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# CUTTING TOOLS

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**BÄUMER**

# FROM RAW MATERIAL TO THE FINISHED KNIFE



# FABRICATION ACCORDING TO DIN EN ISO 9001

## RAW MATERIAL

- Raw material of impeccable quality, comprehensive incoming goods inspection
- Acquisition of raw material only from certified European producers
- Functional and proper storage in especially designed warehouse



## CUTTING OFF

- Special machinery to cut band knives to exact length
- Individually cut to size by our highly trained staff



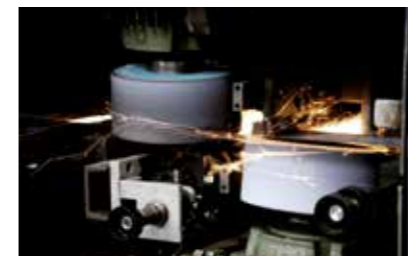
## WELDING

- Years of experience and qualified staff members
- State of the art grinding machines
- Fulfillment of individual customer requests



## PRECISION GRINDING

- Elaborate processing of welding seams
- Very well trained welding operators and modern machine park
- Inspection and analysis of all welding seams after processing



## QUALITY CHECK

- Ongoing quality checks at each production step and thorough outbound inspection
- Surface quality tests, material hardness tests, ultrasonic tests, tests of tolerances, running smoothness of band knives, etc.





# PROCUT AND HQ

## DURABILITY AND SHARPNESS

... FOR ALL MACHINE TYPES WITH TOOTHED OR GROUND BAND KNIVES

### PROCUT FOR TOOTHED KNIVES

The hardened tooth tips make ProCUT a premium type among the toothed band knives and enhance our high-quality standard product range. ProCUT is perfectly suitable for processing special materials for example on contour or vertical cutting machines.

#### Advantages of ProCUT at a glance:-

- Increase of service life by up to 40 % depending on material and machine
- Increase of the degree of hardness of the tooth tips by up to 25 %
- Higher process security as the knife remains sharp for a longer time
- Increase of your productivity as in the long run less knives have to be exchanged
- Allows to cut special materials (such as rebond foam with a volume weight of up to 200 kg, melamine foam, pressed filter foam, Basotect or sponge with scouring fleece)
- The optimum physical features of the knife, such as elasticity are maintained
- Only the tooth tips of these knives are hardened with a special and unique technology

### HQ FOR GROUND KNIVES

The high quality band knives have been given their name by the extremely low admissible tolerance range of the knife back and the knife edge and thus provide utmost cutting accuracy. They are perfectly suitable for splitting, peeling, profiling and horizontal cutting machines for example.

#### Advantages of HQ knives at a glance:

- Very low tolerances of the knife back and the knife edge allow a high cutting accuracy
- Much longer service life of the knife due to harder knife steel
- Increase of your productivity due to fewer knife changes
- Higher process security thanks to improved steel quality
- Grinding time decreased by 10 % because of a precise pre-sharpening
- After competition of quality control and tolerance certification a test certificate is issued and will be supplied with the band knife

# BLANKET ORDER

### SAVE YOUR TIME AND MONEY

We would like to offer you our annual blanket order option which will provide great benefits for your company.

By placing a blanket order, the band knives will be supplied according to your individual demand. The requested quantity to be released is available for shipping at any time. Delivery times specified upon blanket order placement can be adjusted if necessary. Just call and we will even deliver the band knife beyond agreed lead times. In addition to the price advantage for large orders you can also benefit from partial invoices as you are only being billed per your release.

Your advantages at a glance:

- Automatic just-in-time delivery of your band knives
- Short lead times in case of an emergency - no loss of production
- Price advantage due to quantity discount
- Invoiced per release
- Less time needed to keep an eye on delivery date
- Time saving in your purchasing department
- Expense reduction due to less capital lockup in your warehouse

Should you have any questions or need any further information, please feel free to contact us or our representative in your country at any time.

