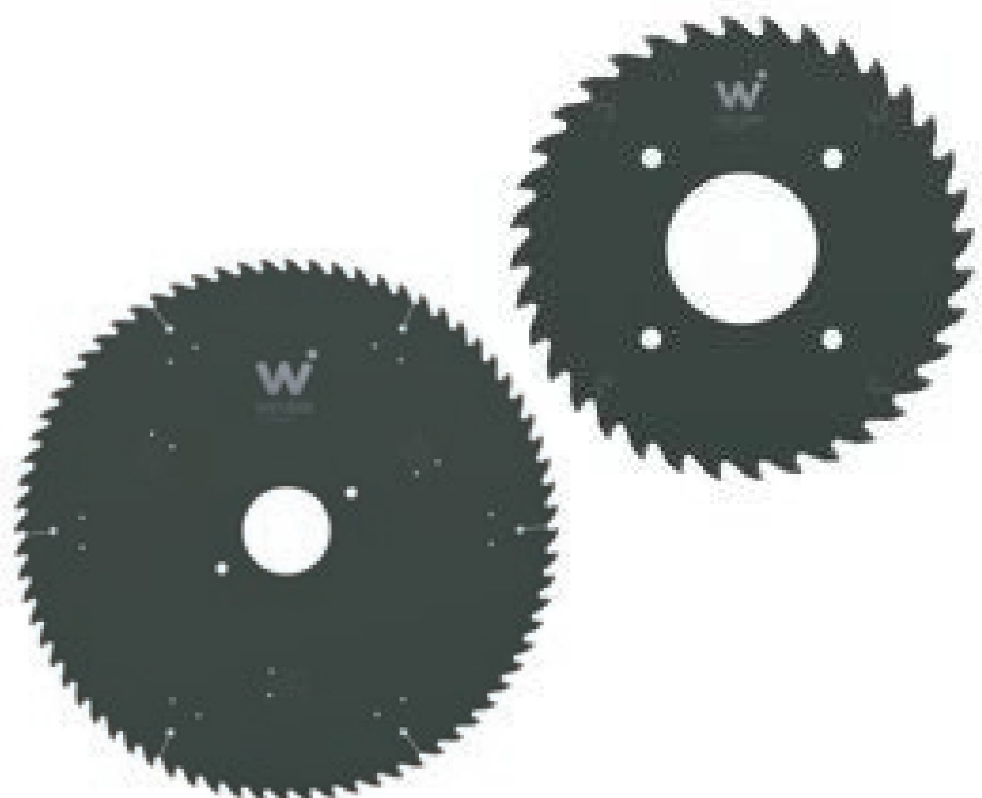




Catalogue

Saw blades  
for  **BIESSE**  
Selco panel  
sizing centres

---



# Wirutex and BIESSE a consolidated partnership

The collaboration between **Wirutex** and **Biesse** began in the 1990s with the first supplies of tools for installation on wood-working machines.

It's a collaboration that has produced not only dialogue and understanding over the years, but also the development of tailor-made tools for **Biesse** machines.



Do you want to see the range of Wirutex tools purposely designed for Biesse machines?

Visit our website  
[wirutex.com](http://wirutex.com)

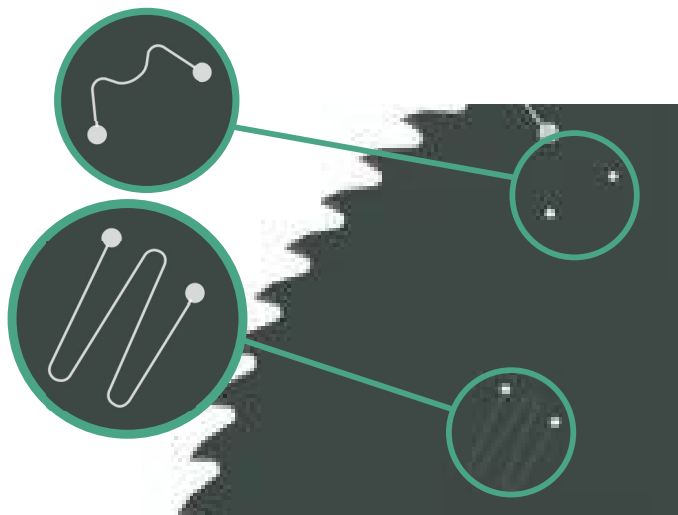
**Wirutex** has created a complete range of saw blades that uses the innovative technological solutions of the **Selco** panel sizing centres.



Automatic scoring saw blade alignment system of Selco panel sizing centres.

## Specific technologies

The Wirutex polycrystalline diamond saw blades are designed with specific technologies that don't interfere with the automatic scoring saw blade alignment system of the Selco panel sizing centres.



