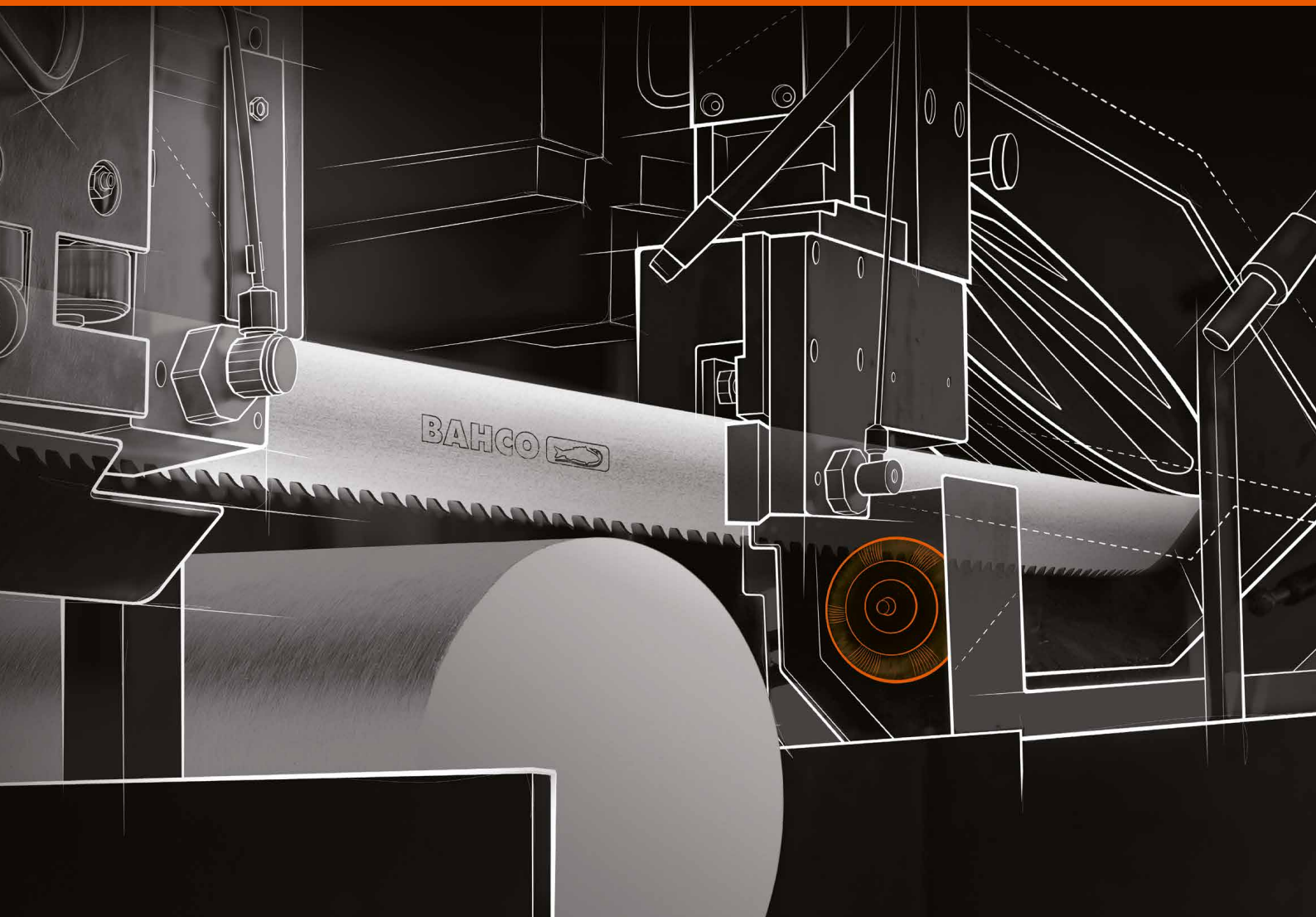
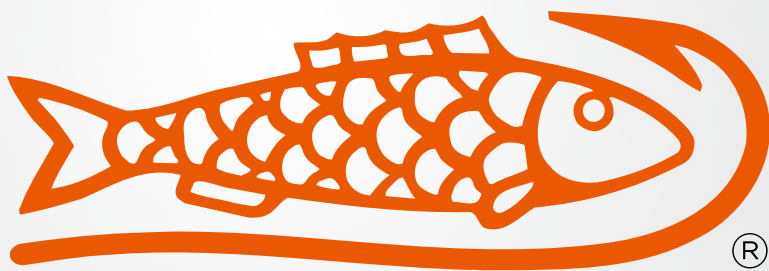


BAHCO®



BANDSAW BLADES



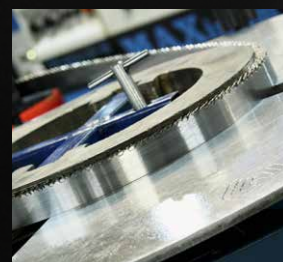


BAHCO

We give professionals what they need: Quality with bite

- State-of-the-art manufacturing processes
- Own research and development centre
- Over 150 years of experience in the manufacture of hand tools and saw blades
- Own welding stations
- Support from application engineers and technical advisors
- Professional training centres

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	Products	Bi-metal								Tri-metal	Carbide														
		3851 PRX Cobra	3854 PHX King Cobra	3854 PQ King Cobra	3858 PHX P9000	3858 PQ P9000	3853 TOP Fabricator	3853 TOP Fabricator – W	3857 Easy-Cut	3859 EZX EasyCut Xtreme	3869 TS	3868 TSX	3868 TSS	3881 THQ	3881 THS	3860 TMC Only on stable machines.	3860 TMC-S Only on stable machines.	3860 TCD Only on stable machines.	3860 TCZ Only on stable machines.	3860 TCA Only on stable machines.					
Catalogue page		4	6	7	8	9	10	11	12	15	17	18	19	20	21	22	23	24	25	26					
Structural steel																									
Free cutting steel																									
Case hardening steel																									
Tempering steel																									
Bearing steel																									
Unalloyed tool steel																									
Cold work tool steel																									
Hot work tool steel																									
High-speed steel																									
High alloy steels																									
Nitriding steel																									
Stainless steel																									
Duplex and heat resistant steel																									
Titanium and titanium alloys																									
Nickel-based alloys																									
Case hardened bar																									
Cast iron																									
Aluminium																									
Aluminium vertical																									
Brass																									
Copper																									
Tubes and profiles																									

Performance: top very good good

NEW! New! Saw blades developed both for pallet dismantling and repair business and for cutting mineral wool insulation

Bi-metal Sandflex®

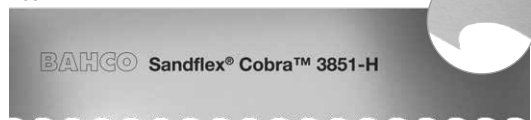
3851 PRX Cobra

The universal saw blade with improved powder metallurgical tooth material was developed for demanding applications.

