
CUTTING TOOLS

BÄUMER

FROM RAW MATERIAL TO THE FINISHED KNIFE



We have compiled all indications, images and technical information with utmost care. However, we cannot give any guarantee on the correctness. Subject to change. 05-2019

FABRICATION ACCORDING TO DIN EN ISO 9001

RAW MATERIAL

- 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

- Elaborate processing of welding seams
- Very well trained welding operators and modern machine park (IDEAL Welding machines)
- Inspection and analysis of all welding seams after processing



PRECISION GRINDING

- State of the art grinding machines
- Years of experience and qualified staff members
- Automatic surface-grinding of the band knives



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.



GROUND BAND KNIVES

Grinding forms



GB1 + GBV1 Ground band knives 1 heel



| | |
|-----------------------|--------|
| GBV1 6 - 20 x 0,45 mm | 1 heel |
| GBV1 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 |
| GB1 100 x 1,20 mm | 1 heel |

GB2 + GBV2 Ground band knives 2 heels

| | |
|-----------------------|---------|
| GBV2 6 - 20 x 0,45 mm | 2 heels |
| GBV2 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 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 |
| GB2 100 x 1,20 mm | 2 heels |

GB4 + GBV4 Ground band knives 4 heels



| | |
|-----------------------|----------------------|
| GBV4 6 - 20 x 0,45 mm | 4 heels, not twisted |
| GBV4 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 + GBV4t Ground band knives 4 heels, twisted



| | |
|------------------------|------------------|
| GBV4t 6 - 20 x 0,45 mm | 4 heels, twisted |
| GBV4t 20 x 0,60 mm | 4 heels, twisted |
| GB4t 25 x 0,45 mm | 4 heels, twisted |
| GB4t 30 x 0,45 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 60 x 1,00 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 Type EC/FC
Ground contour blades



| | | |
|-----|----------------------|---------|
| CBG | 3-5 x 0,45 - 0,80 mm | 2 heels |
|-----|----------------------|---------|



TOOTHED CONTOUR BLADES

CBT-12, Type E 18/2, EC 18, FC 18
Toothed contour blades with 12 teeth



| | |
|---------------------------------|---------|
| CBT-12, Type E18/2, 3 x 0,45 mm | toothed |
|---------------------------------|---------|



| | |
|---------------------------------|---------|
| CBT-12, Type EC 18, 3 x 0,60 mm | toothed |
|---------------------------------|---------|



| | |
|--|---------|
| CBT-12, Type FC 18, 3-5 x 0,60 - 0,80 mm | toothed |
|--|---------|

CBT-18, Type P
Toothed contour blades with 18 teeth



| | |
|------------------------------------|---------|
| CBT-18, Type P, 3-5 x 0,45-0,80 mm | toothed |
|------------------------------------|---------|

CBT-24, Type DC, DC-HQ, FDC
Toothed contour blades with 24 teeth



| | |
|--|---------|
| CBT-24, Type DC-HQ, 3 x 0,60 mm* | toothed |
| CBT-24, Type DC, 3 x 0,60 mm | toothed |
| CBT-24, Type FDC, 3-5 x 0,60 - 0,80 mm | toothed |

*only as oscillating version

TOOTHED AND HARDENED CONTOUR BLADES

CBT-12Pro oder CBT-24Pro

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



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



CBT-24Pro 3-5 x 0,45 - 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 tothing**



No 12 17 Teeth/inch; 6 x 0,45 mm **pointed tothing**



No 13 25 Teeth/inch; 6 x 0,45 mm **pointed tothing**



No 14 25 Teeth/inch; 10 x 0,45 mm **pointed tothing**



No 30 10 Teeth/inch; 10 x 0,45 mm **pointed tothing**



No 31 10 Teeth/inch; 20 x 0,60 mm **pointed tothing**



No 34 10 Teeth/inch; 20 x 0,45 mm **pointed tothing**



No 40 14 Teeth/inch; 20 x 0,45 mm **pointed tothing**



No 41 10 Teeth/inch; 30 x 0,45 mm **pointed tothing**



No 52 14 Teeth/inch; 15 x 0,45 mm **pointed tothing**

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 0,45 mm **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; 6-20 x 0,45 mm
12 Teeth/inch; 8 x 0,60 mm **contour tooth**