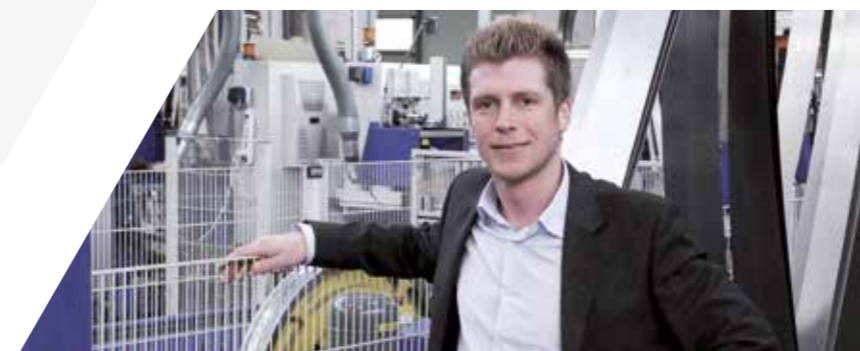
We look forward to hearing from you soon.

### Your sales representative for replacement parts and cutting tools:



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BÄUMER IS THE MOST EXPERIENCED MANUFACTURER OF BAND KNIVES, BAND SAWS AND CUTTING WIRES. STATE-OF-THE-ART PRODUCTION TECHNOLOGY, CAREFULLY SELECTED RAW MATERIALS AND TIGHT QUALITY CONTROLS ENSURE EXCEPTIONAL QUALITY.

**WE DON'T KNOW  
WHAT YOU WANT  
TO CUT, BUT WE  
KNOW THAT WE  
CAN DO IT**

# GROUND BAND KNIVES

## Grinding forms



6-30 mm  
2 heels



6-30 mm  
4 heels



6-30 mm  
4 heels  
twisted



6-20 mm  
1 heel  
single-sided



25-100 mm  
1 heel  
single-sided



25-100 mm  
2 heels



25-100 mm  
2 heels,  
Ratio 2:1

## GB1 Ground band knives 1 heel



|                      |        |
|----------------------|--------|
| GB1 6 - 20 x 0,45 mm | 1 heel |
| GB1 20 x 0,60 mm     | 1 heel |
| GB1 25 x 0,45 mm     | 1 heel |
| GB1 30 x 0,45 mm     | 1 heel |
| GB1 30 x 0,60 mm     | 1 heel |
| GB1 40 x 0,50 mm     | 1 heel |
| GB1 40 x 0,60 mm     | 1 heel |
| GB1 50 x 0,60 mm     | 1 heel |
| GB1 60 x 0,60 mm     | 1 heel |
| GB1 60 x 1,00 mm     | 1 heel |
| GB1 80 x 0,60 mm     | 1 heel |
| GB1 80 x 1,00 mm     | 1 heel |
| GB1 80 x 1,20 mm     | 1 heel |
| GB1 85 x 1,00 mm     | 1 heel |
| GB1 85 x 1,20 mm     | 1 heel |
| GB1 90 x 1,00 mm     | 1 heel |
| GB1 95 x 1,00 mm     | 1 heel |
| GB1 95 x 1,20 mm     | 1 heel |

## GB2 Ground band knives 2 heels



|                      |         |
|----------------------|---------|
| GB2 6 - 20 x 0,45 mm | 2 heels |
| GB2 20 x 0,60 mm     | 2 heels |
| GB2 25 x 0,45 mm     | 2 heels |
| GB2 30 x 0,45 mm     | 2 heels |
| GB2 30 x 0,60 mm     | 2 heels |
| GB2 40 x 0,50 mm     | 2 heels |
| GB2 40 x 0,60 mm     | 2 heels |

## GB2 Ground band knives 2 heels



|                  |         |
|------------------|---------|
| GB2 50 x 0,60 mm | 2 heels |
| GB2 60 x 0,60 mm | 2 heels |
| GB2 60 x 1,00 mm | 2 heels |
| GB2 80 x 0,60 mm | 2 heels |
| GB2 80 x 1,00 mm | 2 heels |
| GB2 80 x 1,20 mm | 2 heels |
| GB2 85 x 1,00 mm | 2 heels |
| GB2 85 x 1,20 mm | 2 heels |
| GB2 90 x 1,00 mm | 2 heels |
| GB2 95 x 1,00 mm | 2 heels |
| GB2 95 x 1,20 mm | 2 heels |