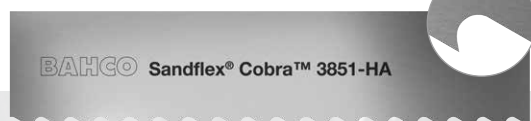
It is suitable for sawing a wide range of materials from aluminium to stainless steel. The stable tooth design ensures maximum cutting performance. Different tooth shapes are available depending on the application:

- **Hook:** Traditional tooth shape for cutting non-ferrous metals, wood and plastics
- **HA:** Special development tooth design for cutting aluminium workpieces, as used in foundries
- **PRX:** Improved, robust tooth design for long tool life with innovative stepped rake angle. Particularly suitable for production sawing of small to large dimensions
- **PS:** High performance tooth design with a positive rake angle of 10° - 15°. Thanks to the large wedge angle and the wide chip chamber, the tooth shape is excellent for sawing very large workpieces

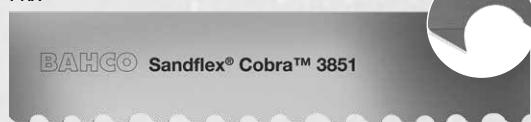
Hook



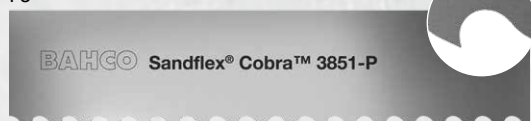
HA



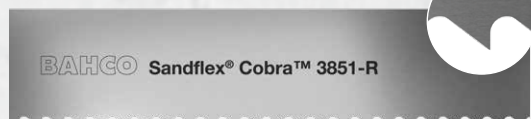
PRX



PS



R



Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
6 x 0.6	6	Hook	3851-6-0.6-H-6
	10/14	PRX	3851-6-0.6-10/14
6 x 0.9	6	Hook	3851-6-0.9-H-6
	10/14	PRX	3851-6-0.9-10/14
10 x 0.6	4	Hook	3851-10-0.6-H-4
	6	Hook	3851-10-0.6-H-6
	10/14	PRX	3851-10-0.6-10/14
10 x 0.9	4	Hook	3851-10-0.9-H-4
	6	Hook	3851-10-0.9-H-6
	10/14	PRX	3851-10-0.9-10/14
	14	R	3851-10-0.9-R-14
13 x 0.5	10	R	3851-13-0.5-R-10
	10/14	PRX	3851-13-0.5-10/14
	14	R	3851-13-0.5-R-14
	14/18	PRX	3851-13-0.5-14/18
	18	R	3851-13-0.5-R-18
	24	Regular	3851-13-0.5-R-24
13 x 0.6	3	Hook	3851-13-0.6-H-3
	4	Hook	3851-13-0.6-H-4
	4	HA	3851-13-0.6-HA-4
	6	Hook	3851-13-0.6-H-6
	6	HA	3851-13-0.6-HA-6
	6/10	PRX	3851-13-0.6-6/10
	8/12	PRX	3851-13-0.6-8/12
	10	Regular	3851-13-0.6-R-10
	10/14	PRX	3851-13-0.6-10/14
	14	Regular	3851-13-0.6-R-14
	5/8	PRX	3851-13-0.6-R-5/8
	18	Regular	3851-13-0.6-R-18
13 x 0.9	3	Hook	3851-13-0.9-H-3
	4	Hook	3851-13-0.9-H-4
	4	HA	3851-13-0.9-HA-4
	6	Hook	3851-13-0.9-H-6
	6	Regular	3851-13-0.9-R-6
	6/10	PRX	3851-13-0.9-6/10
	10/14	PRX	3851-13-0.9-10/14
	14	Regular	3851-13-0.9-R-14

Example for ordering a bandsaw blade:

Product code - Blade length in mm

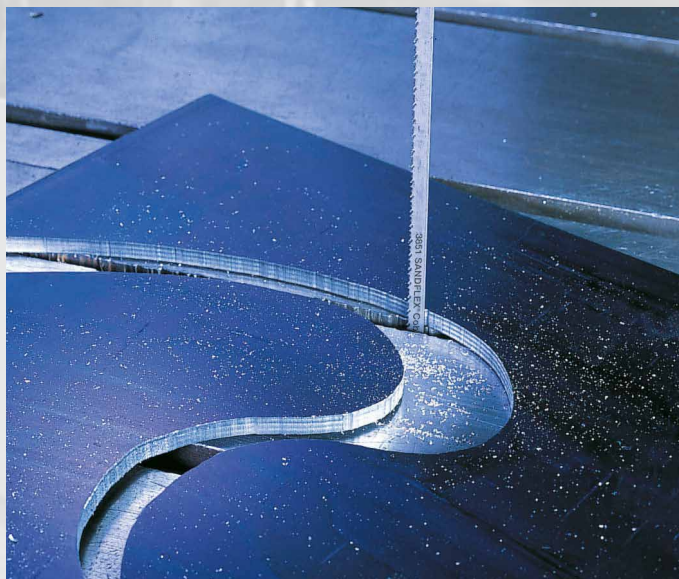
Example:

3851-13-0.9-R-14-1300

Bi-metal Sandflex®

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
20 x 0.9	3	HA	3851-20-0.9-HA-3
	3	H	3851-20-0.9-H-3
	4	H	3851-20-0.9-H-4
	4	HA	3851-20-0.9-HA-4
	4/6	PRX	3851-20-0.9-4/6
	5/8	PRX	3851-20-0.9-5/8
	6/10	PRX	3851-20-0.9-6/10
	8/12	PRX	3851-20-0.9-8/12
	10/14	PRX	3851-20-0.9-10/14
27 x 0.9	18	Regular	3851-20-0.9-R-18
	2	HA	3851-27-0.9-HA-2
	2/3	PRX	3851-27-0.9-2/3
	3	HA	3851-27-0.9-HA-3
	3	PS	3851-27-0.9-P-3
	3/4	PRX	3851-27-0.9-3/4
	4	HA	3851-27-0.9-HA-4
	4	PS	3851-27-0.9-P-4
	4/6	PRX	3851-27-0.9-4/6
	5/8	PRX	3851-27-0.9-5/8
	6	Regular	3851-27-0.9-R-6
	6/10	PRX	3851-27-0.9-6/10
	8/12	PRX	3851-27-0.9-8/12
34 x 1.1	10/14	PRX	3851-27-0.9-10/14
	2	PS	3851-34-1.1-P-2
	2/3	PRX	3851-34-1.1-2/3
	3	PS	3851-34-1.1-P-3
	3/4	PRX	3851-34-1.1-3/4
	4/6	PRX	3851-34-1.1-4/6
	5/8	PRX	3851-34-1.1-5/8
	6/10	PRX	3851-34-1.1-6/10

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
41 x 1.3	1.4/2	PRX	3851-41-1.3-1.4/2
	2/3	PRX	3851-41-1.3-2/3
	3/4	PRX	3851-41-1.3-3/4
	4/6	PRX	3851-41-1.3-4/6
	5/8	PRX	3851-41-1.3-5/8
54 x 1.3	1.4/2	PRX	3851-54-1.3-1.4/2
	2/3	PRX	3851-54-1.3-2/3
	3/4	PRX	3851-54-1.3-3/4
	4/6	PRX	3851-54-1.3-4/6
54 x 1.6	1/1.4	PRX	3851-54-1.6-1/1.4
	1.4/2	PRX	3851-54-1.6-1.4/2
	2/3	PRX	3851-54-1.6-2/3
	3/4	PRX	3851-54-1.6-3/4
	4/6	PRX	3851-54-1.6-4/6
67 x 1.6	0.7/1	PRX	3851-67-1.6-.7/1
	1/1.4	PRX	3851-67-1.6-1/1.4
	1.4/2	PRX	3851-67-1.6-1.4/2
	2/3	PRX	3851-67-1.6-2/3
	3/4	PRX	3851-67-1.6-3/4
	4/6	PRX	3851-67-1.6-4/6
80 x 1.6	0.7/1	PRX	3851-80-1.6-.7/1
	1/1.4	PRX	3851-80-1.6-1/1.4
	1.4/2	PRX	3851-80-1.6-1.4/2



