LionNord

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LionNord

PRECISION AND STRENGTH

2018

The Company

Bandsaw cutting has evolved into a sophisticated high technology. Bichamp Cutting Technology rises to the challenges, thanks to our highly skilled team, modern and reliable manufacturing facilities, and many years of experience. The combination of experience and specialized technical knowledge ensures high performance bandsaw blades, which are perfectly suited to meet your specific requirements.

Our responsibility for our products performance drives our continuous investment in our facilities, processes and people.

This enables our research and development teams to integrate the best manufacturing and product technology, and for our customers to experience the results in products, which outperform conventional bandsaw blades and bring more value.

Our corporate policy

- Top Quality and Total Customer Satisfaction

Bandsaw Blades Coil Specification:

We can supply welded loops to your specification.

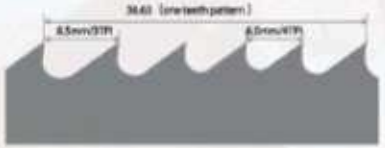
We also provide coil stock in the following lengths:

13mm-100+/-5m per coil	19mm-100+/-5m per coil
27mm-100+/-5m per coil	34mm-85+/-5m per coil
41mm-75+/-5m per coil	54mm-55+/-5m per coil
67mm-55+/-5m per coil	

Bandsaw Blades Size Specification:

13mm×0.65mm	41mm×1.30mm
13mm×0.90mm	54mm×1.60mm
19mm×0.90mm	67mm×1.60mm
27mm×0.90mm	80mm×1.60mm
34mm×1.10mm	

Variable tooth: blades are indicated by two numbers since the tooth pitch and the gullet vary. Distances vary within a group of teeth. Smallest to largest tooth pitch denotes the tooth variable of the saw blade. Variable tooth pitch reduces noise and vibration of cut while also increasing the life of the blade.



*Please visit the following tooth pitch selection chart for further TPI information

Bandsaw Blades Size Specification: TPI Calculation:

Tooth pitch: The number of teeth per inch or per 25.4mm in a saw blade.

$$TPI = \frac{25.4}{\text{The distance between two adjacent teeth (mm)}}$$

There are two kinds of tooth pitch, constant tooth pitch and variable tooth pitch.

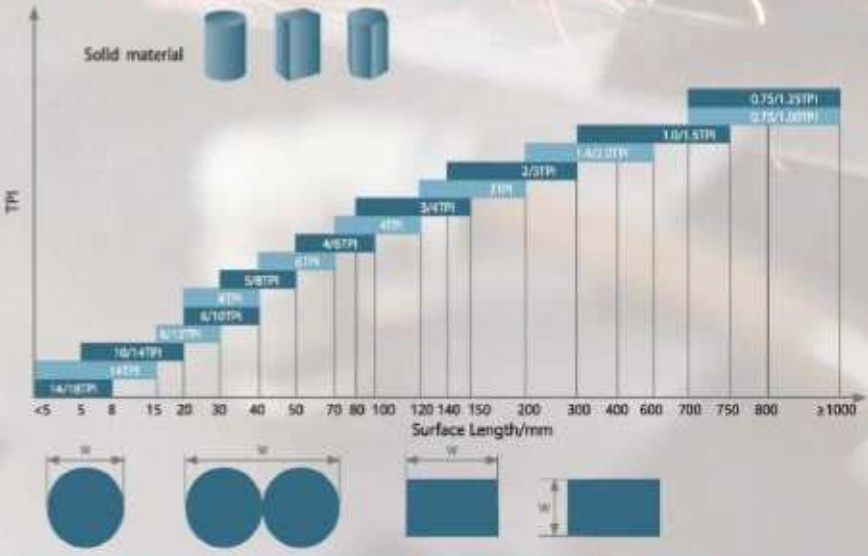
Constant tooth: blades have a tooth distance which is equally spaced. Number of teeth per inch denotes the tooth of the saw blade. If the distance of two adjacent teeth is 6.35mm, the pitch is 4 TPI.