TOOTHED BAND KNIVES

TB2 + TB2t

Toothed band knives, ground on both sides



No 11 | 10 Teeth/inch; 15 x 0,45 mm | double pointed toothing



No 28 | 10 Teeth/inch; 10 x 0,45 mm | double pointed toothing



No 29 | 18 Teeth/inch; 10 x 0,45 mm | double pointed toothing



No 32 | 18 Teeth/inch; 15 x 0,45 mm | double pointed toothing



No 42 | 14 Teeth/inch; 15 x 0,45 mm | double pointed toothing



No 44 | 10 Teeth/inch; 15 x 0,45 mm C100S | double pointed toothing



No 45 | 10 Teeth/inch; 20 x 0,45 mm C100S | double pointed toothing



No 46 | 24 Teeth/inch; 20 x 0,45 mm | double pointed toothing



No 47 | 24 Teeth/inch; 15 x 0,45 mm | double pointed toothing



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

TB2 + TB2t

Toothed band knives, ground on both sides



No 37 | 10 Teeth/inch; 15 x 0,45 mm | double angle toothing



No 43 | 14 Teeth/inch; 15 x 0,45 mm | double angle toothing



K18 | 12 Teeth/inch; 6-20 x 0,45 mm oder 8 x 0,60 mm | contour tooth

TB1-Pro

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



| | | |
|-------|--|------------------|
| No 10 | 10 Teeth/inch; 15 x 0,45 mm | pointed toothing |
| No 12 | 17 Teeth/inch; 6 x 0,45 mm | pointed toothing |
| No 13 | 25 Teeth/inch; 6 x 0,45 mm | pointed toothing |
| No 14 | 25 Teeth/inch; 10 x 0,45 mm | pointed toothing |
| No 30 | 10 Teeth/inch; 10 x 0,45 mm | pointed toothing |
| No 31 | 10 Teeth/inch; 20 x 0,60 mm | pointed toothing |
| No 34 | 10 Teeth/inch; 20 x 0,45 mm | pointed toothing |
| No 40 | 14 Teeth/inch; 20 x 0,45 mm | pointed toothing |
| No 41 | 10 Teeth/inch; 30 x 0,45 mm | pointed toothing |
| No 52 | 14 Teeth/inch; 15 x 0,45 mm | pointed toothing |
| K18 | 12 Teeth/inch; 6-20 x 0,45 mm or 8 x 0,60 mm | contour tooth |

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 toothing |
| No 28 | 10 Teeth/inch; 10 x 0,45 mm | double pointed toothing |
| No 29 | 18 Teeth/inch; 10 x 0,45 mm | double pointed toothing |
| No 32 | 18 Teeth/inch; 10 x 0,45 mm | double pointed toothing |
| No 42 | 14 Teeth/inch; 15 x 0,45 mm | double pointed toothing |
| No 44 | 10 Teeth/inch; 15 x 0,45 mm | double pointed toothing |
| No 45 | 10 Teeth/inch; 20 x 0,45 mm | double pointed toothing |
| No 46 | 24 Teeth/inch; 20 x 0,45 mm | double pointed toothing |
| No 47 | 24 Teeth/inch; 15 x 0,45 mm | double pointed toothing |
| K18 | 12 Teeth/inch; 6-20 x 0,45 mm or 8 x 0,60 mm | contour tooth |

