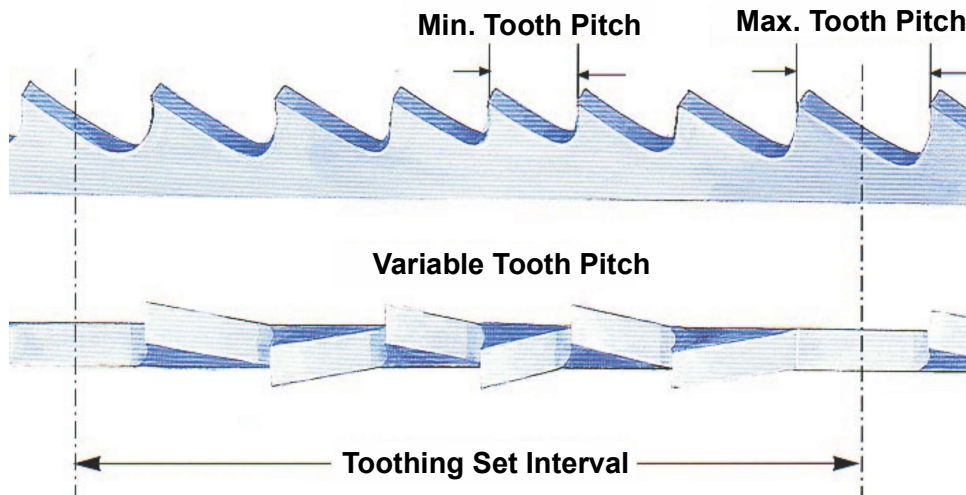
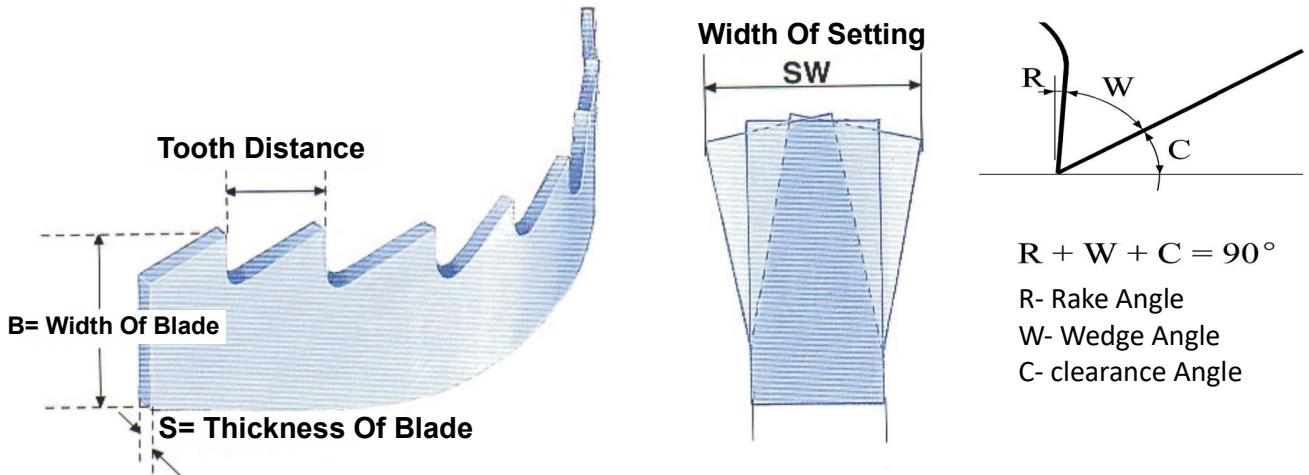


