



PILANA METAL

Hand hacksaw blades

Standard products

Production to order (special sizes)

Customized colours and design

Private labels

BiM (BI-METAL) hand hacksaw blades

Bi-metal hand hacksaw blades are made of M2 and D6A steel. The combination of these two materials ensures excellent quality. HSS wire is welded by a laser to a spring steel tape.

This ensures flexibility, solidity and pliability of the blade body and also high teeth hardness. In order to guarantee our customers uncompromising quality of the blades, we use only bi-metal steel produced by renowned producers in Europe.

Chemical composition of the steel:

BiM hacksaw blades	C	Cr	Mo	V	W	Ni
HSS steel M2 (teeth)	0,85	4,2	5,1	2,0	6,4	-
Steel D6A (body)	0,45	1,0	1,0	0,1	-	0,5

Mechanical attributes and execution of the blades:

Teeth hardness	Body hardness	Tooth setting	Dimensions	Color	Marking
64-65 HRC	50 +/- 1 HRC	wavy	300 x 13 x 0,63 mm (12 x 1/2 x 0,025")	white	blue (RAL 5005)

BiM hacksaw blade 18 TPI

Order code: B-3013-18-P

Suitable for cutting material > 6 mm



BiM hacksaw blade 24 TPI

Order code: B-3013-24-P

Suitable for cutting material < 5 mm



BiM hacksaw blade 32 TPI

Order code: B-3013-32-P

Suitable for cutting material < 2 mm



Usage and advantages of BiM hacksaw blades:

They are suitable for cutting various materials, especially for hard steel up to 1100 N/mm². BiM blades have a long lifetime and enable an easy and fluent cut without efforts.

Packing:

Blades are packed in black plastic boxes of 100 pcs, for easier handling are the blades inside the box in bundles of 10 pcs. On the box is a label with the identification of the blade. The weight of the packing is 2000g.

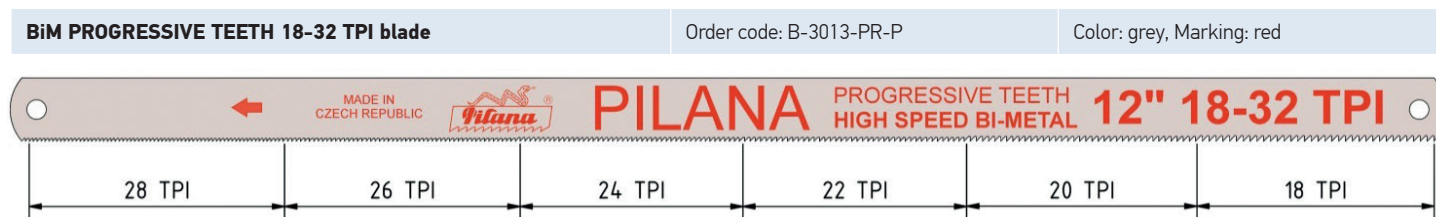


Apart from the standard toothing we offer BiM blades also with irregular teeth pitch. The use of this special blades has three main reasons:

1. Easier cutting-in into the material.
2. Cutting of bars and profiles with various wall thickness.
3. Increasing of the profile cutting speed

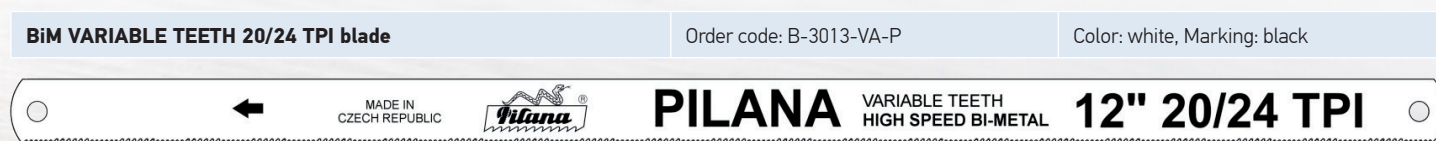
BiM hacksaw blade with PROGRESSIVE TEETH 18-32 TPI

The labelling 18-32 is a long used business name. In fact has our PROGRESSIVE blade six groups of teeth of 50 mm. On the left side are 18 TPI, followed by 20, 22, 24, 26 and 28 TPI are on the right side. Because of the six groups of teeth the cutting is fluent. For an easy cuttin-in you use the side with the fine teeth (26 a 28 TPI).



BiM hacksaw blade with VARIABLE TEETH 20/24 TPI

These blades use the same toothing technology like the band saw blades for metal cutting (VARIO). On the entire lenght of the blade we can find repeatedly groups of 12 teeth, where the first 6 teeth has a pitch of 20 TPI and the next 6 teeth 24 TPI. VARIABLE toothing will be appreciated especially when cutting pipes. In the top and bottom part of the pipe you are cutting thick material, while in the central part the blade is cutting through thin walls. With this toothing you can achieve faster cutting, whether cutting any material.