## Less vibration

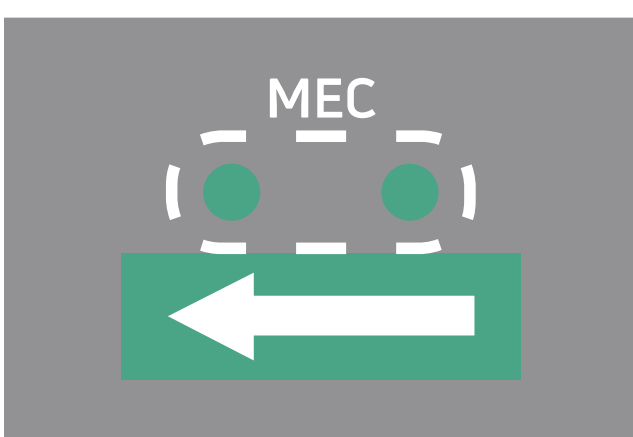
The noise reduction slots created with laser technology reduces the vibrations. The quality and duration of the cut are enhanced, reducing the noise produced whilst machining.



## Machining operations and materials

Wirutex saw blades are ideal for sectioning individual panels or books of panels in MDF, chipboard or melamine chipboard.

Upon request, we can produce special saw blades for machining compound materials like carbon, resin, Corian, HPL and stratified materials.



## Mechanical feed

All the tools in this catalogue are designed for machining operations with mechanical feed.

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# Summary

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Main saw blade (DP - HW) p. 6

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Scoring saw blade (DP - HW) p. 17

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## List of symbols and abbreviations