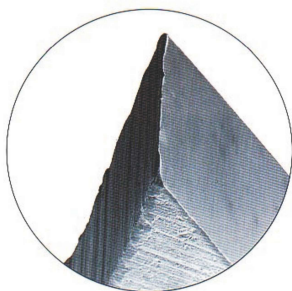
Geometry of a Band Saw Blade



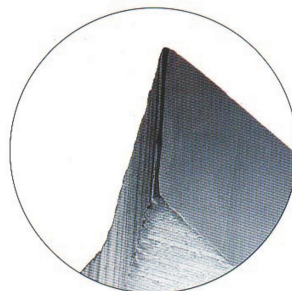
Sawing in of new Bandsaw Blades

The sharp cutting tooth of the MEBA-Bandsaw blades achieves high cutting efficiency with an extremely small edge radius. To have the best tool life it is most important to saw in the new Bandsaw blades correctly. Find out in relation to the material type and the size the correct cutting speed (m/min) and the correct feed (mm/min).

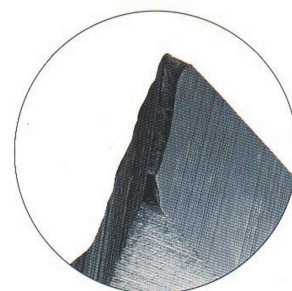
Picture Scale 30:1



New cutting tooth with extreme small edge radius.



With a correct sawing in of the new saw blade it becomes an optimal rounded edge radius.



Too much feed while sawing in the new blade can produce damage at the cutting edge

To sawing in the new saw blade it is necessary to reduce the normal feed by 50 %. So you can avoid the sharp cutting tooth being damaged by a big chip thickness. New Bandsaw blades can tend at the beginning to vibrate and make an singing noise. If it so, please reduce slightly the cutting speed.

On small work pieces we commend to cut 300 mm² of the cutting material to sawing in the new Bandsaw blades. At big workpiece dimensions we commend a time for the sawing in approx. 15 min. After sawing in of the new Bandsaw blades increase the feed slowly to the normal value.

MEBA BIMETAL BAND SAW BLADES

MEBA
sawing solutions.

MEBA - Bimetal - "P"

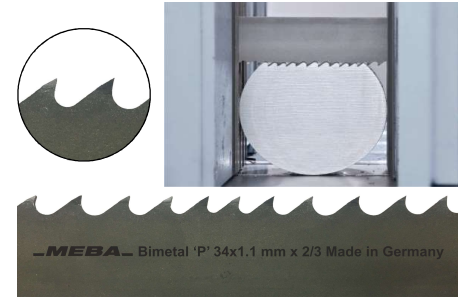
General purpose band saw blades for all type of sawing.

Advantages:

➤ High cutting accuracy, High wearability - 8% cobalt

Range of application:

➤ General purpose grade



MEBA - Bimetal - "E"

Best Performance bandsaw blade with wear resistant M42 HSS suitable for vibration-reduced cutting of thin or medium materials.

Advantages:

➤ High working life by oscillating sawing cuttings

Range of application:

➤ For profiles and bundle cuts

➤ For small and often changing workpiece dimensions



MEBA - Bimetal - "S"

Best Performance bandsaw blade with wear resistant M42 HSS positive rake angle which ensures high performance and long service life.

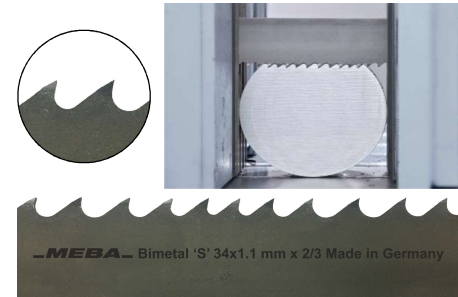
Advantages:

➤ Increased cutting accuracy and wearability by alloyed high cutting steel

➤ with 8% cobalt and 10% molybdenum

Range of application:

➤ For steel up to 45 HRC; for serial cuts; for bundle cuts; for non ferrous metals and fine steel.