Bi-metal Sandflex®

3854 PHX King Cobra

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
27 x 0.9	2/3	PHX	3854-27-0.9-PHX-2/3
	3/4	PHX	3854-27-0.9-PHX-3/4
	4/6	PHX	3854-27-0.9-PHX-4/6
34 x 1.1	1.4/2	PHX	3854-34-1.1-PHX-1.4/2
	2/3	PHX	3854-34-1.1-PHX-2/3
	3/4	PHX	3854-34-1.1-PHX-3/4
	4/6	PHX	3854-34-1.1-PHX-4/6
41 x 1.3	1.4/2	PHX	3854-41-1.3-PHX-1.4/2
	2/3	PHX	3854-41-1.3-PHX-2/3
	3/4	PHX	3854-41-1.3-PHX-3/4
	4/6	PHX	3854-41-1.3-PHX-4/6
54 x 1.3	1.4/2	PHX	3854-54-1.3-PHX-1.4/2
	2/3	PHX	3854-54-1.3-PHX-2/3
	3/4	PHX	3854-54-1.3-PHX-3/4
54 x 1.6	0.7/1	PHX	3854-54-1.6-PHX-.7/1
	1/1.4	PHX	3854-54-1.6-PHX-1/1.4
	1.4/2	PHX	3854-54-1.6-PHX-1.4/2
	2/3	PHX	3854-54-1.6-PHX-2/3
	3/4	PHX	3854-54-1.6-PHX-3/4
67 x 1.6	0.7/1	PHX	3854-67-1.6-PHX-.7/1
	1/1.4	PHX	3854-67-1.6-PHX-1/1.4
	1.4/2	PHX	3854-67-1.6-PHX-1.4/2
	2/3	PHX	3854-67-1.6-PHX-2/3
80 x 1.6	0.7/1	PHX	3854-80-1.6-PHX-.7/1
	1/1.4	PHX	3854-80-1.6-PHX-1/1.4
	1.4/2	PHX	3854-80-1.6-PHX-1.4/2



For sawing large workpieces and difficult materials. With special tooth design for optimum sawing performance and noise reduction.

- Fatigue-resistant blade back and powder-metallurgical tooth material, similar to M51, offer best properties and a long service life in difficult-to-saw materials
- Special VariEdge tooth design with variable clearance and rake angle for optimum sawing performance of each individual tooth
- Special set with different tooth heights results in a multi-span saw profile that reduces sawing forces and extends saw blade life
- Powder metallurgy HSS tooth edge withstands high temperatures and is wear resistant
- Extra large gullet to remove more chips
- Precise set for smooth cutting surfaces

PHX



3854 PQ™ King Cobra

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
27 x 0.9	3/4	PQ	3854-27-0.9-PQ-3/4
	4/6	PQ	3854-27-0.9-PQ-4/6
34 x 1.1	2/3	PQ	3854-34-1.1-PQ-2/3
	3/4	PQ	3854-34-1.1-PQ-3/4
	4/6	PQ	3854-34-1.1-PQ-4/6
41 x 1.3	1.4/2	PQ	3854-41-1.3-PQ-1.4/2
	2/3	PQ	3854-41-1.3-PQ-2/3
	3/4	PQ	3854-41-1.3-PQ-3/4
	4/6	PQ	3854-41-1.3-PQ-4/6
54 x 1.6	0.9/1.2	PQ	3854-54-1.6-PQ-.9/1.2
	1.4/2	PQ	3854-54-1.6-PQ-1.4/2
	2/3	PQ	3854-54-1.6-PQ-2/3
	3/4	PQ	3854-54-1.6-PQ-3/4
	4/6	PQ	3854-54-1.6-PQ-4/6
67 x 1.6	0.9/1.2	PQ	3854-67-1.6-PQ-.9/1.2
	1.4/2	PQ	3854-67-1.6-PQ-1.4/2
	2/3	PQ	3854-67-1.6-PQ-2/3
80 x 1.6	0.9/1.2	PQ	3854-80-1.6-PQ-.9/1.2
	1.4/2	PQ	3854-80-1.6-PQ-1.4/2



Aggressive tooth design with extreme positive rake angle and new, higher quality, powder metallurgy tooth material similar to M51. High chip capacity for difficult-to-machine materials such as stainless bearing steel, tool steels and difficult-to-machine special alloys. The alternating set leads to height differences between the tooth tips and so a reduction in cutting forces and an improved blade life.

- Suitable for sawing a wide range of materials from aluminium to stainless steel, especially suitable for tough materials
- Sturdy tooth construction for maximum cutting performance
- Long service life of the saw blade

PQ



Example for ordering a bandsaw blade:

Product code - Blade length in mm

Example:

3854-54-1.6-PQ-1.4/2-7500

Bi-metal Sandflex®

3858 PHX P9000

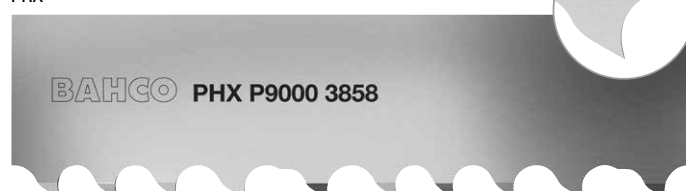
Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
34 x 1.1	1.4/2	PHX	3858-34-1.1-PHX-1.4/2
	2/3	PHX	3858-34-1.1-PHX-2/3
	3/4	PHX	3858-34-1.1-PHX-3/4
41 x 1.3	1.4/2	PHX	3858-41-1.3-PHX-1.4/2
	2/3	PHX	3858-41-1.3-PHX-2/3
	3/4	PHX	3858-41-1.3-PHX-3/4
54 x 1.3	1.4/2	PHX	3858-54-1.3-PHX-1.4/2
	2/3	PHX	3858-54-1.3-PHX-2/3
	3/4	PHX	3858-54-1.3-PHX-3/4
54 x 1.6	0.7/1	PHX	3858-54-1.6-PHX-.7/1
	1/1.4	PHX	3858-54-1.6-PHX-1/1.4
	1.4/2	PHX	3858-54-1.6-PHX-1.4/2
	2/3	PHX	3858-54-1.6-PHX-2/3
	3/4	PHX	3858-54-1.6-PHX-3/4
67 x 1.6	0.7/1	PHX	3858-67-1.6-PHX-.7/1
	1/1.4	PHX	3858-67-1.6-PHX-1/1.4
	1.4/2	PHX	3858-67-1.6-PHX-1.4/2
	2/3	PHX	3858-67-1.6-PHX-2/3
80 x 1.6	0.7/1	PHX	3858-80-1.6-PHX-.7/1
	1/1.4	PHX	3858-80-1.6-PHX-1/1.4
	1.4/2	PHX	3858-80-1.6-PHX-1.4/2



For high performance sawing of harder materials, as well as larger and difficult to cut workpieces. With special tooth design for optimum sawing performance and noise reduction.

- Stable blade back with 4 % Cr content and powder-metallurgical tooth material, similar to M71, offer the best properties and a long service life in difficult-to-saw materials
- Special VariEdge tooth design with variable clearance and rake angle for optimum sawing performance of each individual tooth
- Special set with different tooth heights results in a multi-span saw profile that reduces sawing forces and extends saw blade life
- Powder metallurgy HSS tooth edge withstands high temperatures and is wear resistant
- Extra large gullet to remove more chips
- Precise set for smooth cutting surfaces
- Sharp tooth tips facilitate penetration into the material to be cut

PHX



3858 PQ™ P9000

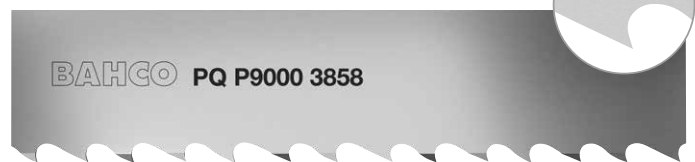
Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
41 x 1.3	1.4/2	PQ	3858-41-1.3-PQ-1.4/2
	2/3	PQ	3858-41-1.3-PQ-2/3
	3/4	PQ	3858-41-1.3-PQ-3/4
54 x 1.6	0.9/1.2	PQ	3858-54-1.6-PQ-9/1.2
	1.4/2	PQ	3858-54-1.6-PQ-1.4/2
	2/3	PQ	3858-54-1.6-PQ-2/3
67 x 1.6	0.9/1.2	PQ	3858-67-1.6-PQ-9/1.2
	1.4/2	PQ	3858-67-1.6-PQ-1.4/2
80 x 1.6	0.9/1.2	PQ	3858-80-1.6-PQ-9/1.2



Aggressive tooth design with extremely positive rake angle. High chip capacity for difficult-to-cut materials such as stainless bearing steel, tool steels and difficult-to-machine special alloys.