Other characteristics and application as with BiM blades with standard toothing.



HSS FLEXIBLE hand hacksaw blade

Blades made from HSS steel, with hardened teeth area only. Heat treatment creates longitudinal areas with different hardness. The teeth have a hardness of 64 +/- 1 HRC, they are followed by several areas with gradually decreasing hardness. The blades are because of this heat treatment extraordinary flexible. HSS FLEXIBLE are blades for intensive cutting, they assure max. safety and high performance.

For these blades we use only HSS steel from the company ERASTEEL KLOSTER AB from Sweden, and that is why we can guarantee good quality of this blades.

Mechanical attributes and execution of the blades:

Teeth hardness	Tooth setting	Dimensions	Color	Marking
64 +/- 1 HRC	wavy	300 x 13 x 0,60 mm (12 x 1/2 x 0,024")	red	white

HSS FLEXIBLE hacksaw blade 18 TPI

Order code: F-3013-18-P

Suitable for cutting material > 6 mm



HSS FLEXIBLE hacksaw blade 24 TPI

Order code: F-3013-24-P

Suitable for cutting material < 5 mm



HSS FLEXIBLE hacksaw blade 32 TPI

Order code: F-3013-32-P

Suitable for cutting material < 2 mm



Usage and advantages of HSS FLEXIBLE:

These blades are suitable especially for cutting workpieces, which can't be firmly clamped (into a vice etc.). It is possible to cut various materials up to steel hardness 700 N/mm².

Packing:

Blades are packed in black plastic boxes of 100 pcs, for easier handling are the blades inside the box in bundles of 10 pcs. On the box is a label with the identification of the blade. The weight of the packing is 2000 g.

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HSS ALL HARD hand hacksaw blades



Hand hacksaw blade HSS ALL HARD is made from HSS steel hardened at full length. High hardness of the blade, which is the same throughout the whole profile, gives the blade extreme rigidity and strength. The blades are suitable for firmly clamped material.

The ends are annealed, which prevents from cracks in the clamping holes during cutting. Also here applies, that for the production we only use HSS steel from the company ERASTEEL KLOSTER AB from Sweden.

Mechanical attributes and execution of the blades:

Teeth hardness	Tooth setting	Dimensions	Color	Marking
64 +/-1 HRC	wavy	300 x 13 x 0,60 mm (12 x 1/2 x 0,024")	blue	white

HSS ALL HARD hacksaw blade 18 TPI	Order code: A-3013-18-P	Suitable for cutting material > 6 mm
HSS ALL HARD hacksaw blade 24 TPI	Order code: A-3013-24-P	Suitable for cutting material < 5 mm
HSS ALL HARD hacksaw blade 32 TPI	Order code: A-3013-32-P	Suitable for cutting material < 2 mm



Packing:

Blades are packed in black plastic boxes of 100 pcs, for easier handling are the blades inside the box in bundles of 10 pcs. On the box is a label with the identification of the blade. The weight of the packing is 2000 g.

HSS „ALL HARD“ blades are also made in a doubleside execution, with width 25 mm.

Teeth hardness	Tooth setting	Dimensions	Color	Marking
64 +/-1 HRC	wavy	300 x 25 x 0,65 mm (12 x 1 x 0,026")	grey	white

HSS ALL HARD hacksaw blade 18 TPI	Order code: A-3025-18-P	Suitable for cutting material > 6 mm
HSS ALL HARD hacksaw blade 24 TPI	Order code: A-3025-24-P	Suitable for cutting material < 5 mm

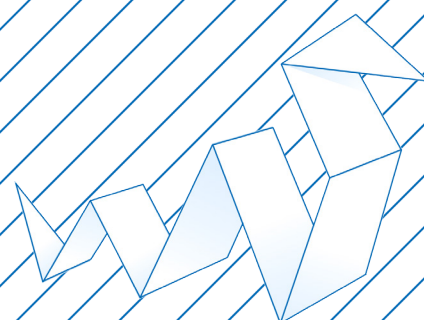


Usage and advantages of HSS ALL HARD:

These blades are suitable for professional cutting. The advantage is the long lifetime of the blade, its speed and accuracy when cutting. They are suitable especially when cutting steel up to 900 N/mm² hardness.

Packing:

The blades are packed into white plastic boxes of 50 pcs or in paper boxes of 100 pcs. The weight of the 50 pcs packing is 2000 g. The weight of the 100 pcs is 3800 g.