**DP**

POLYCRYSTALLINE DIAMOND

**HW**

TUNGSTEN CARBIDE

**D**

DIAMETER

**B**

CUTTING THICKNESS

**B-B1**

CUTTING THICKNESS

**b**

SAW BLADE BODY THICKNESS

**d**

CENTRAL BORE

**Z**

NUMBER OF TEETH

**FT**

PIN HOLES

**$\alpha$**

HOOK ANGLE

**$\beta$**

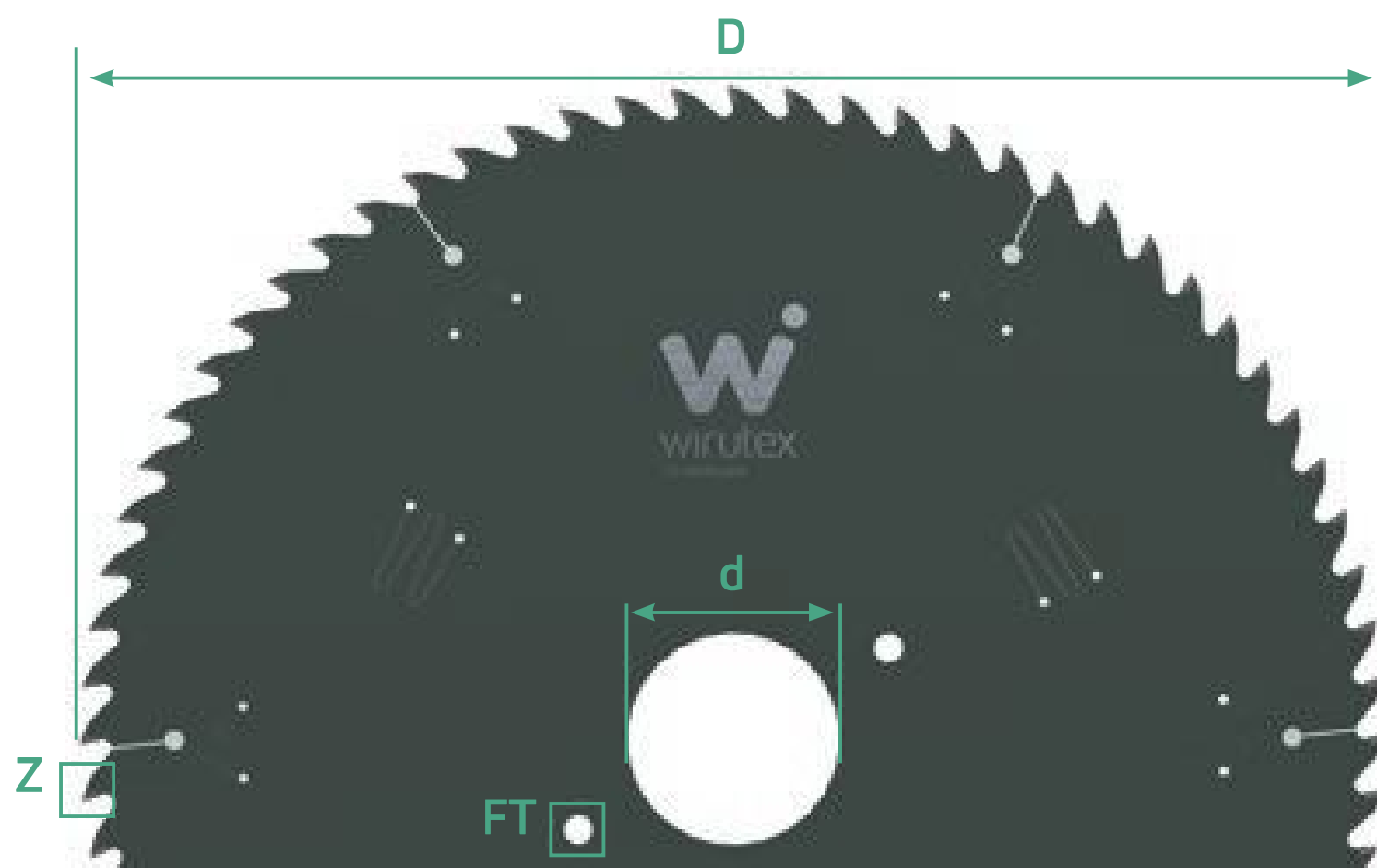
BACK RELIEF ANGLE

**H**






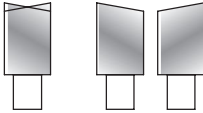

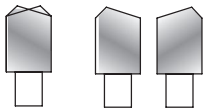

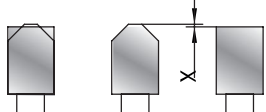

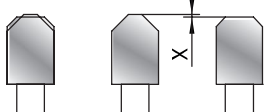

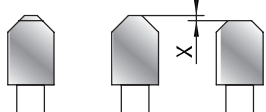

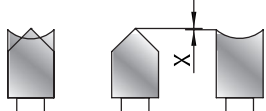
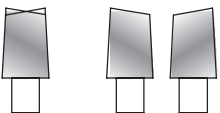
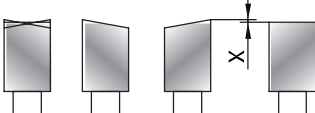

HEIGHT OF TIP BEFORE SHARPENING

**Id-No.**

PRODUCT CODE



# Type of teeth applied to the saw blades

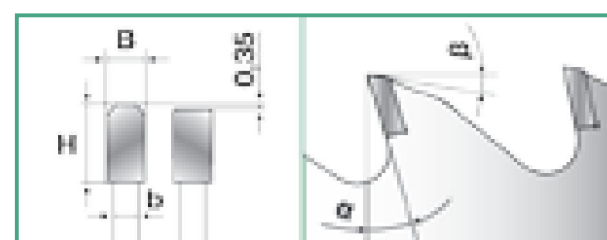
	<b>FZ</b> Flat		<b>HZ/FA</b> Hollow-ground with two-sided chamfer
	<b>FZ/FA</b> Flat with chamfers on both sides		<b>DZ</b> Inverted-V
	<b>ES-L</b> Top bevel, left		<b>WZ</b> Alternate top bevel
	<b>ES-R</b> Top bevel, right		<b>WZ/FA</b> Alternate top bevel with chamfer
	<b>ES-R/FA</b> Top bevel, right with chamfer		<b>TR/FZ</b> Triple chip - flat
	<b>ES-L/FA</b> Top bevel, left with chamfer		<b>TR/FZFA</b> Triple chip - flat with chamfer
	<b>TR</b> Triple chip		<b>TR/TR</b> Triple chip - triple chip
	<b>KON/FZ</b> Conical flat		<b>HZ/DZ</b> Inverted-V + hollow-ground
	<b>KON/WZ</b> Conical alternate bevel		<b>WZ/FZ</b> Alternate top bevel + flat
	<b>HZ</b> Hollow-ground		

## Main saw blade

## MACHINE MODEL

EB70

EB70L



## DESIGN

Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	300	4.4	3.2	65	60	16°	12°	2/9/110	10	CL0037
DP	300	4.4	3.0	65	60	12°	14°	2/9/110	4	L00803
DP	300	4.4	3.0	65	60	12°	13°	2/9/110	6	L00503

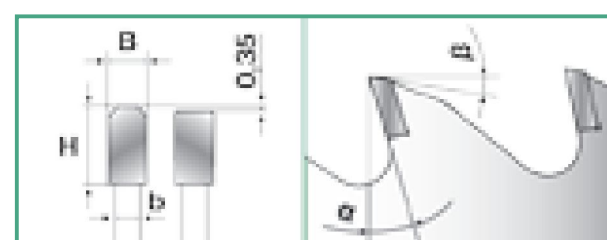
## Main saw blade

## MACHINE MODEL

EB70 (kit80) SEKTOR 430

EB80 SEKTOR 450

EB75 SK 450



## DESIGN

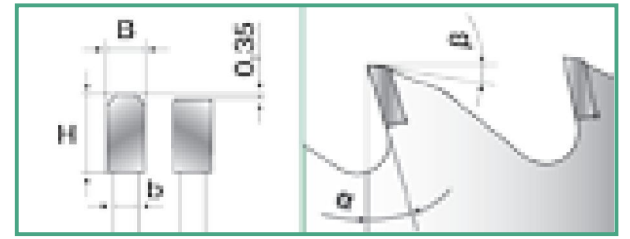
Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	320	4.4	3.2	65	60	16°	12°	2/9/110	10	C03737
DP	320	4.4	3.0	65	60	10°	14°	2/9/110	4	L00820
DP	320	4.4	3.0	65	60	10°	13°	2/9/110	6	L00520

