

# Primalloy Saws

### Cut Metal Not Your Budget

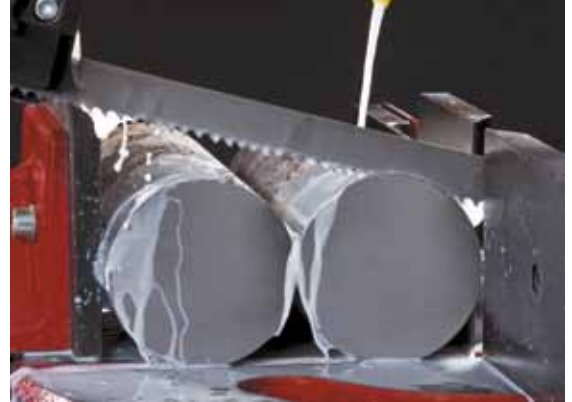
The Primalloy Saw is designed for heavy-duty cutting applications. The cutting performance of the high-speed steel is greatly increased through alloying with cobalt and vanadium. These alloying elements substantially increase the heat resistance as well as the wear resistance. The Primalloy Saw provides superiority in overall wear and operating life without the expense of carbide-tip solutions.

With Primalloy edge and Extended Life Treatment (EXT) functionality, the Primalloy Band Saw minimizes blade replacement thus cutting costs resulting in steadier production.

The Starrett Primalloy Band Saw product line applies a proprietary Extended Life Treatment (EXT) to its alloy steel backing material. This process, in addition to controlled blast peening, enhances the fatigue life of the blade. The EXT applied during the peening operation adds increased residual stress into the surface of the blade. Higher stress levels aid in the reduction of fatigue cracks that originate along microscopic grain boundaries. The benefits of extended life treatment are proven with X-Ray Diffraction (XRD) and extensive mechanical fatigue tests. This process will soon be applied to most Starrett bimetal and carbide tip product lines.

### Features

- Longer operating blade life due to tooth tip chemistry
- Increased cutting accuracy
- Improved efficiency over the all-purpose M42 HSS Edge Band Saw
- Cost-effective cutting solution for steels with low machinability
- Three times the Vanadium content dramatically increases wear resistance over competitive products
- Ground teeth are effective for the hardest steels and alloys of all dimensions
- 10% cobalt tool steel cutting edge provides excellent heat resistance
- Starrett EXT applied to alloy steel backing material ensures maximum fatigue life
- Primalloy Edge provides higher edge hardness, up to HRC 69, over competitive M42 products
- Faster cutting rates due to aggressive 12 degree tooth form
- Primalloy will be beneficial on machines not rigid enough for carbide tip product



Blade Width x Thickness		Blade Pitch with Material Numbers			
Inch	mm	1-1/2/P	1.4-2/P	2-3/P	3-4/P
1 x .035"	25 x 0.90mm				99800
1-1/4 x .042"	32 x 1.10mm			99801	99802
1-1/2 x .050"	38 x 1.30mm		99803	99804	99805
2 x .063"	50 x 1.60mm		99806	99807	99808
2-5/8 x .063"	67 x 1.60mm	99809	99810	99811	



1" to 2-5/8" sizes available in 150' (45m) coils.