MEBA - Bimetal - "PB"

Extremely innovative teeth design, suitable to cut tubes and structural in singular or bundles

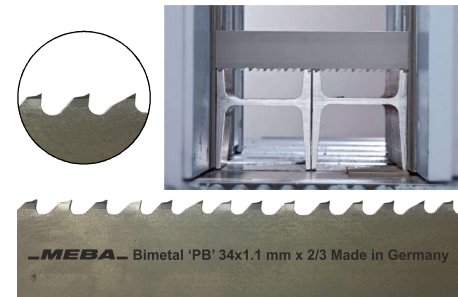
Advantages:

➤ Optimized aggressive tooth profile; More resistant to tooth strippage

➤ High tool life at cutting of hollow sections and bad supported I-beams

Range of application:

➤ For bundle cuts, profiles and bundle cuts, I-beams, stainless steel profiles.



MEBA - Bimetal - "H1 / HL"

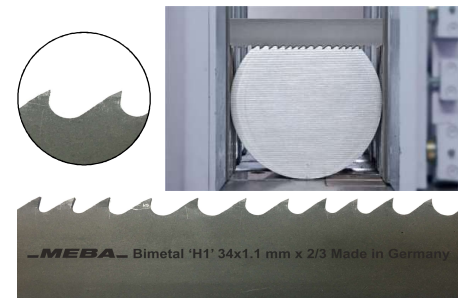
high positive rake angle makes it suitable for cutting difficult to cut materials with powder metalurgy cutting edge

Advantages:

➤ Specially developed positive tooth profile for sawing more easily with reduced feed forces.

Range of application:

➤ For medium to high toughness metal; for stainless steel; for high carbon steel



MEBA - Bimetal - "H2"

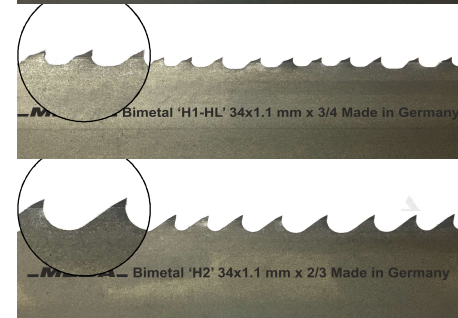
Best performance, high wear resistant M51 HSS teeth increase blade for difficult to cut materials.

Advantages:

➤ For highest performance; Teeth with high speed cutting steel M-51;

Range of application:

➤ Suitable for high toughness metal cutting materials; stainless steels; hardened steel; alloys used in the aero space technology like Ti-6AL-4V, 17-4PH, Monel and Inconel



MEBA SPECIAL BANDSAW BLADES



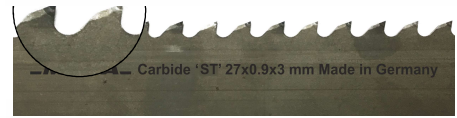
MEBA - Carbide - "HP"

New design Carbide tipped unset ground teeth bandsaw blade, suitable for very difficult to cut/hard materials with accurate and fast cuts.



MEBA - Carbide - "ST"

Suitable for cutting of abrasive materials, with suitably to use for construction industries & building trades.



MEBA - Carbide - "FD"

Carbide-tipped foundry specialist bandsaw blade for sawing hard materials as well as cutting of sanded castings.



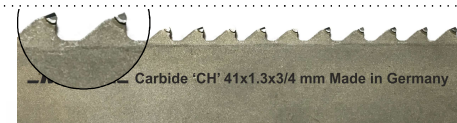
MEBA - Carbide - "GC"

Suitable for cutting abrasive, bonded materials, vehicle tires, graphite, braking linings; glass-fiber, reinforced plastics, cables and ceramic tiles.



MEBA - Carbide - "CH"

Carbide-tipped unset ground bandsaw design to cut case hardened/chrome plated steels.



MEBA - "Bimetal Coated" & "Carbide Coated"

Suitable for cutting hard/difficult materials with high production and higher tool life.



MEBA - "Diamond"

Suitable for cutting aluminium with high silicon content, carbide, marble/granite, green ceramics, brake linings, glass fibers, graphites, lime stone quartz.