Tooth Pitch Selection Chart For Pipes And Profiles

Thickness S./mm	Diamter/mm													
	15	20	40	60	80	100	120	150	200	300	400	500	00	>700
2	14/18	14/18	14/18	10/14	10/14	10/14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8
3	14/18	14/18	10/14	10/14	10/14	8/12	8/12	8/12	8/12	6/10	6/10	6/10	5/8	5/8
4	14/18	10/14	10/14	10/14	8/12	8/12	6/10	6/10	6/10	5/8	5/8	4/6	4/6	4/6
5	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	4/6
6	10/14	10/14	8/12	8/12	6/10	5/8	5/8	5/8	4/6	4/6	4/6	4/6	4/6	3/4
8		10/14	8/12	6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6	4/6	4/6	3/4
10			6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4	3/4
12			6/10	5/8	5/8	4/6	4/6	4/6	4/6	4/6	3/4	3/4	3/4	3/4
15			6/10	4/6	4/6	4/6	4/6	4/6	3/4	3/4	3/4	3/4	3/4	2/3
20				4/6	4/6	3/4	3/4	3/4	2/3	2/3	2/3	2/3	2/3	2/3
30					3/4	3/4	3/4	3/4	2/3	2/3	2/3	2/3	2/3	2/3
50							2/3	2/3	2/3	2/3	2/3	2/3	2/3	1.4/2.0
75									2/3	2/3	2/3	1.4/2.0	1.4/2.0	1.4/2.0
100											1.4/2.0	1.4/2.0	1.0/1.5	1.0/1.5
150											1.4/2.0	1.4/2.0	1.0/1.5	1.0/1.5
200												1.0/1.5	0.75/1.25 0.75/1.00	0.75/1.25 0.75/1.00
250													0.75/1.25 0.75/1.00	0.75/1.25 0.75/1.00
>300														0.75/1.25 0.75/1.00

For 2 or more materialadd up all wall thickness

Tooth Pitch Selection Chart For Solid Materials



LionNord www.mtsaw.com

MTSAW BIMETAL BANDSAW BLADES SELECTION

PRODUCT SERIES	ALUMINUM /COPPER	BRONZE/ BERILLIUM COPPER	MILD STEELS	STRUCTURAL STEELS	LOW ALLOY STEELS	BEARING STEELS	DIE STEELS	STAINLESS STEELS	TOOL STEELS	TI AND TI-ALLOY	INCONEL/ NICKLE BASED ALLOY
MTSAW-F	■	■	■	■	■	■	■	■	■	■	■
MTSAW-A	■	■	■	■	■	■	■	■	■	■	■
MTSAW-P	■	■	■	■	■	■	■	■	■	■	■
MTSAW-T	■	■	■	■	■	■	■	■	■	■	■
MTSAW-DT	■	■	■	■	■	■	■	■	■	■	■

Recommand:

■ Very suitable ■ Can be used ■ Not recommand

M42 SAW BLADE

MTSAW-F Cost-effective

MTSAW-A Middle Quality

MTSAW-P High Quality

M51 SAW BLADE

MTSAW-T

TCT SAW BLADE

MTSAW-DT

MTSAW-F M42 GENERAL PURPOSE

M42 tooth tips with reliable 4%Cr backing material make this general-purpose blade suitable for cutting various materials.

Applications:

- Carbon steel
- Stainless steel
- Structural steel
- Aluminum/Aluminum alloys
- Alloy steel
- Cast iron
- Tool steel

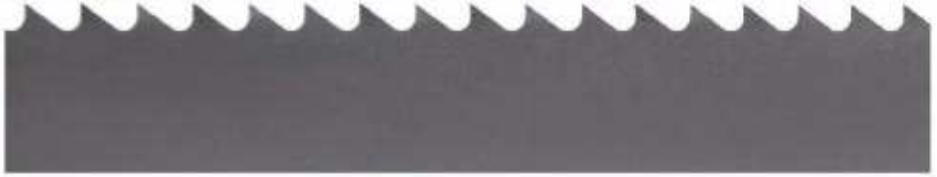
Features:

- Perfect for sawing small to medium profiles and solid materials
- 4%Cr backing material for superior fatigue resistance
- High cutting efficiency with upgrade processing techniques

Width* Thickness	TPI											
	1/1.5	1.4/2	2/3	3/4	4/6	5/8	6	6/10	8/12	10/14	14	14/18
13*0.65							■	■	■	■	■	■
19*0.90					■	■	■	■	■	■	■	■
27*0.90			■	■	■	■	■	■	■	■	■	
34*1.10			■	■	■	■		■	■			
41*1.30	▲	■	■	■	■	■						

▲: Deep tooth gullet tooth profile for better chip removal.