## GB4 Ground band knives 4 heels



|                      |                      |
|----------------------|----------------------|
| GB4 6 - 20 x 0,45 mm | 4 heels, not twisted |
| GB4 20 x 0,60 mm     | 4 heels, not twisted |
| GB4 25 x 0,45 mm     | 4 heels, not twisted |
| GB4 30 x 0,45 mm     | 4 heels, not twisted |
| GB4 30 x 0,60 mm     | 4 heels, not twisted |

## GB4t Ground band knives 4 heels, twisted



|                       |                  |
|-----------------------|------------------|
| GB4t 6 - 20 x 0,45 mm | 4 heels, twisted |
| GB4t 20 x 0,45 mm     | 4 heels, twisted |
| GB4t 20 x 0,60 mm     | 4 heels, twisted |
| GB4t 30 x 0,60 mm     | 4 heels, twisted |

## GB2-HQ Ground band knives 2 heels



|                     |         |
|---------------------|---------|
| GB2-HQ 50 x 0,60 mm | 2 heels |
| GB2-HQ 60 x 0,60 mm | 2 heels |
| GB2-HQ 80 x 0,60 mm | 2 heels |
| GB2-HQ 80 x 1,00 mm | 2 heels |
| GB2-HQ 85 x 1,00 mm | 2 heels |

# GROUND CONTOUR BLADES

## CBG

Ground contour blades



|     |               |         |
|-----|---------------|---------|
| CBG | 3-5 x 0,60 mm | 2 heels |
| CBG | 3-5 x 0,45 mm | 2 heels |



|     |               |         |
|-----|---------------|---------|
| CBG | 3-5 x 0,60 mm | 2 heels |
| CBG | 3-5 x 0,70 mm | 2 heels |
| CBG | 3-5 x 0,80 mm | 2 heels |



# TOOTHED CONTOUR BLADES

## CBT 12 or CBT 24

Toothed contour blades with 12 or 24 teeth



|        |               |         |
|--------|---------------|---------|
| CBT-12 | 3-5 x 0,60 mm | toothed |
| CBT-12 | 3-5 x 0,45 mm | toothed |



|        |               |         |
|--------|---------------|---------|
| CBT-24 | 3-5 x 0,60 mm | toothed |
|--------|---------------|---------|



|        |               |         |
|--------|---------------|---------|
| CBT-12 | 3-5 x 0,60 mm | toothed |
| CBT-12 | 3-5 x 0,70 mm | toothed |
| CBT-12 | 3-5 x 0,80 mm | toothed |



|        |               |         |
|--------|---------------|---------|
| CBT-24 | 3,6 x 0,60 mm | toothed |
| CBT-24 | 3,7 x 0,60 mm | toothed |
| CBT-24 | 3,8 x 0,70 mm | toothed |
| CBT-24 | 4,5 x 0,80 mm | toothed |

