

**Garant**
**Circular saw blade medium, TiAlN, Ø×thickness: 275X2,5mm**

**Order data**

Order number	177070 275X2,5
GTIN	4045197849397
Item class	11T

**Description**
**Version:**

Top quality **with TiAlN coating** for the highest blade life requirements. Shorter sawing times due to higher cutting speeds.

**Application:**

For low speed machines (approx. 50 rpm).

**Pitch t:** (tooth form).

- **4 mm (BW) – For profiles and pipes with 1.0 – 1.5 mm wall thickness.**
- **5 / 6 mm (HZ) – For medium profiles, pipes and solid bar with 1.5 – 20 mm wall thickness / cross-section.**
- **7 / 8 mm (HZ) – For thick profiles and solid bar up to approx. 50 mm wall thickness / cross-section.**
- **10 – 16 mm (HZ) – For extra thick cross-sections and solid bar more than 50 mm.**

**Note:**

- **For stainless steels (such as V2A) the correct cutting speed and lubrication is crucial (see information in the machining handbook No. 110020).**
- **The concentricity and axial run-out values are considerably better than those to DIN 1840, in some cases by up to 50 %.**

**Successor product to No. 177060.**

## Technical description

Bore Ø	40 mm
Pitch t	6 mm
Ø	275 mm
suitable for saw makes	Eisele; Trennjäger
Thickness	2.5 mm
No. of teeth Z	140
Drive hole pitch circle	55; 64 mm
Number of drive holes	2; 4
Drive hole Ø	8; 12 mm
Coating	TiAlN
Tool material	HSS
Through-coolant	no
Type of product	Circular saw blade

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	800 m/min	N
Alu > 10% Si	suitable only under restricted conditions	800 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	55 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	42 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	38 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	28 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	24 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	20 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	26 m/min	S

GG(G)	suitable	45 m/min	K
CuZn	suitable only under restricted conditions	600 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable only under restricted conditions		