MTSAW-A PM GENERAL PURPOSE



PM Tooth tips combined with our reliable 4%Cr backing material make this general-purpose blade the all-round blade for cutting various materials.

Applications:

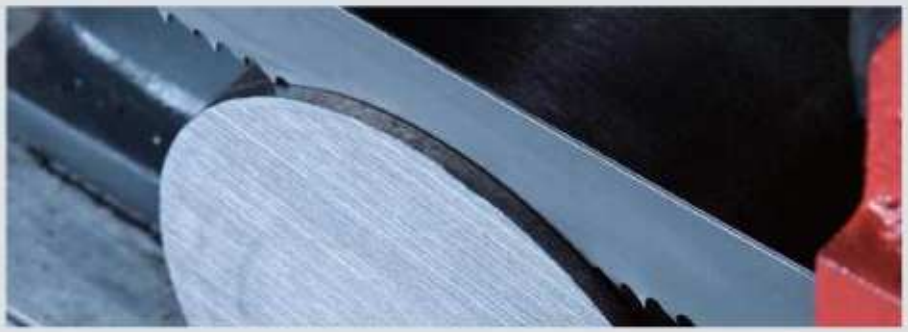
- Aluminum/Copper
- Carbon Steel
- Structural Steel
- Alloy Steel
- Bearing Steel
- Die Steel

Features:

- Deep gullet tooth design for better chip removal.
- Wear resistant PM tooth tips
- 4%Cr backing material for good beam strength.

Width* Thickness	Inches	TPI											
		0.75/1.25	1/1.5	1.4/2	2/3	3/4	4/6	5/8	6	6/10	8/12	10/14	14	14/18
13*0.65	1/2".025								■	■	■	■	■	■
19*0.90	3/4".035						■	■	■	■	■	■	■	■
27*0.90	1".035				■▲	■▲	■	■	■	■	■	■	■	
34*1.10	1-1/4".042				■▲	■▲	■	■		■	■			
41*1.30	1-1/2".052		■	■▲	■▲	■▲	■	■						
54*1.60	2".063	■	■▲	■▲	■▲	■▲	■							
67*1.60	2-5/8".063	■	■▲	■▲	■▲	■▲								
80*1.60	3".063	■	#	#										

▲: Deep tooth gullet tooth profile for better chip removal. "#" : non standard tooth, pre-order required .



MTSAW - P IMPACT RESISTANT

With a Protective tooth geometry, especially developed for cutting profiles and tubes.Bichamp's unique heat treatment process of the backing material results in PROCUT having excellent fatigue life.

Applications:

- Mild Steel
- Structural Steel
- Alloy Steel
- Stainless Steel

Features:

- High wear resistant tooth tips
- Strong beam strength
- High cutting efficiency
- Impact resistant tooth form
- Excellent fatigue life
- Reduced noise

Width*Thickness	Inches	TPI				
		2/3	3/4	4/6	5/7	8/11
13*0.65	1/2".025					■
13*0.90	1/2".035					■
19*0.90	3/4".035				■	■
27*0.90	1".035		■	■	■	
34*1.10	1-1/4".042	■*	■	■		
41*1.30	1-1/2".052	■*	■	■		
54*1.60	2".063	■*	■*			
67*1.60	2-5/8".063	■*	■*			

"*" heavy set style is available for pinching problem solving

MTSAW-T HIGH PERFORMANCE

With PM tooth tips, designed to cut medium to very large work pieces with high precision. This blade is characterized by long blade life and extremely clean cutting surface.