# TOOTHED CONTOUR BLADES

## CBT-12Pro or CBT-24Pro

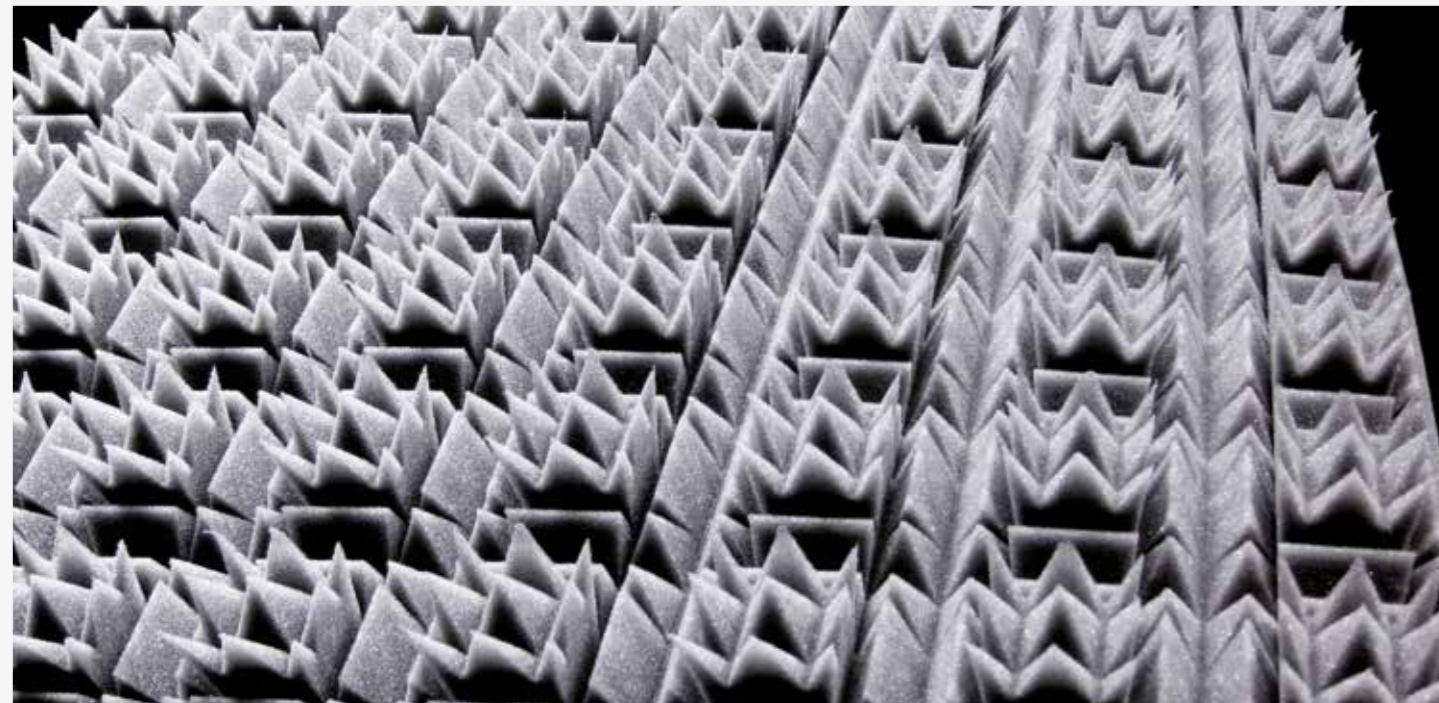
Toothed hardened contour blades with 12 or 24 teeth, ProCUT (hardened tooth tips)



|                         |         |
|-------------------------|---------|
| CBT-12Pro 3-5 x 0,45 mm | toothed |
| CBT-12Pro 3-5 x 0,60 mm | toothed |
| CBT-12Pro 3-5 x 0,70 mm | toothed |
| CBT-12Pro 3-5 x 0,80 mm | toothed |



|                         |         |
|-------------------------|---------|
| CBT-24Pro 3,6 x 0,60 mm | toothed |
| CBT-24Pro 3,7 x 0,60 mm | toothed |
| CBT-24Pro 3,8 x 0,70 mm | toothed |
| CBT-24Pro 4,5 x 0,80 mm | toothed |



EXPERTS THAT ARE A CUT ABOVE THE REST.