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



No 50 14 Teeth/inch; 16 x 0,50 mm angle tothing / set



No 53 2/3 Teeth/inch; 27 x 0,90 mm angle tothing / not set, carbide tooth

BS2

Band saws, toothed on both side

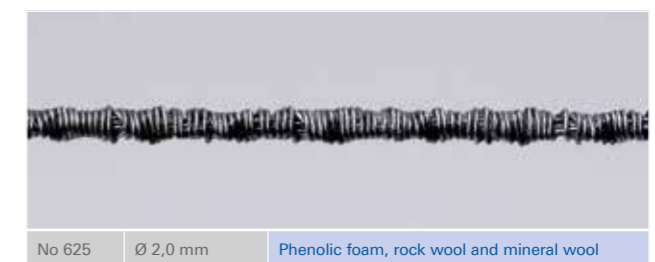
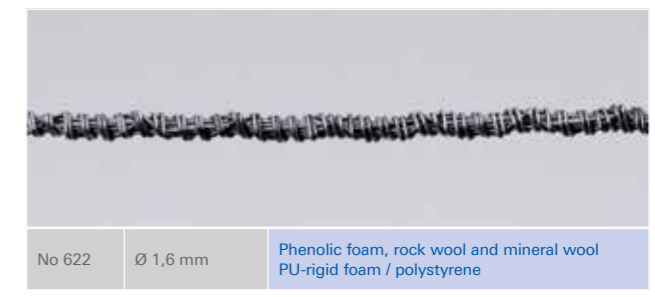
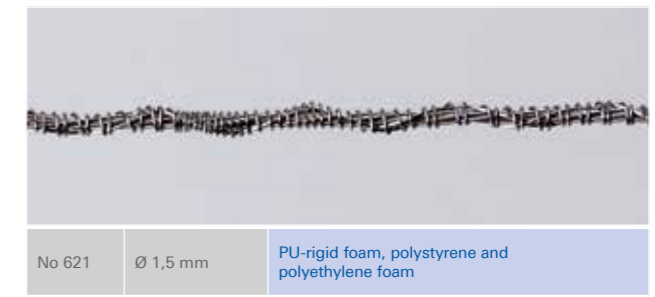
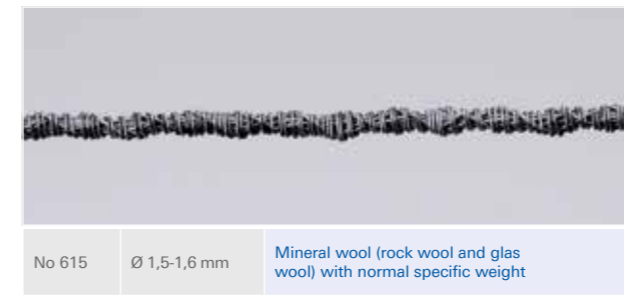
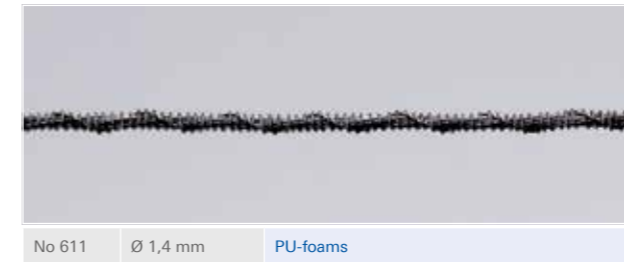
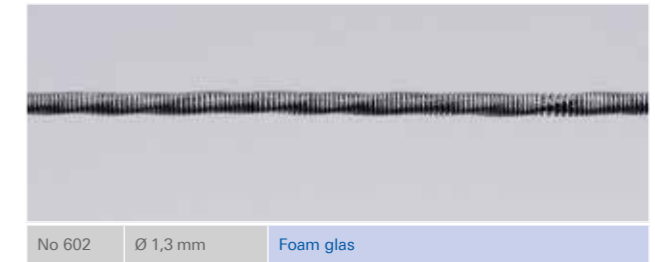
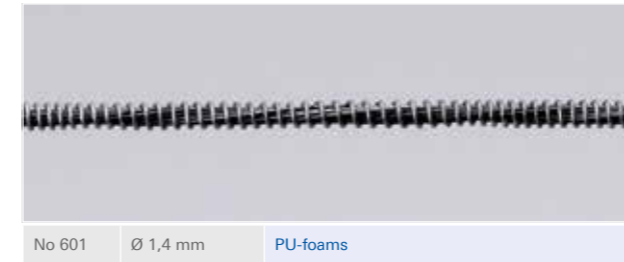
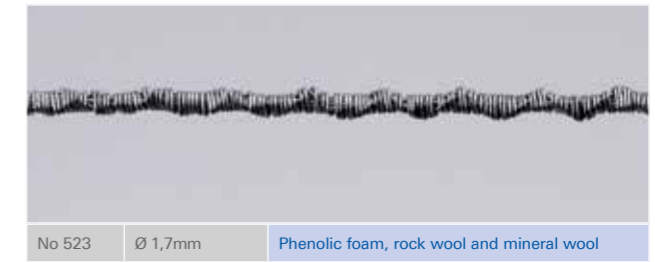
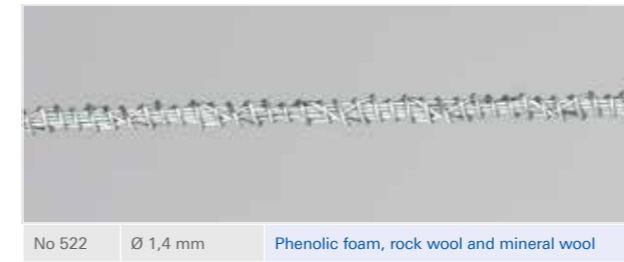
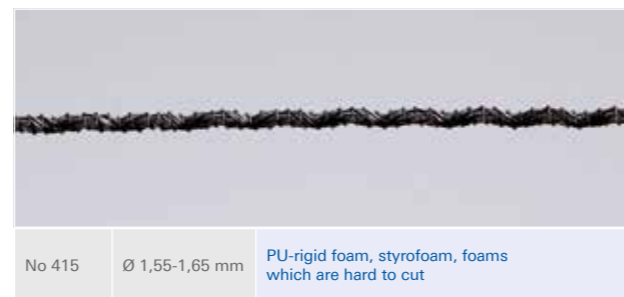
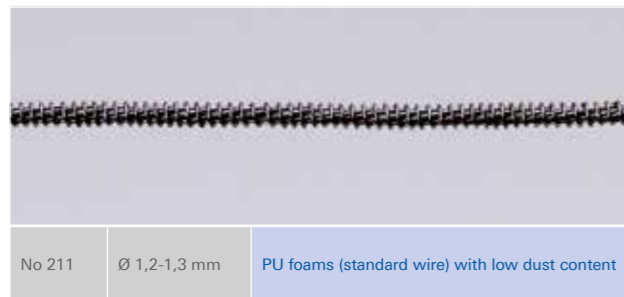
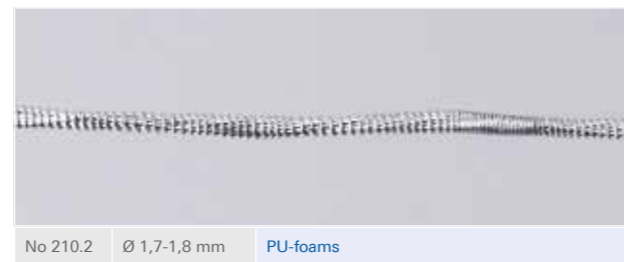
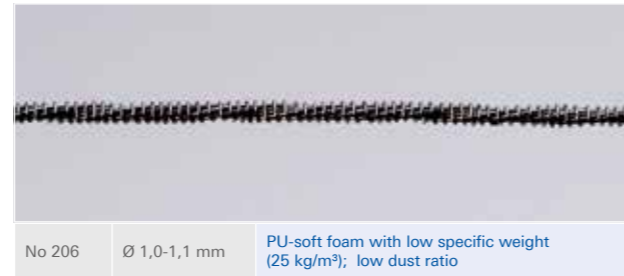
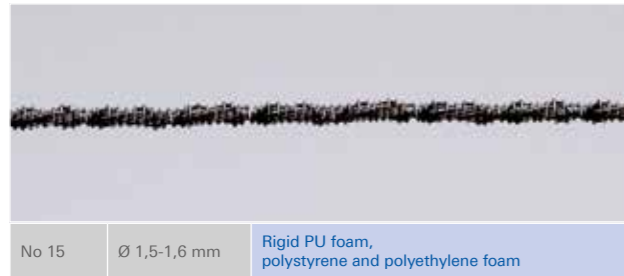