- New high quality powder metallurgy tooth material, similar to M71, ensures precise cuts, better surface finish and increases tool life
- Suitable for sawing a wide range of materials from aluminium to stainless steel
- Sturdy tooth construction for maximum cutting performance
- Long service life of the saw blade
- Particularly suitable for tough materials
- More stable back material with 4 % Cr content

PQ



Example for ordering a bandsaw blade:

Product code - Blade length in mm

Example:

3858-54-1.6-PQ-1.4/2-7500

Bi-metal Sandflex®

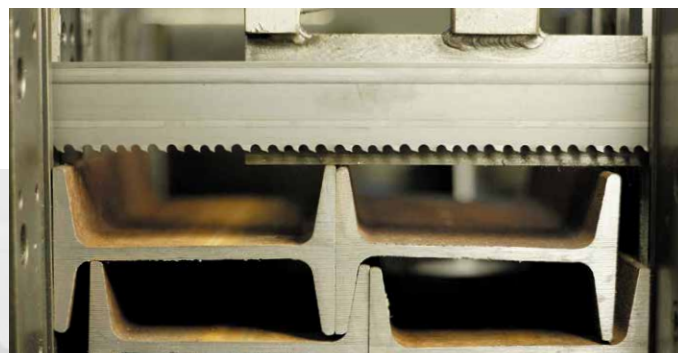
3853 TOP Fabricator™

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
20 x 0.9	5/7	PF	3853-20-0.9-5/7-VS
	8/11	PF	3853-20-0.9-8/11-VS
27 x 0.9	3/4	PF	3853-27-0.9-3/4
	4/6	PF	3853-27-0.9-4/6
	5/7	PF	3853-27-0.9-5/7-VS
	5/8	PF	3853-27-0.9-5/8
	8/11	PF	3853-27-0.9-8/11-VS
34 x 1.1	2/3	PF	3853-34-1.1-2/3
	3/4	PF	3853-34-1.1-3/4
	4/6	PF	3853-34-1.1-4/6
	5/7	PF	3853-34-1.1-5/7-VS
	5/8	PF	3853-34-1.1-5/8
	8/11	PF	3853-34-1.1-8/11-VS
41 x 1.3	2/3	PF	3853-41-1.3-2/3
	3/4	PF	3853-41-1.3-3/4
	4/6	PF	3853-41-1.3-4/6
	5/7	PF	3853-41-1.3-5/7-VS
	5/8	PF	3853-41-1.3-5/8
54 x 1.3	3/4	PF	3853-54-1.3-3/4
	5/8	PF	3853-54-1.3-5/8
54 x 1.6	2/3	PF	3853-54-1.6-2/3
	3/4	PF	3853-54-1.6-3/4
	4/6	PF	3853-54-1.6-4/6
67 x 1.6	2/3	PF	3853-67-1.6-2/3
	3/4	PF	3853-67-1.6-3/4

Its patented tooth design makes it particularly suitable for sawing structural steels, profiles, round and square tubes, bundled or single. Precisely set, heavier duty teeth made from powder metallurgy material with positive rake angle result in lower cutting stress, with smoother surfaces and less jamming.

- Excellent tool life
- Reinforced back to prevent tooth breakage
- Multispan ensures better chip removal
- High quality, powder metallurgy tooth material similar to M51
- Significantly reduces:
 - cut out of square
 - broken teeth
 - vibrations
 - wedging

PF



3853 TOP Fabricator™ – with wide set (W)

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
41 x 1.3	2/3	PF	3853-41-1.3-2/3-W
	3/4	PF	3853-41-1.3-3/4-W
54 x 1.3	3/4	PF	3853-54-1.3-3/4-W
54 x 1.6	2/3	PF	3853-54-1.6-2/3-W
	3/4	PF	3853-54-1.6-3/4-W
67 x 1.6	2/3	PF	3853-67-1.6-2/3-W
	3/4	PF	3853-67-1.6-3/4-W
	5/8	PF	3853-67-1.6-5/8-W



- Extremely high cutting performance
- High resistance to high temperatures during sawing
- Made from PM material
- High quality, powder metallurgy tooth material similar to M51
- Excellent tool life
- Extra wide set prevents jamming on large workpieces with inherent tension

PF



Example for ordering a TOP Fabricator™ band saw blade with wide set or wide set and superior coating:

W – Wide set **WS** – Superior coating and wide set

Product code + W or WS after TPI specification - Blade length in mm

Examples

Standard band saw blade:

3853-41-1.3-3/4-6300

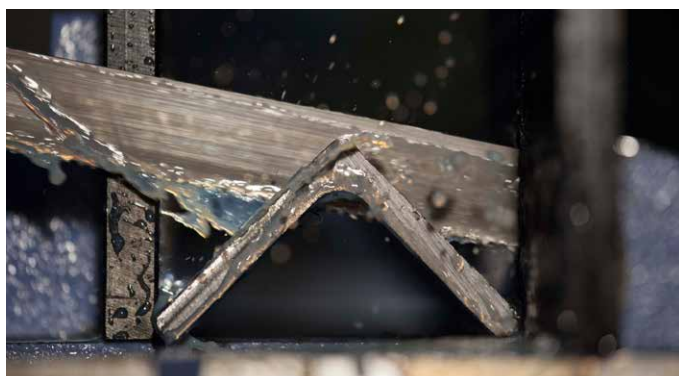
Band saw blade with wide set:

3853-41-1.3-3/4-W-6300

Bi-metal Easy-Cut

3857 Easy-Cut

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
13 x 0.6	S (small)	EZ	3857-13-0.6-EZ-S
	M (medium)	EZ	3857-13-0.6-EZ-M
	L (large)	EZ	3857-13-0.6-EZ-L
20 x 0.9	S (small)	EZ	3857-20-0.9-EZ-S
	M (medium)	EZ	3857-20-0.9-EZ-M
	L (large)	EZ	3857-20-0.9-EZ-L
27 x 0.9	S (small)	EZ	3857-27-0.9-EZ-S
	M (medium)	EZ	3857-27-0.9-EZ-M
	L (large)	EZ	3857-27-0.9-EZ-L
34 x 1.1	S (small)	EZ	3857-34-1.1-EZ-S
	M (medium)	EZ	3857-34-1.1-EZ-M
	L (large)	EZ	3857-34-1.1-EZ-L

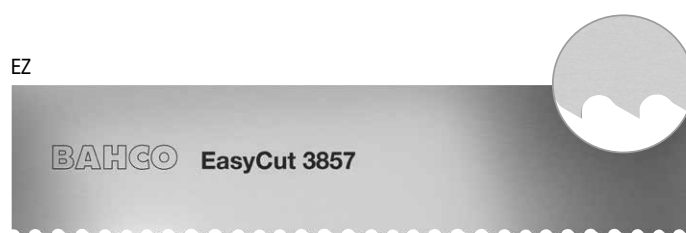


This new generation of bandsaw blades meets all the requirements for use in versatile applications. The new, patented tooth shape is suitable for cutting a wide range of cross-sections and materials with a single band saw blade.

Easy-Cut saw bands cut almost any material - no band change necessary!

- Tool steel
- Wood
- Mouldings
- Mild steel
- Plastic
- Angle iron
- Stainless steel
- Sheet metal
- I-beam
- Aluminium
- Tubes
- Double T-beam
- Copper
- Solid materials
- Brass
- Bundles
- Boring bars

EZ



3 pieces Easy-Cut bandsaw blades for mobile bandsaws. Especially suitable for small portaband machines.