Applications:

- Alloy Steel
- Bearing Steel
- Die Steel
- Tool Steel
- Stainless Steel
- Titanium Alloys

Features:

- Wear resistant PM tooth tips
- Quality backing material for long fatigue life and good beam strength
- Deep gullet tooth design for better chip removal

Width*Thickness	Inches	TPI					
		0.75/1.25	1.0/1.5	1.4/2	2/3	3/4	4/6
27*0.90	1".035				■	■	■
34*1.10	1-1/4".042				■	■	■
41*1.30	1-1/2".052			■	■	■	■
54*1.60	2".063	■#	■	■	■	■	■#
67*1.60	2-5/8".063	■	■	■	■	■#	
80*1.60	3".063	■	■#		■#		

"#" non standard tooth, pre-order required.

DT EXTREME CUTTING RATE

Engineered for sawing difficult to cut and big solid materials. The High-Low tooth design will reduce cutting forces, resulting in extreme smooth and efficient cutting.

Applications:

- Alloy Steel
- Die Steel
- Stainless Steel
- Tool Steel
- Titanium Alloys

Features:

- Reduced cutting force, compared with general-purpose blades
- Higher cutting efficiency
- Better chip removal capability
- High-Low teeth formation

Width*Thickness	Inches	TPI				
		0.75/1.0	1.0/1.5	1.4/2	2/3	3/4
27*0.90	1*.035				■	■
34*1.10	1-1/4*.042				■	■
41*1.30	1-1/2*.052			■	■	■
54*1.60	2*.063		■	■	■	
67*1.60	2-5/8*.063	■	■	■		
80*1.60	3*.063	■	■			

CARBIDE PRODUCT SELECTION

PRODUCT SERIES	HARD WOOD	ALUMINUM COPPER	BRONZE BERILLIUM COPPER	MILD STEELS	STRUCTURAL STEELS	LOW ALLOY STEELS	BEARING STEELS	DIE STEELS	STAINLESS STEELS	TOOL STEELS	TI AND TI-ALLOY	INCONEL NICKLE BASED ALLOY	CASE HARDENED MATERIAL
CB-MP													
CB-PRO													
TCB-MP													
TCB-PROAL													

All the above products are not suitable for thin wall structural materials and for the solid material of which the diameter is less than 50mm.

Recommand:

Very suitable | Can be used | Not recommand

CB-MP SET STYLE FOR MULTIPURPOSE

This carbide tipped bandsaw blade with specially designed multipurpose geometry is developed to cover cutting a wide range of materials. The geometry and set teeth also allows for the blade to be used in less stable machines.

Applications:

- Alloy Steel
- Die Steel
- Abrasive Tool Steel
- Aerospace Alloys
- Non ferrous (Aluminum)
- Bearing Steel
- Stainless Steel
- Titanium Alloys
- Abrasive Graphite

Features:

- High rake angle set style bandsaw blade
- Wear resistant, extra fine grain carbide grade tooth tips
- High toughness and accuracy
- High beam strength due to gullet design

Width*Thickness	Inches	TPI					
		0.75/1.0	1.0/1.25	1.4/2.0	2/3	3	3/4
19*0.90	3/4*.035					■	
27*0.90	1*.035				■	■	■
34*1.10	1-1/4*.042				■	■#	■
41*1.30	1-1/2*.052			■	■		■
54*1.60	2*.063	■#	■	■	■		
67*1.60	2-5/8*.063	■	■	■	■#		
80*1.60	3*.063	■	■#				

"#" non standard tooth, pre-order required

CB-PRO SET STYLE FOR DIFFICULT TO CUT MATERIALS

Carbide tipped bandsaw blade with a Multi-Chip geometry, that is designed for cutting difficult to cut materials providing excellent cutting performance, toughness and wear resistance.

Applications:

- Titanium Alloys
- Stainless Steel
- Inconel
- High Nickel Chrome Alloy
- Aerospace Alloys

Features:

- Precision ground multi chamfer tooth profile
- High cutting efficiency with reduced cutting forces

Width*Thickness	Inches	TPI				
		0.75/1.0	1.0/1.25	1.4/2.0	2/3	3/4
34*1.10	1-1/4*.042				■	■
41*1.30	1-1/2*.052			■	■	■
54*1.60	2*.063		■	■	■#	
67*1.60	2-5/8*.063	■	■	■	■#	
80*1.60	3*.063	■	■			

"#" non standard tooth, pre-order required

TCB-MP NON-SET STYLE FOR MULTIPURPOSE

TCB-MP-Multipurpose is the ultimate all-round carbide tipped bandsaw blade that covers cutting most materials including hard wood.