# TOOTHED BAND KNIVES

## TB1

Toothed ground on one side



No 10 | 10 Teeth/inch; 15 x 0,45 mm | Pointed tooting



No 12 | 17 Teeth/inch; 6 x 0,45 mm | Pointed tooting



No 13 | 25 Teeth/inch; 6 x 0,45 mm | Pointed tooting



No 14 | 25 Teeth/inch; 10 x 0,45 mm | Pointed tooting



No 30 | 10 Teeth/inch; 10 x 0,45 mm | Pointed tooting



No 31 | 10 Teeth/inch; 20 x 0,60 mm | Pointed tooting



No 34 | 10 Teeth/inch; 20 x 0,45 mm | Pointed tooting



No 40 | 14 Teeth/inch; 20 x 0,45 mm | Pointed tooting



No 41 | 10 Teeth/inch; 30 x 0,45 mm | Pointed tooting

## TB1

Toothed, ground on one side



No 15 | FT 10 x 3; 20 x 0,50 mm | Wave tooth



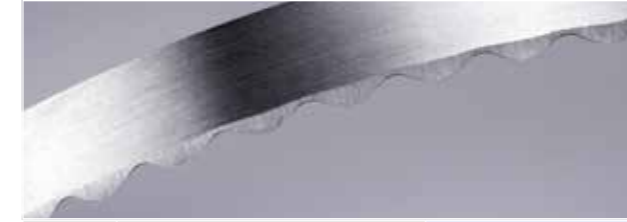
No 16 | FT 7 x 1,5; 20 x 0,45mm | Wave tooth



No 17 | 20 x 0,45 mm | Wave / concave



No 19 | 20 x 0,45 mm | Wave / convex



No 20 | FT 10 x 3; 40 x 0,50 mm | Wave tooth



No 22 | 30 x 0,45 mm | Wave / convex



No 36 | FT 10 x 3; 50 x 0,50 mm | Wave tooth



No 49 | 15 x 0,45 mm | Wave / concave



K18 | 12 Teeth/inch; 6-15 x 0,45 mm  
12 Teeth/inch; 8 x 0,60 mm | Toothed



# TOOTHED BAND KNIVES

## TB2 + TB2t

Toothed band knives, ground on both sides



No 11 | 10 Teeth/inch; 15 x 0,45 mm | Double Pointed tooting



No 28 | 10 Teeth/inch; 10 x 0,45 mm | Double Pointed tooting



No 29 | 18 Teeth/inch; 10 x 0,45 mm | Double Pointed tooting



No 32 | 18 Teeth/inch; 15 x 0,45 mm | Double Pointed tooting



No 42 | 14 Teeth/inch; 15 x 0,45 mm | Double Pointed tooting



No 44 | 10 Teeth/inch; 15 x 0,45 mm C100S | Double Pointed tooting



No 45 | 10 Teeth/inch; 20 x 0,45 mm C100S | Double Pointed tooting



No 46 | 24 Teeth/inch; 20 x 0,45 mm | Double Pointed tooting



No 47 | 24 Teeth/inch; 15 x 0,45 mm | Double Pointed tooting



No 18 | 15 x 0,45 mm | Double wave / concave

## TB2 + TB2t

Toothed band knives, ground on both sides



No 37 | 10 Teeth/inch; 15 x 0,45 mm | Double angle tooting



No 43 | 14 Teeth/inch; 15 x 0,45 mm | Double angle tooting



K18 | 12 Teeth/inch; 6-15 x 0,45 mm oder 8 x 0,60 mm

## TB1-Pro

Toothed band knives, toothed on one side, ProCUT (hardened tooth tips)



|       |                             |                 |
|-------|-----------------------------|-----------------|
| No 10 | 10 Teeth/inch; 15 x 0,45 mm | Pointed tooting |
| No 12 | 17 Teeth/inch; 6 x 0,45 mm  | Pointed tooting |
| No 13 | 25 Teeth/inch; 6 x 0,45 mm  | Pointed tooting |
| No 14 | 25 Teeth/inch; 10 x 0,45 mm | Pointed tooting |
| No 30 | 10 Teeth/inch; 10 x 0,45 mm | Pointed tooting |
| No 31 | 10 Teeth/inch; 20 x 0,60 mm | Pointed tooting |
| No 34 | 10 Teeth/inch; 20 x 0,45 mm | Pointed tooting |
| No 40 | 14 Teeth/inch; 20 x 0,45 mm | Pointed tooting |
| No 41 | 10 Teeth/inch; 30 x 0,45 mm | Pointed tooting |

