DUOS

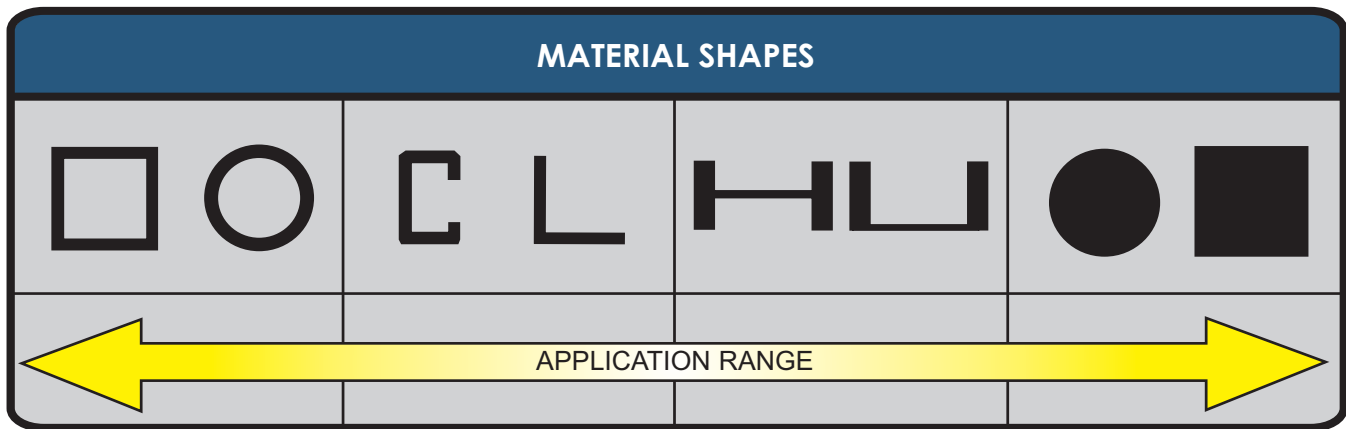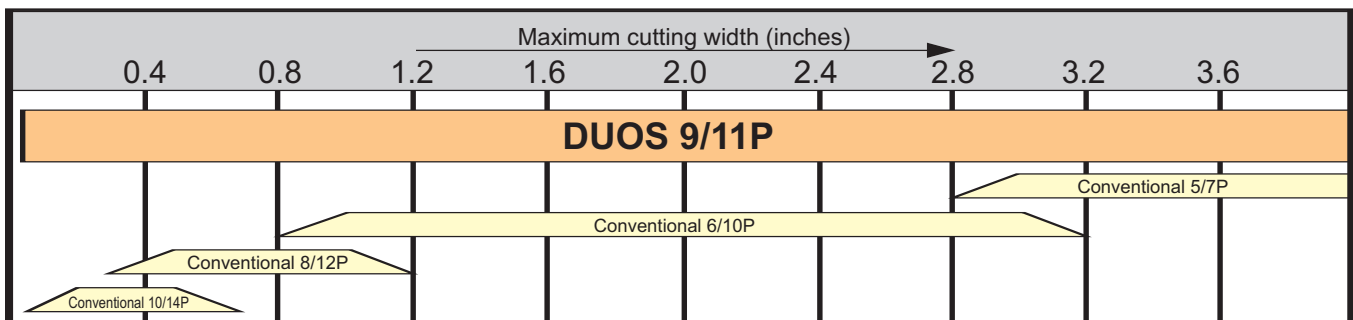## HSS Bi-Metal Band Saw Blade

◆ *Highest quality backing material with M42 strip assures the longest possible blade life.*

◆ *Innovative Twin Set plus Proprietary Tooth shapes in a Hi-Lo configuration for the most efficient and economic metal sawing.*

◆ *Blade exclusively designed for the light-duty band sawing machines to cover a wide range of cutting applications.*

APPLICATIONS
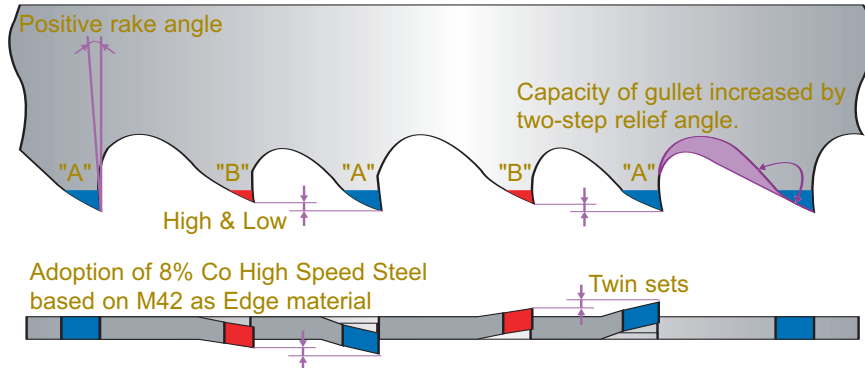
Break-in procedure is unnecessary.

MATERIAL SHAPES

APPLICATION RANGE

Relation Between Pitch & Cut Width

		Maximum cutting width (inches)						
0.4	0.8	1.2	1.6	2.0	2.4	2.8	3.2	3.6

DUOS 9/11P

Conventional 5/7P

Conventional 6/10P

Conventional 8/12P

Conventional 10/14P

◆MADA®

FEATURES

Most cutting applications can be cut efficiently and economically with the "DUOS 9/11 P".

The problem of operators selecting the improper blade has been virtually eliminated by the "DUOS".

Positive rake angle

Capacity of gullet increased by two-step relief angle.

"A"   "B"   "A"   "B"   "A"

High & Low

Adoption of 8% Co High Speed Steel based on M42 as Edge material

Twin sets

- ◆ The "DUOS" uses two different tooth and set configurations to control excessive feeding in profile and tubing type materials.

- ◆ Adopting a positive rake angle enhances cutting performance in both solid and profile cutting.

- ◆ Increasing the chip area of the gullet by utilizing the two-step relief angle is a first for the smaller pitches.

- ◆ Time-consuming break-in periods are totally eliminated when using the "DUOS".

- ◆ "DUOS" is a blade developed exclusively for the light-duty band saw. This design prevents teeth stripping and or chipping when cutting profiles while expanding the application to include solid materials to the full capacity.

Solid

Feed rate will be relatively light.

Only "A" teeth are used, and apparent pitches increase in size.

Tube

Feed rate will be relatively heavy.

Excessive cutting can be controlled, because all "A" teeth and "B" teeth are used.

LINE-UP OF PRODUCTS

Band Width (in.)	Band Thickness (in.)	Pitch
1/2	0.025	9/11
	0.035	9/11
3/4	0.035	9/11
1	0.035	9/11
1 1/4	0.035	9/11

Note: Product line-up of "DUOS" is limited to comparatively small pitches considering frequency of use.
Please use "PROTECTOR" 4/6 or 3/4 pitch when material is outside of the application range.