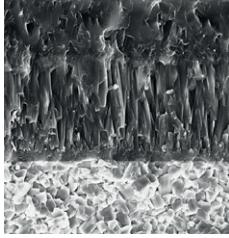
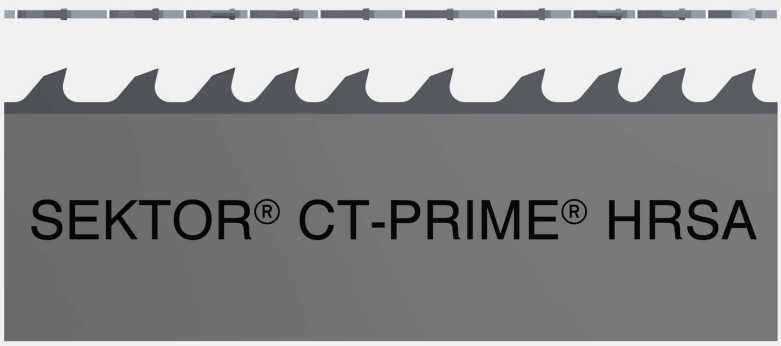


CT-PRIME® HRSA

Carbide bandsaw blade for strain hardened, difficult to cut materials; intended for the aerospace sector



- LEVEL PRODUCT S
- GEOMETRY HRSA
- SIZES 41x1,3- 80x1,6 mm
- HONED
- COATED

Characteristics

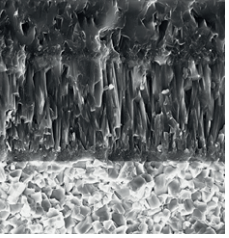
- Special multilayer coated carbide blade for high efficiency cutting of heat-resistant superalloys
- Sharp carbide hone
- Heat resistant PVD edge for difficult cutting
- Maximum durability on HRSA alloys with sharp nanohardness of over 35 gigapascal (GPa)
- HRSA tooth geometry
- HRSA geometry and quality of the coated carbide tips designed to withstand maximum cutting forces and high wear on the cutting edge
- Coolant with low percentage of emulsion required
- Can be used on new or factory rebuilt machines
- Reduced cutting resistance for increased chip removal at low blade speed for the relevant material
- For high volume cutting and reduced cycle times

Applications

- All nickel and iron based HRSA alloys
- Heat resistant duplex and superduplex steels
- Stainless steel
- Titanium alloys

Advantages

- Maximum capability on HRSA materials
- Significantly increased cutting speeds
- PVD thermal barrier coating



CT-PRIME®
CARBIDE TIPS BANDSAW BLADE

SEKTOR®
CUTTING EXPERT

CT-PRIME® HRSA

WIDTH x THICKNESS		TPI (TEETH PER INCH)		
mm	inch	2,0/3	1,4/2	1,3/1
41 x 1,3	1-5/8 x 0,050	HRSA		
54 x 1,3	2-1/8 x 0,050	HRSA	HRSA	
54 x 1,6	2-1/8 x 0,063	HRSA	HRSA	
67 x 1,6	2-5/8 x 0,063	HRSA	HRSA	HRSA
80 x 1,6	3-1/8 x 0,063		HRSA	HRSA
CONTACT LENGTH		120-250	250-400	400-800

Overview of materials

	CT-PRIME® HRSA (COATED)	CT-APEX® HRSA (UNCOATED)
Construction steel, Automatic steel	Approved	Approved
Carbon steel	Approved	Approved
Hardened and tempered steel	Approved	Approved
Hardened and tempered steel over 1200 N/mm²	Approved	Allowed
Case hardening steel, harmonic steel	Approved	Approved
Bearing steel	Allowed	Allowed
Hot tool steel	Allowed	Allowed
Cold tool steel	Allowed	Allowed
High-speed steel	Allowed	Allowed
Ferritic stainless steel	Approved	Approved
Austenitic stainless steel	Recommended	Approved
Martensitic stainless steel	Recommended	Approved
Duplex and heat-resistant steel	Recommended	Approved
Cast iron	Not Applicable	Not Applicable
Nickel alloys	Recommended	Recommended
Titanium alloys	Approved	Approved
Aluminium	Not Applicable	Not Applicable
Copper alloys	Not Applicable	Not Applicable
Aluminium bronze	Not Applicable	Not Applicable

LEGEND

Recommended · Approved · Allowed · Not Applicable

Recommended uses

- All common titanium alloys
- Common superalloys (HRSA)

Superleghe (HRSA) comuni

- Alloy 400, Alloy K-500, Alloy C-276, Alloy C-22, Alloy X, Alloy 825, Alloy 925, Alloy 903, Alloy 907, Alloy 909, Alloy 625, Alloy 725, Alloy X-750, Alloy 718, Alloy 75, Alloy 80a, Alloy 90, Alloy 901, Alloy C263, Waspaloy®