No 21 8 Teeth/inch; 15 x 0,45 mm Double-angle tothing / set

CUTTING WIRES

CW

Cutting wires



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

| | High Quality (HQ) | Standard Quality (SQ) |
|--------------------------|--|---|
| Quality of material | C100 | C75 |
| Hardness / HRC | 51-54 | 46-49 |
| Material surface | regrindable | regrindable |
| Dimension | 60 x 0,60 mm, 80 x 0,60 mm 80 x 1,00 mm, 85 x 1,00 mm | 50 x 0,6 mm, 50 x 0,60 (1,00) mm 80 x 0,60 (1,00) mm, 85 x 1,00 mm |
| Weld tolerance | 0,02 mm | 0,04 mm |
| Knife back tolerance | 0,10 mm (max.) | 0,10 - 0,20 mm |
| Knife edge tolerance | 0,1 mm (max.) | 0,10 - 0,20 mm |
| Test certificate | Yes | No |
| Protection of knife edge | Yes | at request |
| Area of application | Automotive industry: e.g. for the car headliners | standard foam |

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
- Individual packaging on request against surcharge possible

When placing an order of a large quantity of the same type and length band knife we will grant you the following discounts:

from 20 pieces
5% discount

from 30 pieces
10% discount

from 40 pieces
13% discount

from 50 pieces
15% discount

We would appreciate to receive your blanket order.





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