- Bimetal HSSI & Coated blades are available in stock from 13 mm to 80 mm width in all TPI.
- Carbide blades are available in stock from 13 mm to 67 mm width in all TPI.
- Diamond blades are available in stock as mentioned below.

Width x Thickness (mm)	10 x 0,50	13 x 0,50	16 x 0,50	20 x 0,50	25 x 0,70	41 x 0,90	50 x 0,90
Pitch (mm)	6	8	8	Continuous Edge	12	20	20

Chosen teeth per inch for Bandsaw Blades

Teeth per inch for solid material				Teeth per inch for Angle / Channel / Pipe			
-----------------------------------	--	--	--	---	--	--	--

Cutting in (mm)	TEETH PER INCH (TPI)							
	10 / 14	8 / 12	6 / 10	5 / 8	4 / 6	3 / 4	2 / 3	1,4 / 2
0-20	■							
20-50		■						
25-60			■					
35-80				■				
50-100					■			
80-150						■		
120-350							■	
250-600								■

D (mm) S (mm)	TEETH PER INCH (TPI)									
	20	40	60	80	100	150	200	300	500	
2	10 / 14	10 / 14	10 / 14	10 / 14	10 / 14	10 / 14	10 / 14	10 / 14	8 / 12	
3	10 / 14	10 / 14	10 / 14	8 / 12	8 / 12	8 / 12	6 / 10	6 / 10	6 / 10	
4	10 / 14	10 / 14	10 / 14	8 / 12	8 / 12	6 / 10	6 / 10	5 / 8	4 / 6	
5	10 / 14	10 / 14	10 / 14	8 / 12	6 / 10	6 / 10	5 / 8	4 / 6	4 / 6	
6	10 / 14	10 / 14	8 / 12	8 / 12	6 / 10	5 / 8	5 / 8	4 / 6	4 / 6	
8	10 / 14	8 / 12	6 / 10	6 / 10	6 / 10	5 / 8	5 / 8	4 / 6	4 / 6	
10		6 / 10	6 / 10	5 / 8	5 / 8	4 / 6	4 / 6	4 / 6	3 / 4	
12		6 / 10	5 / 8	4 / 6	4 / 6	4 / 6	4 / 6	3 / 4	3 / 4	
15		4 / 6	4 / 6	4 / 6	4 / 6	3 / 4	3 / 4	3 / 4	2 / 3	
20				4 / 6	4 / 6	3 / 4	3 / 4	3 / 4	2 / 3	
30				3 / 4	3 / 4	3 / 4	2 / 3	2 / 3	2 / 3	
50						2 / 3	2 / 3	2 / 3	1,4 / 2	
75							2 / 3	1,4 / 2	1,4 / 2	
100								1,4 / 2	1,4 / 2	

When you clamp 2 or more tubes placed side by side, use above list with the double wall thickness (S).

MEBA High Productivity Machine Models



MEBAswing The smart choice for all-purpose bandsawing.

MEBAswing 300. Semi Auto
Capacity: 90° - 300mm
max. mm 300 x 250
Motor: 2.2 KW
Bandspeed: 25/40/55/70 m/min
Saw Blade: 3505x27x0.9
Material Feed: Manual

MEBAswing 350. Semi Auto
Capacity: 90° - 350mm
max. mm 400 x 250



MEBAeco 330 A NC Automatic
Ready-made Individuality
Capacity: 90° - 330mm
max. mm 330 x 330
Motor: 4KW
Bandspeed: 10-100 m/min
Saw Blade: 4420x34x1.1
Material Feed: Automatic

MEBAeco 260 A NC Automatic
MEBAeco 330 A NC Automatic
MEBAeco 430 A NC Automatic
MEBAeco 600 A NC Automatic



MEBAswing The smart choice for fabrication expert in mitre cutting.