## Main saw blade

### MACHINE MODEL

EB90



### DESIGN

Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	355	4.4	3.2	80	72	16°	12°	2/9/130+4/19/120	10	CL0058
DP	355	4.4	3.0	80	72	12°	13°	2/9/130+4/19/120	4	L00844
DP	355	4.4	3.0	80	72	12°	14°	2/9/130+4/19/120	6	L00544

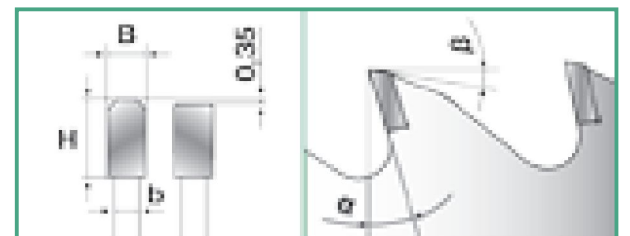
## Main saw blade

### MACHINE MODEL

EB95

SEKTOR 470

SK 470



### DESIGN

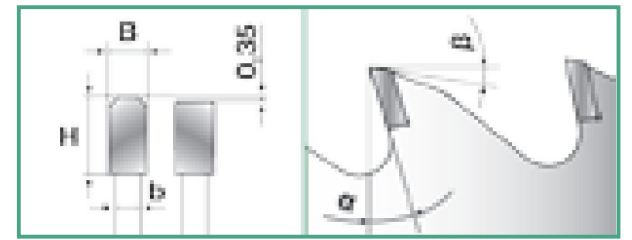
Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	355	4.4	3.2	65	72	16°	12°	2/9/110	10	C04165
DP	355	4.4	3.0	65	72	12°	13°	2/9/110	4	L00841
DP	355	4.4	3.0	65	72	12°	13°	2/9/110	6	L00541

## Main saw blade

### MACHINE MODEL

EB100



### DESIGN

Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	360	4.4	3.2	65	72	16°	12°	2/9/110	10	CL0060
DP	360	4.4	3.0	65	72	12°	14°	2/9/110	4	L00846
DP	360	4.4	3.0	65	72	12°	13°	2/9/110	6	L00546

## Main saw blade

### MACHINE MODEL

WN-WNA 610

WN-WNA 610 (PFS)



### DESIGN

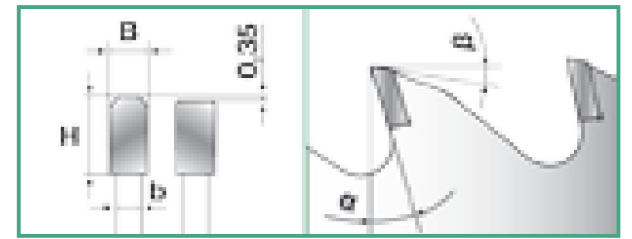
Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	380	4.4	3.2	65	72	16°	12°	2/9/110	10	D03230
DP	380	4.4	3.0	65	72	12°	14°	2/9/110	4	L00855
DP	380	4.4	3.0	65	72	12°	13°	2/9/110	6	L00555



## Main saw blade

MACHINE MODEL	
EB108	WN 200 (PFS)
EB110	WN 512 (PFS)
EB120	WN 600-132 (PFS)
EB120 (PFS)	WN 600-145 (PFS)
WN 125 (PFS)	



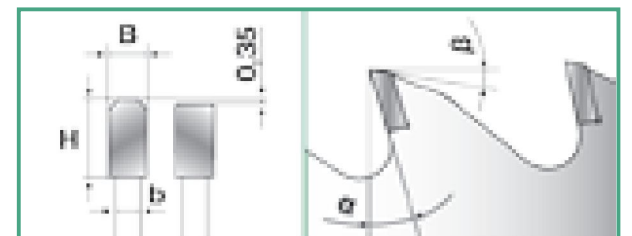
### DESIGN

Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	400	4.4	3.2	80	72	16°	12°	2/9/130+4/19/120	10	C01840
DP	400	4.4	3.0	80	72	10°	13°	2/9/130+4/19/120	4	L00871
DP	400	4.4	3.0	80	72	12°	13°	2/9/130+4/19/120	6	L00571

## Main saw blade

MACHINE MODEL
WN-WNA 630
WN-WNA 630 (PFS)
WN-WNA 650 (PFS)