## TB2-Pro + TB2t-Pro

Tooth band knives, toothed on both sides, ProCUT (hardened tooth tips)



|       |                             |                        |
|-------|-----------------------------|------------------------|
| No 11 | 10 Teeth/inch; 15 x 0,45 mm | Double Pointed tooting |
| No 28 | 10 Teeth/inch; 10 x 0,45 mm | Double Pointed tooting |
| No 29 | 18 Teeth/inch; 6 x 0,45 mm  | Double Pointed tooting |
| No 32 | 18 Teeth/inch; 10 x 0,45 mm | Double Pointed tooting |
| No 42 | 24 Teeth/inch; 10 x 0,45 mm | Double Pointed tooting |
| No 44 | 10 Teeth/inch; 20 x 0,60 mm | Double Pointed tooting |
| No 45 | 10 Teeth/inch; 20 x 0,45 mm | Double Pointed tooting |
| No 46 | 24 Teeth/inch; 20 x 0,45 mm | Double Pointed tooting |
| No 47 | 24 Teeth/inch; 15 x 0,45 mm | Double Pointed tooting |

# BAND SAWS TOOTHED ON ONE SIDE

## BS1

Band saws, toothed on one side



No 1 7 Teeth/inch;  
30 x 0,70 mm Pointed tothing / set



No 2 6 Teeth/inch;  
25 x 0,45 mm Angle tothing / set



No 3 8 Teeth/inch;  
20 x 0,45 mm Angle tothing / set



No 4 8 Teeth/inch;  
15 x 0,45 mm Angle tothing / set