Capacity: 90° - 45° - 30°
240 DG max. mm 310 x 240

230 GA max. mm 310 x 230
350 G max. mm 500 x 300
440 DG max. mm 620 x 440



MEBAeco 800
Heavy duty semi automatic machine
Capacity: 90°
max. mm 800 x 800

300	max. mm 400 x 300
400	max. mm 400 x 400
700-400	max. mm 700 x 400
600	max. mm 600 x 600
800	max. mm 800 x 800
1000	max. mm 1000 x 1000
1500-1000	max. mm 1500 x 1000
2000	max. mm 2000 x 2000

2-column linear guided machine AC-drive
Saw feed by strong & rigid hydraulic mechanism
Incl. hydraulic material shuttle table or infeed roller table - driven

MEBAeco 335
Ready-made individuality.

Capacity: 90° - 45° - 30°

335 / 335 A / 335 G / 335 GA

335 DG / 335 DGA-600 / DGA 1300...

max. mm 500 x 335



MEBAeco 410
Ready-made individuality.

Capacity: 90° - 45° - 30°

410 / 410 DG / 410 A-1300

410 DGA-2300...

max. mm 700 x 400



MEBAeco 510
Ready-made individuality.

Capacity: 90° - 45° - 30°

510 / 510 DG / 510 A-1300

510 DGA-2300...

max. mm 700 x 500



MEBAmat 330
MEBAmat 434
Power. Persistence. Precision.

Capacity: 90°

330 max. mm 350x 330

434 max. mm 430x 430

Solid and powerful machine for serial cuttings
For highest productivity and hard to cut materials



MEBAxtreme
Pure Power.
Capacity: 90°

800-510 max. mm 800x510
1140-510 max. mm 1140x510
1250-510 max. mm 1250x510
800-600 max. mm 800x600
1140-600 max. mm 1140x600
1250-600 max. mm 1250x600
1250-800 max. mm 1250x800
1000x1000 max. mm 1000x1000
1250-1000 max. mm 1250x1000
800-510A max. mm 800x510
800-600A max. mm 800x600
800-600A-2000 max. mm. 800x600

800x510
1140x510
1250x510
800x600
1140x600
1250x600
1250x800
1000x1000
1250x1000
800x510
800x600



MEBAsteel
The clever solution for structural steel.

Capacity: 90° - 45° - 30°

1100 DG max. mm 1100 x 510
1100 DGA-3300 max. mm 1100 x 510
1250 DG max. mm 1250 x 520

Mitre cutting of materials with big dimensions



MEBAtop
The revolution in structural steel.

Capacity: 90° - 45° - 30°

1020 DGP max. mm 1020 x 500
swiveling 30° on both sides
1270 DGP max. mm 1270 x 500

Flexible solution for power-sawing e.g. in structural steel engineering



MEBAPsv
Cost efficient vertical bandsaw with travelling head designed to cut large Carbon Steel, Stainless Steel, Slabs, Blocks & Ingots

MEBAPsv range
- Standard vertical bandsaw machine
- Graphite cutting plate saws
- Customized designed machines as per customer requirement upto 3,000 mm



MEBAMcs 70
High performance circular saw for serial cuts. high-tec, high productivity, precise cutting

Capacity: 90°
70 / 85 / 110 / 150

- Rigid and solid machine structure for overall rigidity and equipment stability.
- High Quality rigid linear guides and high performance servo motors
- Accurate positioning of the material by ball lead screw with servo motor regulated by AC drive



MEBA Metall-Bandsägemaschinen GmbH
Lindenstraße 6-8
D-72589 Westerheim
Tel: (+49) 07333-9644-0
Fax: (+49) 07333-9644-44
Web.: <http://www.meba-saw.de>
E-mail: info@meba-saw.de

MEBA India Private Ltd.
Plot No 289, Phase-IV, Sec. 57, HSIIDC Kundli,
District-Sonepat, Pin Code-131028
Haryana (India)
Tel: +91 130 4091010 Fax: +91 130 4000603
Web.: <http://www.meba-saw.in> ; www.mebaindia.com
E-mail: info@meba-saw.in; info@mebaindia.com

Authorised Dealer