Applications:

- Hard Wood
- Bearing Steel
- Stainless Steel
- Titanium
- Cast Iron Bronze
- Alloy Steel
- Die Steel
- Tool Steel
- Nickel Based Material
- Aluminum /Aluminum alloys

Features:

- Triple chip tooth design
- Selected backing material for excellent fatigue life
- For general purpose applications

Width*Thickness	Inches	TPI					
		0.75/1.0	1/1.5	1.4/2	2/3	3	3/4
19*0.90	3/4*.035					■ #	
27*0.90	1*.035				■	■	■
34*1.10	1-1/4*.042			■	■	■	■ #
41*1.30	1-1/2*.052			■	■	■	■ #
54*1.60	2*.063		■	■			
67*1.60	2-5/8*.063	■	■				
80*1.60	3*.063	■					

"#" non standard tooth, pre-order required

TCB-PRO AL

NON-SET STYLE FOR ALUMINUM HIGH SPEED CUTTING

This carbide tipped bandsaw blade with multi chip tooth geometry is specially designed for cutting Aluminum.

Applications:

- Aluminum and non ferrous materials
- Aluminum Foundries

Features:

- High cutting performance on non-ferrous metals.
- Multi-chips tooth design for efficient chip removal

Width*Thickness	Inches	TPI				
		0.75/1.0	1/1.5	1.4/2	2/3	3/4
34*1.10	1-1/4*.042			■ #	■	■
41*1.30	1-1/2*.052			■	■	■ #
54*1.60	2*.063	■ #	■	■		
67*1.60	2-5/8*.063	■	■			

"#" non standard tooth, pre-order required

Bandsaw Blade Speed Chart

Materials	Trade Name	German DIN	Japan JIS	Bi-Metal Band Speed FPM	Bi-Metal Band Speed MPM	Carbide bandsaw Band Speed FPM	Carbide bandsaw Band Speed MPM
Aluminum Alloys	2024, 5052, 6061, 7075	3.1355, 3.3525, 3.3211, 3.4365	2024, 5052, 6061, 7075	275-340	84-104	3500-8000*	1000 - 2600 *
Copper Alloys	CDA 220	2.023	C2200	210	64	210	64
	CDA 360	2.0375	C3601	295	89	295	90
	Cu NI (30%)	2.0835	-	200	61	200	61
	Be Cu	-		160	49	160	49
Bronze Alloys	AMPCO 18	-	-	180	55	180	55
	AMPCO 21	-	-	160	49	160	49
	AMPCO 25	-	-	110	34	110	34
	Leaded Tin Bronze	2.1177	-	290	88	290	88
	Al Bronze 865	2.0976	AlBCin1	150	46	150	46
	Mn Bronze	2.0602	-	215	65	215	66
	932	-	-	280	85	280	85
	937	-	-	250	76	250	76
Brass Alloys	Cartridge Brass, Red Brass (85%)	-	BC6	220	67	220	67
	Naval Brass	-	YCuZn5n	200	61	200	61
Leaded, Free Machining Low Carbon Steels	1145	-	-	270	82	290	88
	1215	1.0736	SUM 25	325	99	325	99
	12L14	1.0718	SUM 24L	350	107	350	107
Structural Steel	A36	1.0132	-	250	76		
Low Carbon Steels	1008, 1018	1.0310, 1.0453	S9CK	270	82	250	76
	1030	1.1178	S 30 C	250	76	240	73
Medium Carbon Steels	1035	1.0501	S 35 C	240	73	230	70
	1045	1.0503, 1.1191	S 45 C	230	70	220	67
High Carbon Steels	1060	1.0601	S 58 C , S60 CM	200	61	200 **	61 **
	1080	1.1259	1080	195	59	195 **	59 **
	1095	1.0618	SUP 4	185	56	185 **	56 **
Mn Steels	1541	1.1167	SMn 438 (H)	200	61		
	1524	1.0499	SCMn1, SCMn21	170	52		
Cr-Mo Steels	4140	1.7225	SCM 440 (H)	225	68		
	41L50	-	-	235	71		
	4150H	-	-	200	61		
Cr Alloy Steels	6150	1.8159	SUP 10	190	58		
	52100	1.3505	SUJ 2	160	49		
	5160	1.7176	SUP 9 (A)5	195	59		
Ni-Cr-Mo Steels	4340	1.6565	SNCM 439 , SNCM 8	195	59		
	8620	1.6523	SNCM 220H, SNCM21	215	65		
	8640	1.6546	SNCM 240	185	56		
	E9310	1.6657	-	160	49		
Low Alloy Tool Steel	L-6	1.2714	SKT 4	145	44	192	59