Dimensions in mm (width x thickness)	Tooth pitch	Blade length	Tooth shape	Product code
13 x 0.6	S (small)	690 mm	EZ	3857-13-0.6-EZ-S-P690
	S (small)	730 mm	EZ	3857-13-0.6-EZ-S-P730
	S (small)	835 mm	EZ	3857-13-0.6-EZ-S-P835
	S (small)	900 mm	EZ	3857-13-0.6-EZ-S-P900
	S (small)	1140 mm	EZ	3857-13-0.6-EZ-S-P1140
	M (medium)	690 mm	EZ	3857-13-0.6-EZ-M-3P690
	M (medium)	730 mm	EZ	3857-13-0.6-EZ-M-3P730
	M (medium)	835 mm	EZ	3857-13-0.6-EZ-M-3P835
	M (medium)	900 mm	EZ	3857-13-0.6-EZ-M-3P900
	M (medium)	1140 mm	EZ	3857-13-0.6-EZ-M-3P1140

Depending on the required cutting size, select S (small), M (medium) or L (large).

Product code	Blade size Width x Thickness	Diameter or wall thickness in mm																	
		1	2	3	5	10	20	30	40	50	75	100	150	200					
3857-13-0.6-EZ-S	13 x 0.6																		
3857-13-0.6-EZ-M	13 x 0.6																		
3857-13-0.6-EZ-L	13 x 0.6																		
3857-20-0.9-EZ-S	20 x 0.9																		
3857-20-0.9-EZ-M	20 x 0.9																		
3857-20-0.9-EZ-L	20 x 0.9																		
3857-27-0.9-EZ-S	27 x 0.9																		
3857-27-0.9-EZ-M	27 x 0.9																		
3857-27-0.9-EZ-L	27 x 0.9																		
3857-34-1.1-EZ-S	34 x 1.1																		
3857-34-1.1-EZ-M	34 x 1.1																		
3857-34-1.1-EZ-L	34 x 1.1																		



Video Bahco
Easy-Cut
Bandsaw



BAHCO Sandflex® King Cobra™ PHX 3854



TriMetal Easy-Cut Xtreme TriMetal

NEW

3859 Carbide Easy-Cut EZX

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
27 x 0.9	3/4	EZX	3859-27-0.9-EZX-3/4
	4/6	EZX	3859-27-0.9-EZX-4/6
34 x 1.1	2/3	EZX	3859-34-1.1-EZX-2/3
	3/4	EZX	3859-34-1.1-EZX-3/4
	4/6	EZX	3859-34-1.1-EZX-4/6
41 x 1.3	1.4/2	EZX	3859-41-1.3-EZX-1.4/2
	2/3	EZX	3859-41-1.3-EZX-2/3
	3/4	EZX	3859-41-1.3-EZX-3/4
	4/6	EZX	3859-41-1.3-EZX-4/6
54 x 1.6	1/1.25	EZX	3859-54-1.6-EZX-1/1.25
	1.4/2	EZX	3859-54-1.6-EZX-1.4/2
	2/3	EZX	3859-54-1.6-EZX-2/3
	3/4	EZX	3859-54-1.6-EZX-3/4
	4/6	EZX	3859-54-1.6-EZX-4/6
67 x 1.6	.7/1	EZX	3859-67-1.6-EZX-.7/1
	1/1.25	EZX	3859-67-1.6-EZX-1/1.25
	1.4/2	EZX	3859-67-1.6-EZX-1.4/2
	2/3	EZX	3859-67-1.6-EZX-2/3
80 x 1.6	.7/1	EZX	3859-80-1.6-EZX-.7/1
	1/1.25	EZX	3859-80-1.6-EZX-1/1.25
	1.4/2	EZX	3859-80-1.6-EZX-1.4/2

Upgrade from bi-metal to carbide: This saw blade is more durable than a normal carbide saw blade and can be used like a bi-metal saw blade. This means that materials that are easy and difficult to cut can be sawn with the same saw blade. The new set pattern allows for a larger chip in the cutting channel, increasing the saw blade's wear resistance and service life.

- Versatile - suitable for a wide range of materials such as mild steel, stainless steel, cast iron, high temperature alloys and tool steel
- Heat resistant - for faster sawing and more flexible use
- User-friendly - no special feeds and speeds to consider, can be used like a bi-metal band saw blade
- Lower costs - less set-up time due to band change and reduction of stock
- No blade break in required

EZX

BAHCO EasyCut Xtreme TriMetal 3859



Example for ordering a bandsaw blade:

Product code - Blade length in mm

Example:

3859-54-1.6-EZX-1.4/2-7500



BAHCO 3859 Easy

Carbide Carbide

3869 TS

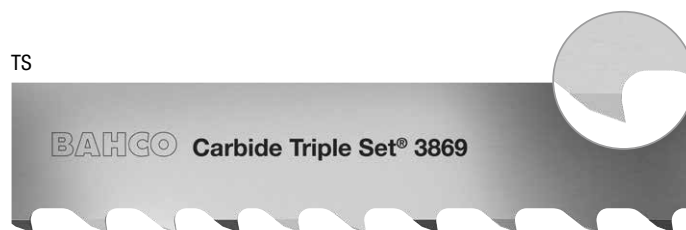
Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
13 x 0.9	3	TS	3869-13-0.9-TS-3
20 x 0.9	3	TS	3869-20-0.9-TS-3
	4	TS	3869-20-0.9-TS-4
27 x 0.9	3	TS	3869-27-0.9-TS-3
	4	TS	3869-27-0.9-TS-4
34 x 1.1	2	TS	3869-34-1.1-TS-2
	3	TS	3869-34-1.1-TS-3



For sawing non-ferrous metals and abrasive materials. Ideal for sawing aluminium castings, magnesium, zirconium, plastics and other abrasive materials. Special design for foundry applications.

- Carbide tipped teeth, triple set
- Fast cutting
- Light feed
- Straight and radius cuts
- Specially designed for foundries
- For use in small machines for difficult to cut materials

TS



Example for ordering a bandsaw blade:

Product code - Blade length in mm

Example:

3869-34-1.1-TS-7800

Carbide Carbide

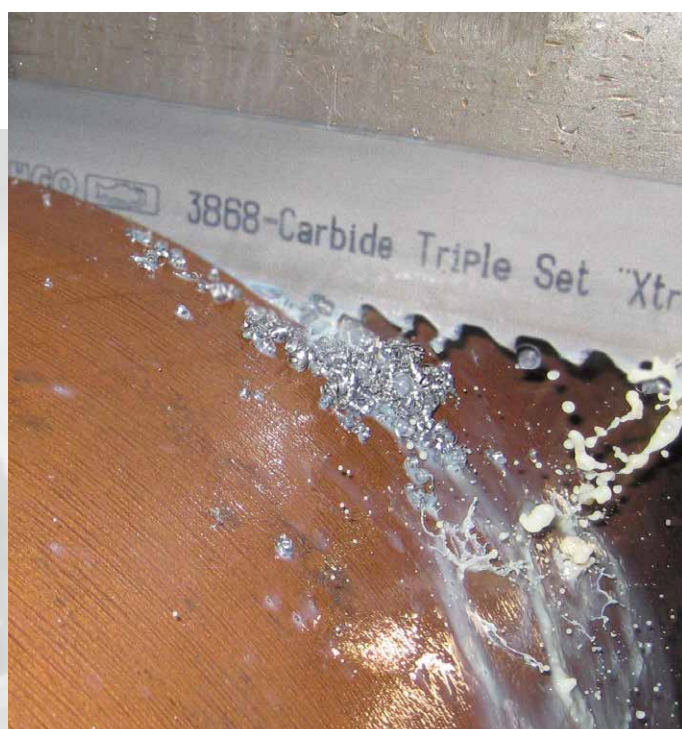
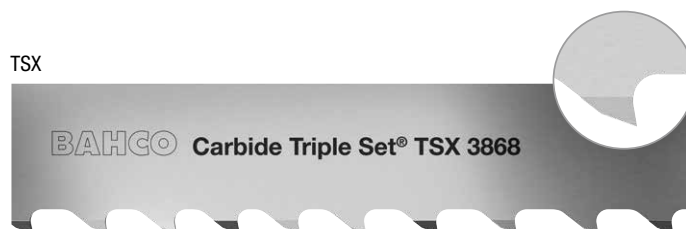
3868 TSX