No 5 8 Teeth/inch;  
20 x 0,45 mm Pointed tothing / set



No 6 14 Teeth/inch;  
16 x 0,65 mm Angle tothing / set



No 7 8 Teeth/inch;  
13 x 0,65 mm Angle tothing / set



No 8 8 Teeth/inch;  
8 x 0,65 mm Angle tothing / set



No 9 25 Teeth/inch;  
8 x 0,60 mm Angle tothing / set



No 23 4 Teeth/inch;  
13 x 0,50 mm Angle tothing / set with broaching tooth



No 24 4 Teeth/inch;  
13 x 0,65 mm Angle tothing / set with broaching tooth



No 25 3 Teeth/inch;  
20 x 0,50 mm Angle tothing / set with broaching tooth



No 26 3 Teeth/inch;  
20 x 0,80 mm Angle tothing / set with broaching tooth



No 27 4 Teeth/inch;  
20 x 0,50 mm Angle tothing / set with broaching tooth



No 35 3 Teeth/inch;  
16 x 0,65 mm Angle tothing / set



No 38 14 Teeth/inch;  
10 x 0,65 mm Angle tothing / set



No 39 18 Teeth/inch;  
8 x 0,65 mm Angle tothing / set



No 48 4 Teeth/inch;  
16 x 0,65 mm Angle tothing / set

## BS2

Band saws, toothed on both sides

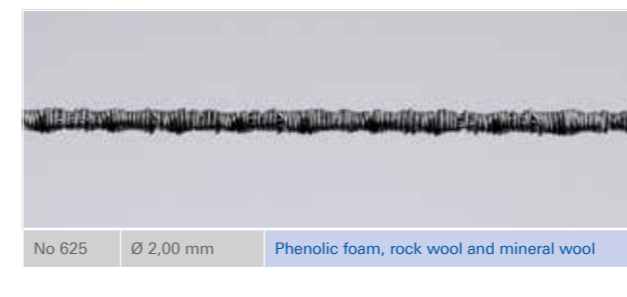
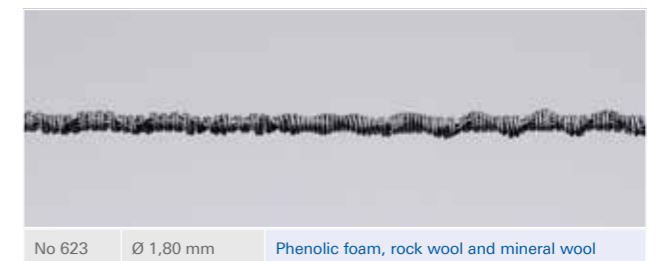
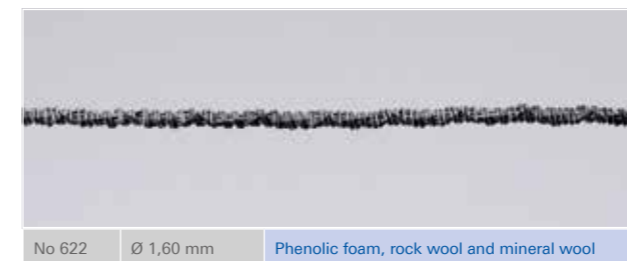
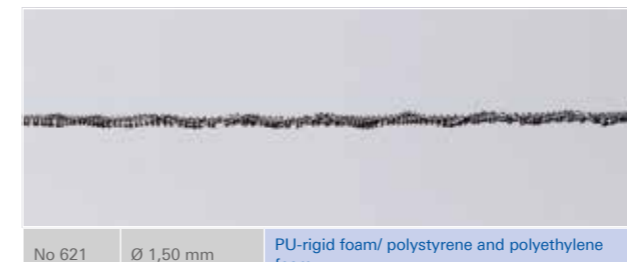