Bandsaw Blade Speed Chart

Water-Hardening Tool Steel	W-1	1.1663	SK 1	148	45	180	55
Cold-Work Tool Steel	D-2	1.2379	SKD 11	98	30	180	55
Air-Hardening Tool Steels	A-2	1.2363	SKD 12	164	50	197	60
	A-6	-	-	148	45	180	55
	A-10	-	-	98	30	131	40
Hot Work Tool Steels	H-13	1.2344	SKD 61	148	45	180	55
	H-25	-	-	98	30	131	40
Oil-Hardening Tool Steels	O-1	1.251	SKS 3	148	45	197	60
	O-2	1.2842		148	45	180	55
High Speed Tool Steels	M-2, M-10	1.3343	SKH 9	115	35	98	30
	M-4	1.3348	SKH 54	98	30	98	30
	T-1	1.3355	SKH 3	98	30	82	25
	T-15	1.3202	SKH 10	66	20	66	20
Mold Steels	P-3	-	-	180	55	164	50
	P-20	1.2328	-	164	50	131	40
Shock Resistant Tool Steels	S-1	1.2542	SKS 41	148	45	0	0
	S-5, S-7	1.2823	-	131	40	0	0
Stainless Steels	304	1.4301	SUS 304	82	25	164	50
	316	1.4401	SUS 316	98	30	131	40
	410	1.4006	SUS 410	148	45	180	55
	440A	1.4109	SUS 440 A	82	25	148	45
	440C	1.4125	SUS 440 C	82	25	148	45
Precipitation Hardening Stainless Steels	17-4 PH	1.4542,1.4568	SUS 630, SUS 631	82	25	115	35
	15-5 PH	1.4545	-	82	25	98	30
Free Machining Stainless Steels	420F	-	-	164	50	197	60
	301	1.431	-	131	40	164	50
Nickel Alloys	Monel® K-500	2.4375	-	82	25	98	30
	Duranickel 301	-	-	66	20	82	25
Iron Based Super Alloys	A286	1.498	SUH 660	82	25	82	25
	Incoloy® 600	-	-	66	20	82	25
	Pyromet X-15	-	-	82	25	98	30
Nickel Based Alloys	Inconel® 600	2.4816,2.4668	NCF-600	66	20	98	30
	RENE 41	2.4973		66	20	98	30
	Inconel® 625	2.4831	-	82	25	115	35
	Hastalloy B	2.4800	Ni-Mo28	66	20	82	25
	RENE 88	2.4951	-	66	20	82	25
Titanium Alloys	-	3.7025	-	82	25	164	50
	Ti-6Al-4V	3.7615	-	66	20	164	50
Cast Irons	A536 (60-40-18)	0.704	FCD 40	230	70	-	-
	A536 (120-90-02)	0.708	-	115	35	-	-
	A48 (120)	0.601	FC 10	164	50	-	-
	A48 (140)	0.6025	FC 25	82	25	-	-
	A48 (300)	0.604	-	98	30	-	-

* For metal cutting saws run between 275 and 350 FPM (88 and 107 FPM)
** Typically for hardened and case hardened carbon steels up to 61 HRC