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
27 x 0.9	3/4	TSX	3868-27-0.9-TSX-3/4
34 x 1.1	2	TSX	3868-34-1.1-TSX-2
	2/3	TSX	3868-34-1.1-TSX-2/3
	3/4	TSX	3868-34-1.1-TSX-3/4
41 x 1.3	1.4/2	TSX	3868-41-1.3-TSX-1.4/2
	1.6	TSX	3868-41-1.3-TSX-1.6
	2	TSX	3868-41-1.3-TSX-2
	2/3	TSX	3868-41-1.3-TSX-2/3
	3/4	TSX	3868-41-1.3-TSX-3/4
54 x 1.3	1.4/2	TSX	3868-54-1.3-TSX-1.4/2
	2/3	TSX	3868-54-1.3-TSX-2/3
54 x 1.6	1/1.25	TSX	3868-54-1.6-TSX-1/1.25
	1.4/1.6	TSX	3868-54-1.6-TSX-1.4/1.6
	1.4/2	TSX	3868-54-1.6-TSX-1.4/2
	1.6	TSX	3868-54-1.6-TSX-1.6
	2	TSX	3868-54-1.6-TSX-2
	2/3	TSX	3868-54-1.6-TSX-2/3
	3/4	TSX	3868-54-1.6-TSX-3/4
67 x 1.6	0.7/1	TSX	3868-67-1.6-TSX-.7/1
	1/1.25	TSX	3868-67-1.6-TSX-1/1.25
	1.4/2	TSX	3868-67-1.6-TSX-1.4/2
	2/3	TSX	3868-67-1.6-TSX-2/3
80 x 1.1	3/4	TSX	3868-80-1.1-TSX-3/4
80 x 1.6	0.7/1	TSX	3868-80-1.6-TSX-.7/1
	1/1.25	TSX	3868-80-1.6-TSX-1/1.25
	2/3	TSX	3868-80-1.6-TSX-2/3

Set carbide saw blades can be used more universally than unset ones. Patented TSX tooth design.

- For highly efficient sawing of small to large workpieces, as well as difficult-to-machine and abrasive materials
- Particularly suitable for tough materials such as stainless steels, and abrasive tool steels
- Specially ground tooth geometry, triple set, with optimum chip removal to prevent tooth chipping
- High low 3-tooth geometry
- Suitable for sawing titanium alloys, graphite alloys and aluminium with high silicon content

TSX



3868 TSS

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
27 x 0.9	3/4	TSS	3868-27-0.9-TSS-3/4
34 x 1.1	2/3	TSS	3868-34-1.1-TSS-2/3
	3/4	TSS	3868-34-1.1-TSS-3/4
41 x 1.3	1.4/2	TSS	3868-41-1.3-TSS-1.4/2
	2/3	TSS	3868-41-1.3-TSS-2/3
54 x 1.6	1/1.25	TSS	3868-54-1.6-TSS-1/1.25
	1.4/2	TSS	3868-54-1.6-TSS-1.4/2
	2/3	TSS	3868-54-1.6-TSS-2/3
67 x 1.6	0.7/1	TSS	3868-67-1.6-TSS-7/1
	1/1.25	TSS	3868-67-1.6-TSS-1/1.25
	1.4/2	TSS	3868-67-1.6-TSS-1.4/2
	2/3	TSS	3868-67-1.6-TSS-2/3



For highly efficient sawing of difficult-to-machine and abrasive materials, especially for stainless steel workpieces where vibrations may occur. This saw blade is "pre-run" in the factory using a patented method, which enables low-vibration sawing from the first cut. The high/low 3 tooth geometry and good clearance prevent tooth chipping. Allows cutting of workpieces at extremely low noise levels.

- No blade break in required
- Recommended for stainless steel applications
- Set design for good chip removal and long tool life
- Very low noise level
- Not suitable for sawing titanium

TSS



Example for ordering a bandsaw blade:

Product code - Blade length in mm

Example:

3868-54-1.6-TSX-1.4/2-7500

Carbide Carbide

3881 THQ

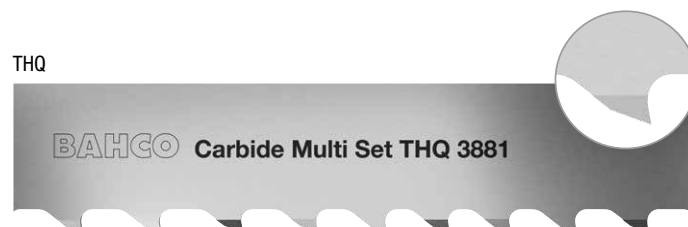
Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
34 x 1.1	2/3	THQ	3881-34-1.1-THQ-2/3
41 x 1.3	1.4/2	THQ	3881-41-1.3-THQ-1.4/2
	2/3	THQ	3881-41-1.3-THQ-2/3
54 x 1.6	1.4/2	THQ	3881-54-1.6-THQ-1.4/2
	2/3	THQ	3881-54-1.6-THQ-2/3
67 x 1.6	1/1.25	THQ	3881-67-1.6-THQ-1/1.25
	1.4/2	THQ	3881-67-1.6-THQ-1.4/2
	2/3	THQ	3881-67-1.6-THQ-2/3
80 x 1.6	0.7/1	THQ	3881-80-1.6-THQ-7/1
	1/1.25	THQ	3881-80-1.6-THQ-1/1.25
	1.4/1.6	THQ	3881-80-1.6-THQ-1.4/1.6
	1.4/2	THQ	3881-80-1.6-THQ-1.4/2
	2/3	THQ	3881-80-1.6-THQ-2/3



Designed for special alloys, especially materials where the saw blade can easily jam, such as Inconel, Waspaloy, titanium and nickel-based alloys. Also works well on stainless steel and tool steels.

- Special interchangeable band saw blade
- Multi-span design for highest cutting performance in medium to large workpieces
- Wider set than standard, prevents jamming in the cut
- High/low offset teeth reduce cutting forces per tooth and ensure longer tool life
- Multiple chipbreaker due to 7 tooth pattern

THQ

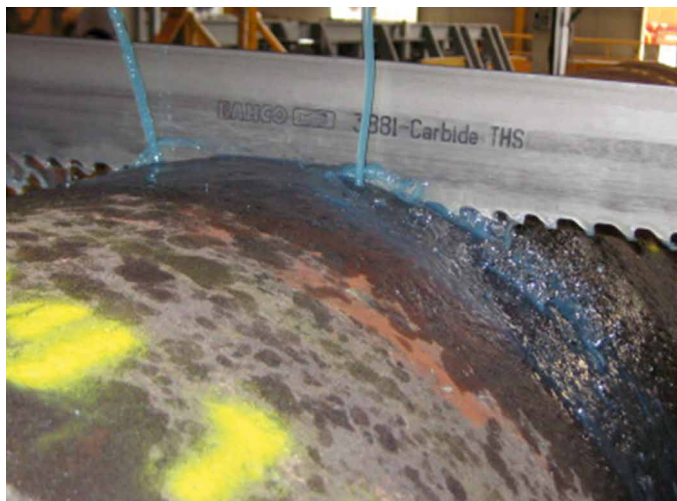


3881-THQ

Carbide Carbide

3881 THS

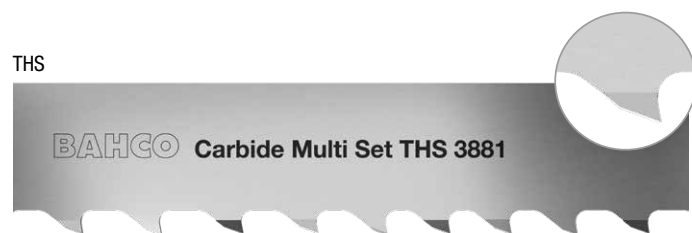
Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
34 x 1.1	2/3	THS	3881-34-1.1-THS-2/3
41 x 1.3	1.4/2	THS	3881-41-1.3-THS-1.4/2
54 x 1.6	1/1.25	THS	3881-54-1.6-THS-1/1.25
	1.4/2	THS	3881-54-1.6-THS-1.4/2
67 x 1.6	0.7/1	THS	3881-67-1.6-THS-7/1
	1/1.25	THS	3881-67-1.6-THS-1/1.25
	1.4/2	THS	3881-67-1.6-THS-1.4/2
	2/3	THS	3881-67-1.6-THS-2/3
80 x 1.6	0.7/1	THS	3881-80-1.6-THS-7/1
	1/1.25	THS	3881-80-1.6-THS-1/1.25
	1.4/2	THS	3881-80-1.6-THS-1.4/2
100 x 1.6	0.7/1	THS	3881-100-1.6-THS-7/1



This saw band is "pre-run" in the factory according to a patented method, which enables low-vibration sawing from the first cut. This enables the cutting of workpieces at an extremely low noise level.