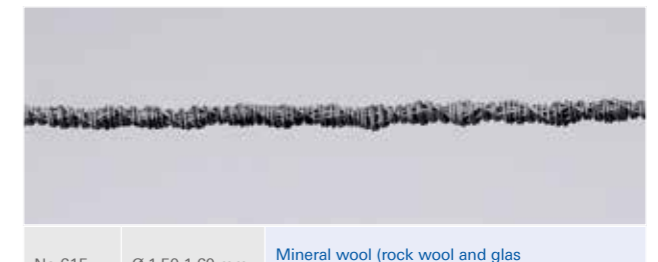
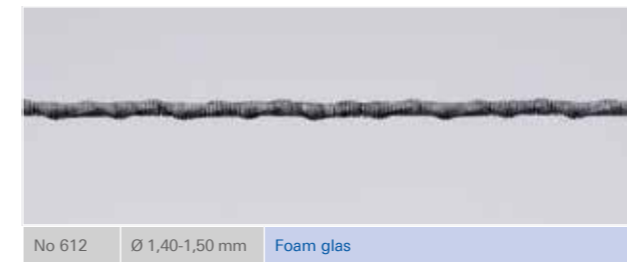
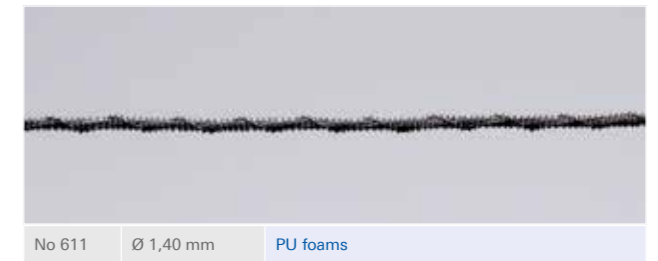
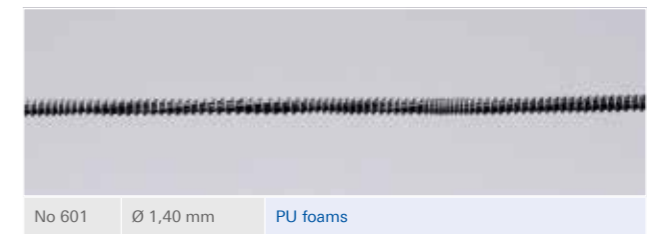
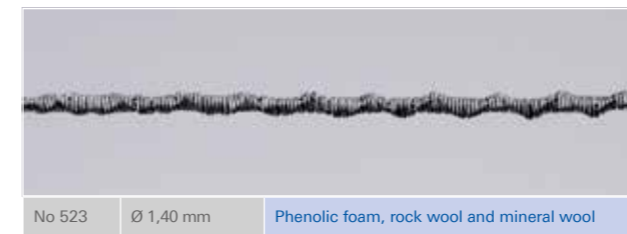
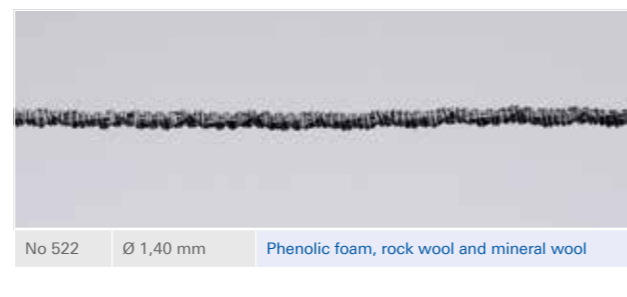
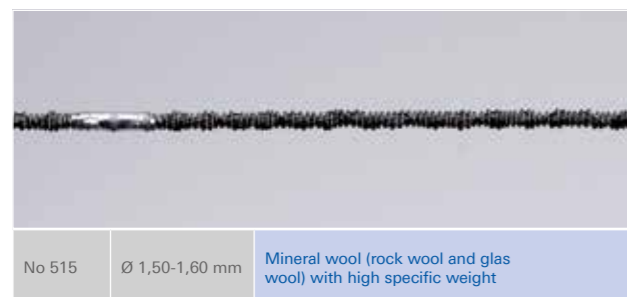
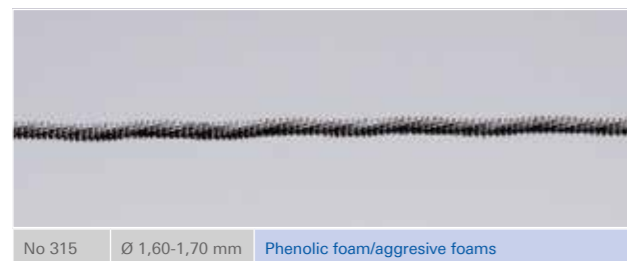
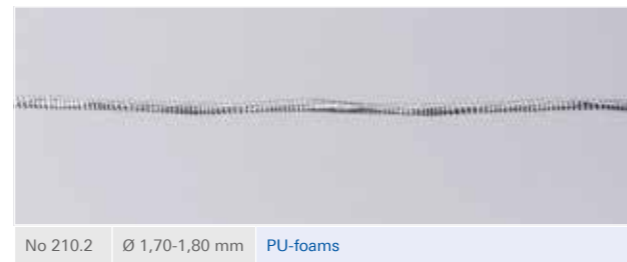
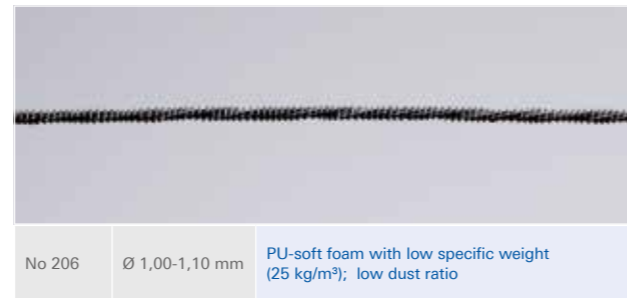
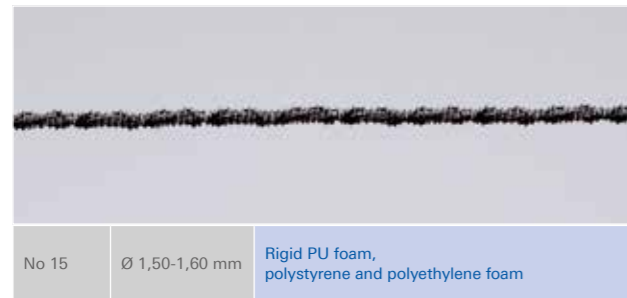


No 21 8 Teeth/inch;  
15 x 0,45 mm Double-angle tothing / set

# CUTTING WIRES

## CW

### Cutting wires





**WHETHER THE ABILITY TO ADJUST TO VARIOUS MATERIALS,  
DIFFERENT CUTTING PROCEDURES OR COMPETITIVE  
MACHINERY, WE CAN DO IT ALL.**

## SPECIAL KNIVES

### MDK

Knives for cushion radius cutting machines



MDK 22 x 0,20 mm

MDK 24 x 0,20 mm

### SP

Knives for shoulder pad machines



SP 16 x 0,10 mm

SP 22 x 0,10 mm



We have compiled all indications, images and technical information with utmost care. However, we cannot give any guarantee on the correctness. Subject to change.



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