CARBON FLEXIBLE hand hacksaw blades

Hand hacksaw blades CARBON FLEXIBLE are made from steel with high content of carbon. The heat treatment is done by induction hardening with cooling down in water. High content of carbon enables to harden up to the same hardness like the blades made from HSS steel. Blades CARBON FLEXIBLE are not meant for challenging application, but especially for home use. For this product we use steel made in the Czech Republic. Because of this, our blades are of much better quality than blades imported from Asia.

Mechanical attributes and execution of the blades:

Teeth hardness	Tooth setting	Dimensions	Color	Marking
64-65 HRC	wavy	300 x 13 x 0,65 mm (12 x 1/2 x 0,026")	orange	black

CARBON FLEXIBLE hacksaw blade 18 TPI	Order code: C-3013-18-P	Suitable for cutting material > 6 mm
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CARBON FLEXIBLE hacksaw blade 24 TPI	Order code: C-3013-24-P	Suitable for cutting material < 5 mm
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CARBON FLEXIBLE hacksaw blade 32 TPI	Order code: C-3013-32-P	Suitable for cutting material < 2 mm
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Usage and advantages of CARBON FLEXIBLE:

Blades are meant for hobby cutting. They are suitable for plastic, non-iron steel and soft steel.

Packing:

Blades are packed in paper boxes of 100 pcs, for easier handling are the blades inside the box in bundles of 10 pcs. On the box is a label with the identification of the blade. The weight of the packing is 2000 g.



One-side and doubleside blades marked MYROS SPECIAL, made by ČSN 222950 and 222951 norm, are traditional product of company PILANA. The blades are induction hardened in oil, which is also a preservative. The blades have a simple design, to ensure a low price, but its utility value is comparable with the value of carbon flexible blades. The hardness of the teeth is between 64-65 HRC. The tooth setting is wavy. If necessary we can also make these blades coloured and marked.

Identification	Dimensions	Order code	Tooth pitch	Packing	Packing weight
22 2950 one-sided	300 x 13 x 0,65 mm	R-3013-18-P	18 TPI	100 pcs	2000 g
22 2950 one-sided	300 x 13 x 0,65 mm	R-3013-24-P	24 TPI	100 pcs	2000 g
22 2950 one-sided	300 x 13 x 0,65 mm	R-3013-32-P	32 TPI	100 pcs	2000 g
22 2951 doublesided	300 x 20 x 0,65 mm	R-3020-18-P	18 TPI	100 pcs	3000 g
22 2951 doublesided	300 x 20 x 0,65 mm	R-3020-24-P	24 TPI	100 pcs	3000 g
22 2951 doublesided	300 x 20 x 0,65 mm	R-3020-32-P	32 TPI	100 pcs	3000 g
22 2951 doublesided	300 x 25 x 0,65 mm	R-3025-18-P	18 TPI	72 pcs	2660 g
22 2951 doublesided	300 x 25 x 0,65 mm	R-3025-24-P	24 TPI	72 pcs	2660 g



Doublesided „COMBI“ hand hacksaw blades

New in our product range are the doublesided blades with combined tooththing. On one side of the blade are teeth 24 TPI for metal cutting and on the other side 8 TPI for wood cutting or 14 TPI for plastic cutting.

Dimensions	Order code	Tooth pitch	Packing	Packing weight	Usage
300 x 20 x 0,65 mm	K-3020-24/14-P	24/14 TPI	100 pcs	3000 g	metal/plastic
300 x 20 x 0,65 mm	K-3020-24/8-P	24/8 TPI	100 pcs	3000 g	metal/wood
300 x 25 x 0,65 mm	K-3025-24/14-P	24/14 TPI	72 pcs	2660 g	metal/plastic
300 x 25 x 0,65 mm	K-3025-24/8-P	24/8 TPI	72 pcs	2660 g	metal/wood



Custom marking

Part of our efforts to support our clients is also manufacturing tools with their logo. It is our common practice that apart from our brand PILANA and MYROS SPECIAL logos and graphics, we denote tools of our customers with their own brands and logos. We produce tools for well-known department stores and acclaimed tools producers. The production with custom marking makes up the majority of our the whole production and goes into hundreds of different markings.

We are ready to make a „brand“ not just for big companies, but also for small traders and distributors, who buy their tools just in hundreds of pieces. Our care lies not only in the preparation of graphic designs and denote of the tools, but also in the supply of branded labels, packing and pallets. We are ready to help you pick the right color, marking and packing for tools with your own brand.

Do not hesitate to contact us. We will do our best to your satisfaction.

260 x 9 mm

WE CAN MAKE YOUR OWN PRIVATE LABEL



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