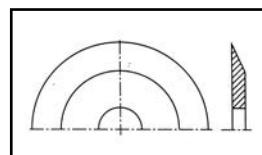
Therefore we ask for detailed enquiries giving us

- exact sizes (drawings or samples)
- material to be cut
- quantity

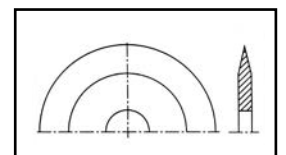
Beispiele / Examples



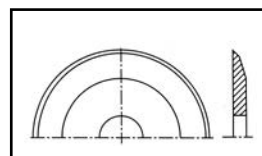
Fasenformen / Type of bevels



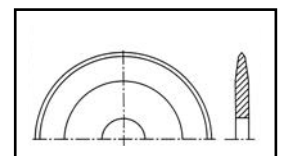
einseitige Fase / one side bevel



doppelseitige Fase / double side bevel



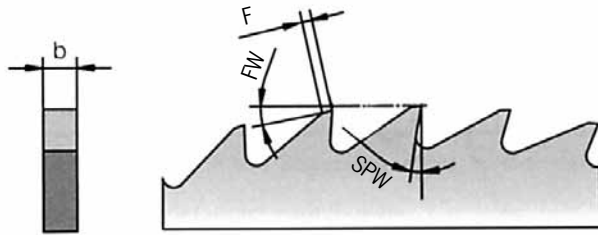
einseitige Fase mit einseitiger Vorfase /
one side bevel with one side pre-bevel



doppelseitige Fase mit
doppelseitiger Vorfase /
double side bevel with
double side pre-bevel

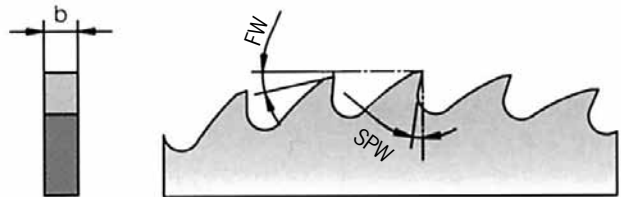
Zahnform A mit Fasse nach DIN 1840
 Tooth form A with face acc. DIN 1840

Für kleine Schnitttiefen, Schlitz und dünnwandige Rohre mit kleinem Durchmesser sowie kurzspanendes Material.
 For low cutting depths, slots and thin-walled tubes with small diameter and for short broken ships.



Zahnform B nach DIN 1840
 Tooth form B acc. DIN 1840

Für Vollmaterial, große Schnitttiefen, Rohre über 2,5 mm Wandstärke und langspanendes Material.
 For solid material, deep cuts, tubes with wall thickness above 2,5 mm and long broken ships.



SPW = Spanwinkel / Rake angle
 FW = Freiwinkel / Free angle
 F = Fasse / Face
 b = Schnittbreite / Cutting width

**Richtwerte für
 Schnittgeschwindigkeit (v_c m/min)**

**Approx. values
 for cutting speed (v_c m/min)**

| Werkstoff | Material | Schnittgeschwindigkeit cutting speed |
|---|---|---|
| Baustahl | structural steel | 120-180 |
| Stahl | steel | 80-120 |
| Stähle mit hoher Festigkeit | steel with high tenacity | 80-100 |
| Extraharte Stähle | steel extra hard | 30-50 |
| Warmarbeitsstähle | hot working steel | 20-30 |
| Austenitische Stähle | steel, mild | 40-80 |
| Aluminium unlegiert | Aluminium unalloyed | 1000-2000 |
| Alu-Legierung mit Cu-Mg-Zn | Al-alloys with Cu-Mg-Zn | 800-1500 |
| Aluminium mit max. 5% Si-Anteil | AL with max. 5% Si-components | 400-600 |
| Kupfer | copper | 200-400 |
| Phosphor-Bronze | phosphorus-bronze | 200-400 |
| Hartbronze | bronze, hard | 100-200 |
| Messing (Cu Zn) | brass | 400-600 |
| Messing legiert | brass alloyed | 200-500 |
| Grauguß | cast grey | 40-80 |
| Titan-Legierungen | titanium alloys | 60-100 |
| Träger und Rohre Wanddicke=0,1D | beams and pipes wall thickness=0.1D | 30-50 |
| Profileisen und Rohre Wanddicke=0,025 D | profiles and pipes wall thickness=0.025 D | 40-60 |