Trouble Shooting Of Bandsawing Operation

▲–major causes △–secondary causes

Causes type	Trouble descriptions / Check points	Early wear	Early tooth Strippage/ chipping	Early breakage	Crooked cut	Rough cut surface	Instability in Bandsawing	Loud cutting Noise	Blade stoppage	Too low efficiency	solutions
Cutting parameters	Too high bandsaw blade speed	▲		△			△	▲			Adjust the speed according to the parameter chart。
	Too low bandsaw blade speed		△				△			▲	Increase the bandsaw blade speed
	Too high feed rate	△	▲	△	▲	▲	△	△	▲		Lower down the feed rate
	Too low feed rate	△								▲	Increase the feed rate
	Improper feed pressure	▲	▲	▲	▲	△	▲	▲	△	△	Adjust the feed pressure
Bandsaw machine	Guides too far apart		▲	△	▲	△	▲	▲	△	▲	Adjust the guides
	Too high blade tension			▲				△			Reduce the bandsaw blade tension.
	Too low blade tension		▲		▲	▲	△		▲	▲	Increase the bandsaw blade tension.
	Worn or damaged back-up guide or guide rollers	▲	▲	▲	▲	△	△	▲		▲	Change the worn parts.
	Incorrect blade speed		▲	△	▲	▲	▲	△	△	▲	Check the main drive gears, bearings lifting mechanism of the frame
	Incorrect installed brush		▲		△	▲	▲				Check the brush.
	Inconsistent Saw frame feed	▲	▲	▲		▲	▲	△	△	▲	Check if there is air in the cylinder, whether the oil is deteriorating and the cylinder is worn or not.
	Bandsaw blade rubbing against band saw machine wheel flange			▲			▲	▲			Check the alignment of the band saw machine wheels.
	Poor material clamping		▲	△	▲	△	△		△	▲	Check the vise or repair it.
	Wrong traverse path of the bandsaw	△			▲						Check the perpendicular traverse path of the frame
	Slippage of the driving belt on the driving wheel		▲			△	△		▲	▲	Check the belt tension or check for worn driving wheel
	Vibration of the entire machine	▲	▲	△		▲	▲	▲		▲	The machines maybe installed improperly or there is some vibration source from other parts.
Lubricant	Wrong cutting fluid	▲	△			△		▲		△	Change to correct cutting fluid.
	Insufficient cutting fluid supply	▲	△	▲		△		▲		△	Check the fluid hoses, increase the volume of the fluid, both on the cutting section and the insert section.
	Improper concentration	▲				▲		△			Adjust the concentration according to the brochure of the lubricant
Selection of bandsaw	Inappropriate blade type or blade pitch	▲	▲			△	▲	△		△	Select the pith and blade type according to the application
	Insufficient break-in process	▲	▲			△					Perform sufficient break in process
	Cut product Jamming, too much edged burrs	▲	▲			△		△	△	△	Proper break in procedure； Proper cutting parameters； Proper lubricant application
	Corroded blade	▲		▲				△			Stored to long。 Humidity is too high. Or the lubricant is corrosive.
	Too much wear of the blade		△	▲	▲	△		▲	△	▲	Change the blade
	Damaged teeth	▲	▲				△	△		△	Change the blades
	Bad butt weld	△	▲	▲		△	▲	△		△	Re-weld or change the blades.
Work material	Unknown material	▲	△		△			△		△	Check the details of materials. Set the cutting parameter according to the chart.
	Hard points inside the material or hard surface	▲	▲		△			▲		△	Adjust the parameters, Usually, need to lower down the speed or select a more protective teeth profile.
	Too low rigidity of the material	△	▲			▲	△	▲		△	Proper tooth form and proper parameters. Proper Clamping method.
	Irregular shape		▲	▲	△	△	▲		△	△	Find the right clamping method.
	Finished parts interrupt the band sawing operation		▲	▲					△		Clear the parts and chips in time.

LianNord

EXQUISITE EXPERTISE
SUSTAINABLE STRENGTH

Overseas:

Great Britain, Netherlands, Denmark, Switzerland, Czech Republic, Poland, Greece, Jordan, Russia, Egypt, Iran, South Africa, India, Thailand, Korea, USA, Brazil, Spain, Portugal, Italy, Syria, Israel, Singapore, New Zealand, Canada, Mexico, Argentina, Qatar, United Arab mirates, Turkey, Lebanon Serbia, Pakistan, Malaysia, Australia, Dominica, Columbia, Ecuador,Slovenia, Indonesia, etc.