### DESIGN

Tooth: triple chip-flat with chamfer TR/FZFA

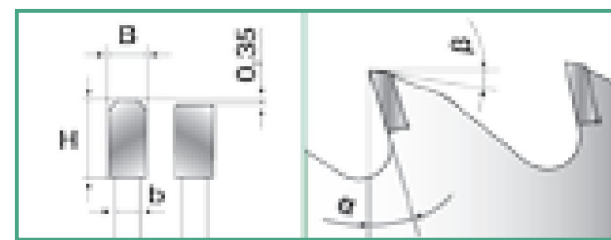
	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	400	4.4	3.2	65	72	16°	12°	2/9/110	10	D03231
DP	400	4.4	3.0	65	72	12°	13°	2/9/110	4	L00868
DP	400	4.4	3.0	65	72	12°	14°	2/9/110	6	L00568

## Main saw blade

### MACHINE MODEL

WNA 600-162 (PFS)

WN 125



### DESIGN

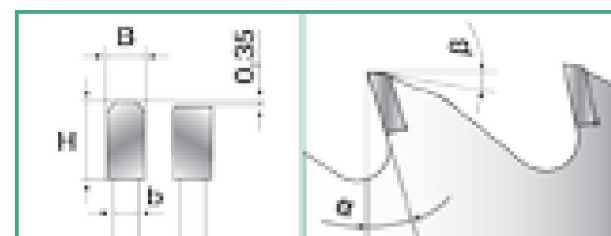
Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	430	4.4	3.2	80	72	16°	12°	2/9/130+4/19/120	10	CL0092
DP	430	4.4	3.2	80	72	12°	14°	2/9/130+4/19/120	4	L00883
DP	430	4.4	3.2	80	72	12°	14°	2/9/130+4/19/120	6	L00583

## Main saw blade

### MACHINE MODEL

WN-WNA 650



### DESIGN

Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	430	4.4	3.2	65	72	16°	12°	2/9/110	10	D03232
DP	430	4.4	3.2	65	72	12°	13°	2/9/110	4	L00881
DP	430	4.4	3.2	65	72	12°	13°	2/9/110	6	L00581

## Main saw blade

### MACHINE MODEL

WN 710

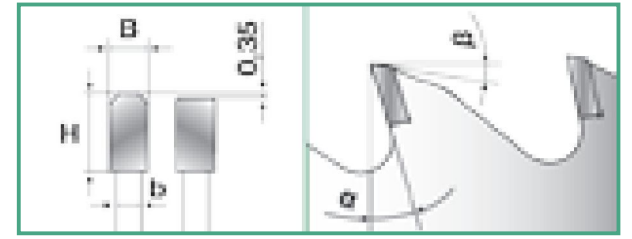
WN 710 (PFS)

WN-WNA 730 (PFS)

WN-WNA 750 (PFS)

WN-WNA 830 (PFS)

WN-WNA 850 (PFS)



### DESIGN

Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	430	4.8	3.5	70	72	16°	12°	4/11/130	10	C03959
DP	430	4.8	3.5	70	72	10°	13°	4/11/130	4	L00887
DP	430	4.8	3.5	70	72	10°	13°	4/11/130	6	L00587

## Main saw blade

### MACHINE MODEL

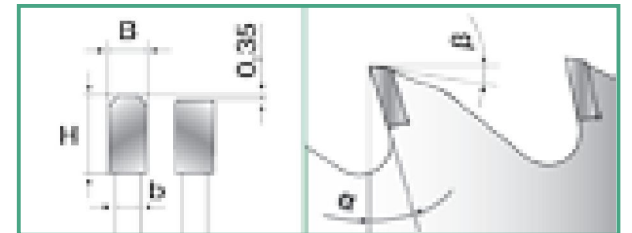
With PFS function  
and automated saw blade  
change.

WN-WNA 730

WN-WNA 750

WN-WNA 830

WN-WNA 850



### DESIGN

Tooth: triple chip-flat with chamfer TR/FZFA

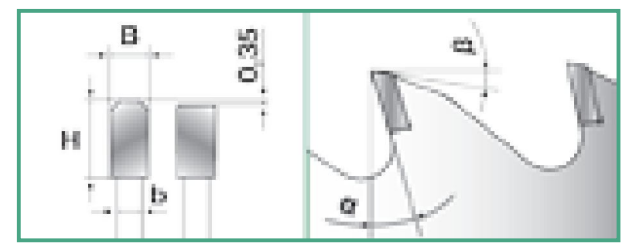
	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	430	4.8	3.5	75	72	16°	12°	4/6.5/130+4/11/130	10	C05396
DP	430	4.8	3.5	75	72	10°	13°	4/6.5/130+4/11/130	4	L00888
DP	430	4.8	3.5	75	72	10°	13°	4/6.5/130+4/11/130	6	L00588

## Main saw blade

### MACHINE MODEL

WNA 200

WN 600-132



### DESIGN

Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	450	4.8	3.5	80	72	16°	12°	2/9/130+4/19/120	10	CL0110
DP	450	4.8	3.5	80	72	10°	13°	2/9/130+4/19/120	4	L00891
DP	450	4.8	3.5	80	72	10°	13°	2/9/130+4/19/120	6	L00591