- Multi-chip design for medium to large workpieces made of difficult-to-cut materials
- THS toothing is especially suitable for stainless steel
- Multi-chipping due to 7 tooth pattern
- Pre run in saw blade gives optimum cutting performance from the first cut
- Not suitable for sawing titanium
- Wide set

THS



Example for ordering a bandsaw blade:

Product code - Blade length in mm

Example:

3881-54-1.6-THQ-1/1.25-7500

Carbide Carbide

3860 TMC

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
41 x 1.3	1.4/2	TMC	3860-41-1.3-TMC-1.4/2
	2/3	TMC	3860-41-1.3-TMC-2/3
54 x 1.3	1.4/2	TMC	3860-54-1.3-TMC-1.4/2
	2/3	TMC	3860-54-1.3-TMC-2/3
54 x 1.6	1/1.25	TMC	3860-54-1.6-TMC-1/1.25
	1.4/2	TMC	3860-54-1.6-TMC-1.4/2
	2/3	TMC	3860-54-1.6-TMC-2/3
67 x 1.6	1/1.25	TMC	3860-67-1.6-TMC-1/1.25
	1.4/2	TMC	3860-67-1.6-TMC-1.4/2
	2/3	TMC	3860-67-1.6-TMC-2/3
80 x 1.6	0.7/1	TMC	3860-80-1.6-TMC-.7/1
	1/1.25	TMC	3860-80-1.6-TMC-1/1.25
	1.4/2	TMC	3860-80-1.6-TMC-1.4/2
100 x 1.1	1.4/2	TMC	3860-100-1.1-TMC-1.4/2



For highly efficient sawing of difficult-to-machine and abrasive materials. This unset carbide band saw blade is particularly suitable for abrasive materials such as Inconel and titanium.

- Unset band saw blade with positive rake angle
- Unset teeth for best surface finish
- High quality of backing material and carbide tips for best cutting performance and long service life
- Ground tooth tips for sharp cutting edges, especially important when sawing titanium
- High heat resistance for fast sawing even in large workpieces

TMC

BAHCO Unset Carbide TMC 3860

Coated Carbide Coated Carbide

NEW

3860 TMC - SUPERIOR

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
54 x 1.6	1/1.25	TMC	3860-54-1.6-TMC-1/1.25S
	1.4/2	TMC	3860-54-1.6-TMC-1.4/2S
	2/3	TMC	3860-54-1.6-TMC-2/3S
67 x 1.6	1/1.25	TMC	3860-67-1.6-TMC-1/1.25S
	1.4/2	TMC	3860-67-1.6-TMC-1.4/2S



These 54 mm and 67 mm TMC bandsaw blades are supplied in a coated version.

The coating allows you to work at a higher band speed and feed rate.

- Extremely high cutting performance
- Increased tool life
- High resistance to high temperatures

Other dimensions and qualities available on request.

TMC



Example for ordering a TMC band saw blade with superior coating:

S – with superior coating

Product code + **S** after the TPI specification - blade length in mm

Examples

Standard band saw blade:

3860-54-1.6-TMC-1.4/2-7200

with **superior** coating:

3860-54-1.6-TMC-1.4/2S-7200

Carbide Carbide

3860 TCD

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
27 x 0.9	3/4	TCD	3860-27-0.9-TCD-3/4
	3	TCD	3860-27-0.9-TCD-3
34 x 1.1	2/3	TCD	3860-34-1.1-TCD-2/3
	3/4	TCD	3860-34-1.1-TCD-3/4
	3/4	TCD	3860-34-1.1-TCD-3/4-W
41 x 1.3	1.4/2	TCD	3860-41-1.3-TCD-1.4/2
	1.9/2.1	TCD	3860-41-1.3-TCD-1.9/2.1
	2/3	TCD	3860-41-1.3-TCD-2/3
	3/4	TCD	3860-41-1.3-TCD-3/4
54 x 1.6	1.4/2	TCD	3860-54-1.6-TCD-1.4/2
	1.9/2.1	TCD	3860-54-1.6-TCD-1.9/2.1
	2/3	TCD	3860-54-1.6-TCD-2/3
	3/4	TCD	3860-54-1.6-TCD-3/4
67 x 1.6	1/1.25	TCD	3860-67-1.6-TCD-1/1.25
	1.4/2	TCD	3860-67-1.6-TCD-1.4/2
80 x 1.6	0.5/0.8	TCD	3860-80-1.6-TCD-.5/0.8

For sawing difficult and abrasive materials.

- Un set bandsaw blade with positive rake angle
- Specially developed multi-span design for highest cutting performance in titanium alloys
- Also suitable for stainless steels and aluminium
- Unset teeth for best surface finish and long service life
- Extra wide set on blades with W in end

TCD

BAHCO Unset Carbide TCD 3860



Carbide Carbide

3860 TCZ

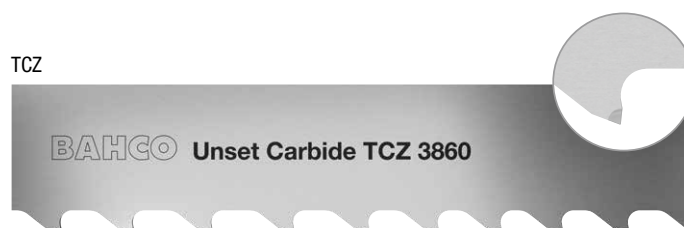
Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
27 x 0.9	3/4	TCZ	3860-27-0.9-TCZ-3/4
34 x 1.1	2/3	TCZ	3860-34-1.1-TCZ-2/3
	3/4	TCZ	3860-34-1.1-TCZ-3/4
41 x 1.3	2/3	TCZ	3860-41-1.3-TCZ-2/3
	3/4	TCZ	3860-41-1.3-TCZ-3/4

3860 TCZ developed for sawing both chrome plated and case hardened bars.

- Also suitable for non-metallic materials, e.g. graphite, which does not form chips when sawing
- Excellent resistance of the teeth
- Long tool life



TCZ



Carbide Carbide

NEW

3860 TCA

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
27 x 0.9	3	TCA	3860-27-0.9-TCA-3
34 x 1.1	0.8/1.0	TCA	3860-34-1.1-TCA-0.8/1.0
	1.4/2	TCA	3860-34-1.1-TCA-1.4/2
	2	TCA	3860-34-1.1-TCA-2
	2/3	TCA	3860-34-1.1-TCA-2/3
41 x 1.3	3	TCA	3860-34-1.1-TCA-3
	0.8/1.0	TCA	3860-41-1.3-TCA-0.8/1.0
	1.4/2	TCA	3860-41-1.3-TCA-1.4/2
54 x 1.6	2/3	TCA	3860-41-1.3-TCA-2/3
	0.8/1.0	TCA	3860-54-1.6-TCA-0.8/1.0
	1/1.25	TCA	3860-54-1.6-TCA-1/1.25
	1.4/2	TCA	3860-54-1.6-TCA-1.4/2
80 x 1.6	2/3	TCA	3860-54-1.6-TCA-2/3
	0.8/1.0	TCA	3860-80-1.5-TCA-0.8/1.0



Special band saw blade for aluminium.