## Main saw blade

### MACHINE MODEL

WN-WNA 730



### DESIGN

Tooth: triple chip-flat with chamfer TR/FZFA

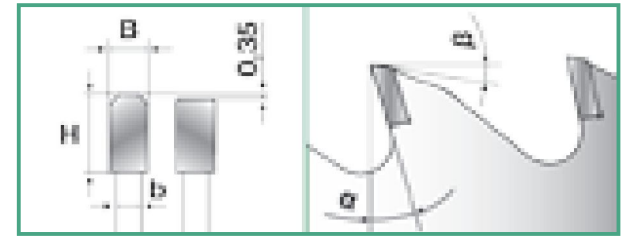
	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	470	4.8	3.5	70	72	16°	12°	4/11/130	10	C04313
DP	470	4.8	3.5	70	72	12°	14°	4/11/130	4	L00918
DP	470	4.8	3.5	70	72	12°	13°	4/11/130	6	L00618

## Main saw blade

### MACHINE MODEL

With automated saw blade change.

WN-WNA 730



### DESIGN

Tooth: triple chip-flat with chamfer TR/FZFA

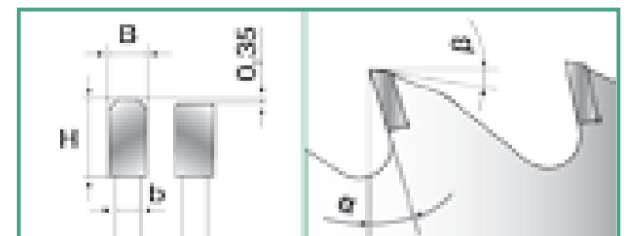
	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	470	4.8	3.5	75	72	16°	12°	4/6.5/130+4/11/130	10	C05395
DP	470	4.8	3.5	75	72	10°	13°	4/6.5/130+4/11/130	4	L00920
DP	470	4.8	3.5	75	72	10°	13°	4/6.5/130+4/11/130	6	L00620

## Main saw blade

### MACHINE MODEL

WNA 512

WN 600-145



### DESIGN

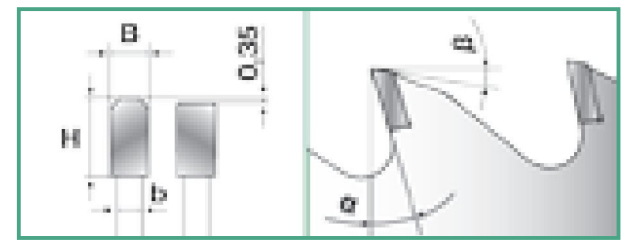
Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	480	4.8	3.5	80	72	16°	12°	2/9/130+4/19/120	10	CL0118
DP	480	4.8	3.5	80	72	10°	12°	2/9/130+4/19/120	4	L00927
DP	480	4.8	3.5	80	72	10°	12°	2/9/130+4/19/120	6	L00627

## Main saw blade

### MACHINE MODEL

WNA 600-162



### DESIGN

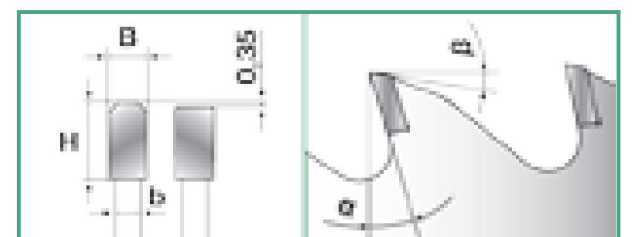
Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	510	4.8	3.5	80	72	16°	12°	2/9/130+4/19/120	10	C05394
DP	510	4.8	3.5	80	72	10°	12°	2/9/130+4/19/120	4	L00938
DP	510	4.8	3.5	80	72	10°	12°	2/9/130+4/19/120	6	L00638

## Main saw blade

### MACHINE MODEL

WN-WNA 750



### DESIGN

Tooth: triple chip-flat with chamfer TR/FZFA

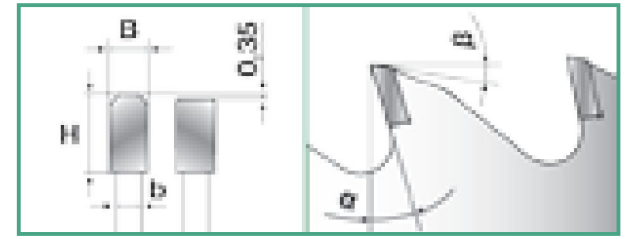
	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	520	4.8	3.5	70	72	16°	12°	4/11/130	10	C04163
DP	520	4.8	3.5	70	72	10°	12°	4/11/130	4	L00949
DP	520	4.8	3.5	70	72	10°	12°	4/11/130	6	L00649

## Main saw blade

### MACHINE MODEL

With automated saw blade change.

WN-WNA 750



### DESIGN

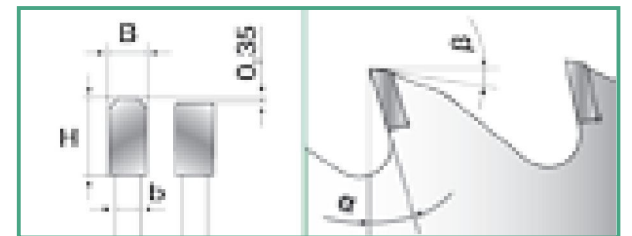
Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	520	4.8	3.5	75	72	16°	12°	4/6.5/130+4/11/130	10	C05397
DP	520	4.8	3.5	75	72	10°	12°	4/6.5/130+4/11/130	4	L00950
DP	520	4.8	3.5	75	72	10°	12°	4/6.5/130+4/11/130	6	L00650

## Main saw blade

### MACHINE MODEL

WN-WNA 830



### DESIGN

Tooth: triple chip-flat with chamfer TR/FZFA

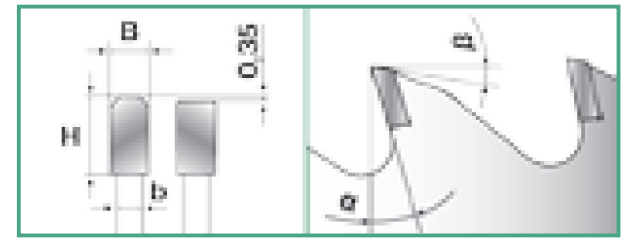
	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	570	5.8	4.0	70	60	16°	12°	4/11/130	10	C05402
DP	570	5.8	4.5	70	60	10°	12°	4/11/130	4	L01600
DP	570	5.8	4.5	70	60	10°	12°	4/11/130	6	L01601

## Main saw blade

### MACHINE MODEL

With automated saw blade change.

WN-WNA 850



### DESIGN

Tooth: triple chip-flat with chamfer TR/FZFA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	600	5.8	4.0	75	60	16°	12°	4/6.5/130+4/11/130	10	C05400
DP	600	5.8	4.5	75	60	10°	12°	4/6.5/130+4/11/130	4	L01602
DP	600	5.8	4.5	75	60	10°	12°	4/6.5/130+4/11/130	6	L01603



## Scoring saw blade

### MACHINE MODEL

Without PFS function

EB70	EB100	SEKTOR 470
EB70L	EB108	SK 450
EB75	EB110	SK 470
EB80	EB120	WN 125
EB90	SEKTOR 430	WN 610
EB95	SEKTOR 450	WN 630
		WN 650



### DESIGN

Tooth: conical flat KON/FZ

	D (mm)	B-B1 (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	200	4.4 - 5.6	3.2	65	36	10°	12°	2/9/110+2/9/100	10	C03213
DP	200	4.4 - 5.0	3.2	65	36	8°	14°	2/9/110+2/9/100	4	L01254
DP	200	4.4 - 5.0	3.2	65	36	8°	13°	2/9/110+2/9/100	6	L01054

## Scoring saw blade

### MACHINE MODEL

Without PFS function

WN 200	WN-WNA 710
WN 512	WN-WNA 730
WN 600-132	WN-WNA 750
WN 600-145	
WNA 600-162	



### DESIGN

Tooth: conical flat KON/FZ

	D (mm)	B-B1 (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	200	4.8 - 5.6	3.5	65	36	10°	12°	2/9/110	10	C02829
DP	200	4.8 - 5.6	3.2	65	30	10°	14°	2/9/110	4	L01264
DP	200	4.8 - 5.6	3.2	65	30	10°	13°	2/9/110	6	L01064

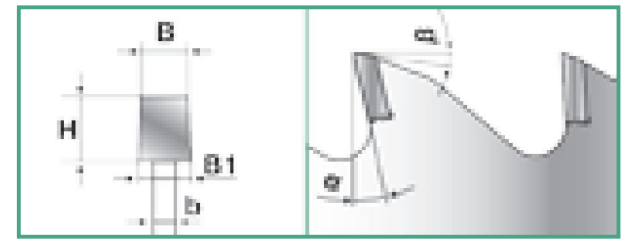
## Scoring saw blade

### MACHINE MODEL

Without PFS function

WN-WNA 830

WN-WNA 850



### DESIGN

Tooth: conical flat KON/FZ

	D (mm)	B-B1 (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	200	5.7 - 6.9	4.0	65	36	10°	12°	2/9/110	10	C05401
DP	200	5.7 - 6.3	4.5	65	36	10°	14°	2/9/110	4	L01604
DP	200	5.7 - 6.3	4.5	65	36	10°	14°	2/9/110	6	L01605

## Scoring saw blade

### MACHINE MODEL

With PFS function - normal cuts

EB70 SEKTOR 430

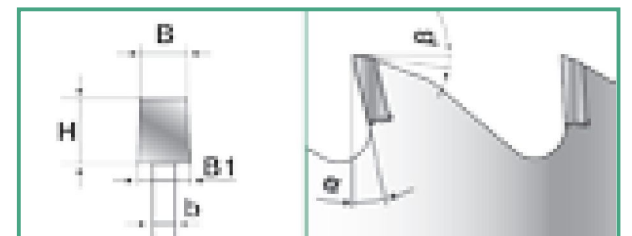
EB70L SEKTOR 450

EB75 SEKTOR 470

EB80 SK 450

EB95 SK 470

EB100



### DESIGN

Tooth: conical flat KON/FZ

	D (mm)	B-B1 (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	300	4.4 - 5.6	3.2	65	48	10°	12°	2/9/100	10	D03234
DP	300	4.4 - 5.0	3.2	65	48	10°	14°	2/9/100	4	L01606
DP	300	4.4 - 5.0	3.2	65	48	10°	14°	2/9/100	6	L01607

## Scoring saw blade

### MACHINE MODEL

With PFS function - post-forming cuts

EB70	SEKTOR 430
EB70L	SEKTOR 450
EB75	SEKTOR 470
EB80	SK 450
EB95	SK 470
EB100	



### DESIGN

Tooth: alternate top bevel with chamfer WZ/FA

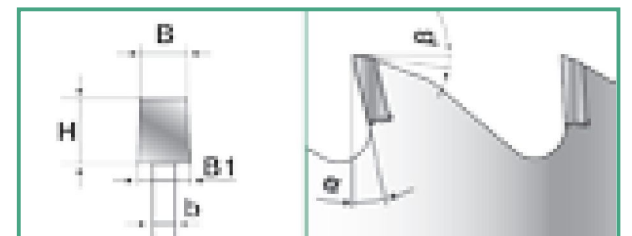
	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	300	4.6	3.2	65	72	10°	12°	2/9/100	10	D03235
DP	300	4.6	3.2	65	72	10°	14°	2/9/100	6	L01609

## Scoring saw blade

### MACHINE MODEL

With PFS function - normal cuts

EB90	WN-WNA 610
EB108	WN-WNA 630
EB110	WN-WNA 650
EB120	
WN 125	



### DESIGN

Tooth: conical flat KON/FZ

	D (mm)	B-B1 (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	300	4.4-5.6	3.2	65	48	10°	12°	2/9/110	10	D03236
DP	300	4.4-5.0	3.2	65	48	8°	14°	2/9/110	4	L01610
DP	300	4.4-5.0	3.2	65	48	8°	14°	2/9/110	6	L01611

## Scoring saw blade

### MACHINE MODEL

With PFS function - post-forming cuts

EB90	WN 512
EB108	WN 600-132
EB110	WN 600-145
EB120	WN 600-162
WN 125	
WN 200	



### DESIGN

Tooth: alternate top bevel with chamfer WZ/FA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	300	4.55	3.2	65	72	10°	12°	2/9/110	10	C02754
DP	300	4.55	3.2	65	72	10°	13°	2/9/110	4	L01612
DP	300	4.55	3.2	65	72	10°	13°	2/9/110	6	L01613

## Scoring saw blade

### MACHINE MODEL

With PFS function - normal cuts

WN-WNA 710
WN-WNA 730
WN-WNA 750
WN-WNA 830
WN-WNA 850



### DESIGN

Tooth: conical flat KON/FZ

	D (mm)	B-B1 (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	300	4.8 - 5.6	3.5	65	48	10°	12°	2/9/110	10	D02696
DP	300	4.8 - 5.6	3.5	65	48	8°	14°	2/9/110	4	L01614
DP	300	4.8 - 5.6	3.5	65	48	8°	14°	2/9/110	6	L01615

## Scoring saw blade

### MACHINE MODEL

With PFS function - post-forming cuts

WN-WNA 610

WN-WNA 630

WN-WNA 650



### DESIGN

Tooth: alternate top bevel with chamfer WZ/FA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	350	4.6	3.2	65	72	10°	12°	2/9/110	10	D03237
DP	350	4.6	3.2	65	72	10°	13°	2/9/110	4	L01616
DP	350	4.6	3.2	65	72	10°	13°	2/9/110	6	L01617

## Scoring saw blade

### MACHINE MODEL

With PFS function - post-forming cuts

WN-WNA 710

WN-WNA 730

WN-WNA 750

WN-WNA 830

WN-WNA 850



### DESIGN

Tooth: alternate top bevel with chamfer WZ/FA

	D (mm)	B (mm)	b (mm)	d (mm)	Z	$\alpha$	$\beta$	NL	H (mm)	Id-No.
HW	350	5	3.5	65	72	10°	12°	2/9/110	10	D02695
DP	350	5	3.5	65	72	10°	13°	2/9/110	4	L01618
DP	350	5	3.5	65	72	10°	13°	2/9/110	6	L01619

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**Wirutex S.r.l.**

Via Mario Ricci, 28  
61122 Pesaro (PU) Italy  
Tel. +39 0721 204355  
Fax +39 0721 204359  
contact@wirutex.com