- Un set band saw blade with positive rake angle
- Specially developed for cutting aluminium, also for large blocks
- Can also be used in foundries with CNC automatic saws
- Extended band life
- Better surface finish of the cut

TCA



Example for ordering a bandsaw blade:

Product code - Blade length in mm

Example:

3860-54-1.6-TCA-1.4/2-10668

BAHCO 

3860-TCA

Wavy Back

WB Wavy Back

The Bahco Wavy Back concept is a patented operation on a band saw that basically reduces the cutting area. This is accomplished by applying a wave to the back of the saw blade. This allows you to cut faster, and certainly increases the overall performance when sawing very difficult-to-cut materials.

Designed for the most difficult applications.

- Improve your productivity with the patented WBB - Wavy Back Band Saw.
- US Patent No. 9,731,366.
- Perfect for cutting larger areas of heat-resistant alloys.
- the WBB - Wavy Back Band Saw saves you money by cutting faster and having a longer service life.
- the WBB - Wavy Back Band Saw has a blade designed for specific applications.
- the WBB - Wavy Back concept can be applied to all Bahco Bi-metal and Carbide saw blades.
- Reduces the risk of premature defects due to heat build-up.
- Ideal for cutting hard materials such as:
 - Nickel alloys
 - Rene
 - Super alloys

Bahco's Bandsaw specialists will ensure that the WBB-Wavy Back Bandsaw cuts the most complex sawing work and exceeds your expectations!

Wavy Back can be applied to both bi-metal and carbide bandsaws. Ask your Bahco contact person about the options.



WB Wavy Back



Band saw blades for wood

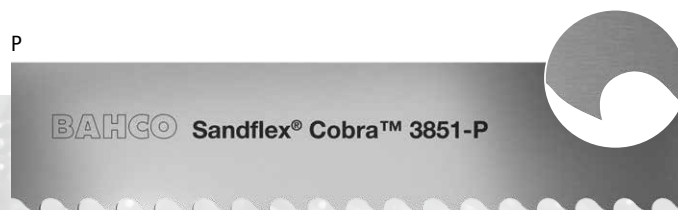
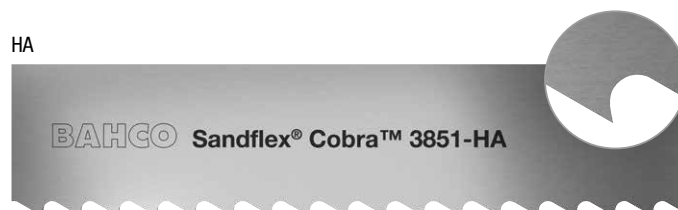
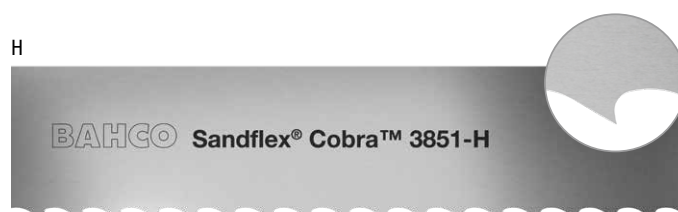
Universal

3851

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
6 x 0.6	6	H	3851-6-0.6-H-6
6 x 0.9	6	H	3851-6-0.9-H-6
10 x 0.6	4	H	3851-10-0.6-H-4
	6	H	3851-10-0.6-H-6
10 x 0.9	4	H	3851-10-0.9-H-4
	6	H	3851-10-0.9-H-6
13 x 0.6	3	H	3851-13-0.6-H-3
	4	H	3851-13-0.6-H-4
	6	H	3851-13-0.6-H-6
13 x 0.9	3	H	3851-13-0.9-H-3
	4	H	3851-13-0.9-H-4
	6	H	3851-13-0.9-H-6
20 x 0.9	3	H	3851-20-0.9-H-3
	4	H	3851-20-0.9-H-4
27 x 0.9	2	HA	3851-27-0.9-HA-2
	3	HA	3851-27-0.9-HA-3
	4	HA	3851-27-0.9-HA-4
34 x 1.1	2	P	3851-34-1.1-P-2
	3	P	3851-34-1.1-P-3

The universal saw blade with improved powder metallurgical tooth material has been developed for demanding applications. The traditional "Hook" tooth form is suitable for cutting non-ferrous metals, plastics and especially wood.

- Resistant blade back as well as heat-resistant and hard-wearing HSS tooth tips (M42), offer very high resistance to fatigue and torsion
- Specially designed tooth shapes for maximum cutting performance
- Longer life than conventional blades, so resharpening is required less often



Example for ordering a bandsaw blade:

Product code - Blade length in mm

Example:

3851-34-1.1-P-2-7200

Band saw blades for wood

Sandcut®

3861 Sandcut® Bi-metal

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
20 x 0.6	4	H	3861-20-0.6-H-4
27 x 0.9	1.33	H	3861-27-0.9-H-1.33
	2	H	3861-27-0.9-H-2-BIG
34 x 0.9	1.15	H	3861-34-0.9-H-1.15
	1.33	H	3861-34-0.9-H-1.33
	2	H	3861-34-0.9-H-2-BIG
34 x 1.1	1.15	H	3861-34-1.1-H-1.15
41 x 1.1	1.15	H	3861-41-1.1-H-1.15
54 x 1.1	1.15	H	3861-54-1.1-H-1.15



Sandcut® bi-metal saw blade with specially developed tooth shape for maximum cutting performance in wood.

- Resistant blade back and heat-resistant and hard-wearing HSS tooth tips, offer very high resistance to fatigue and twisting
- Longer life than conventional bandsaw blades, so resharpening is required less often

Sandcut® Bi-metal

BAHCO Sandcut Bi-Metal 3861

3862 Sandcut® Solid

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
33 x 0.9	1.15	H	3862-33-0.9-H-1.15
33 x 1.1	1.15	H	3862-33-1.1-H-1.15
40 x 1.1	1.15	H	3862-40-1.1-H-1.15



Hardened spring steel saw band ensures a good performance/cost ratio.

- Economical saw band from for cutting wood
- Fatigue resistant material with high resistance to torsion

Sandcut® Solid

BAHCO Sandcut Solid 3862

Pallet repair & dismantler blades

Designed for pallet industry

Pallet dismantler Bandsaw blades

Dimensions in mm (width x thickness)	TPI	Product code
34 x 1.1	5/8	M42-34-1.1-5/8-UB
54 x 1.3	4/6	3853-54-1.3-4/6



- Bandsaw blades designed for pallet disassembly saws.
- 34 mm, normally used on manual saws
- 54 mm normally used on robotic saws
- Cuts through nails and staples that are found in pallets.
- This tough bimetal blade withstands the cutting heat that quickly destroys the temper of carbon steel blades traditionally used to cut wood pallets and skids.
- It also stands up to the shock of interrupted cuts in pallets.

PF


 BAHCO Sandflex® Top Fabricator 3853

3940-PR Sandflex® Bi-Metal Sabre saw blades

Length (mm)	Thickness (mm)	TPI	Tooth pitch	Weight (g)	Product code
228	1.3	10/14	PR	408	3940-228-10/14-PR13-10P
228	0.9	10/14	PR	300	3940-228-10/14-PR09-10P
228	0.9	10/14	PR	2900	3940-228-10/14-PR09-100P
228	1.3	10/14	PR	4080	3940-228-10/14-PR13-100P
228	1.3	8/12	PR	4045	3940-228-8/12-PR13-100P
228	0.9	10	PR	2900	3940-228-10-PR09-100P



The pallet repair blade is developed in close cooperation with pallet repair shops

- Virtually unbreakable Sandflex® bi-metal blade for all materials and type of cut
- HSS toothing with 8% Cobalt
- This toothing has good material removal rate in wood with nails and high strength to tooth breakage
- By increasing the shank radius, we have improved the fatigue strength
- The unique front design prevents the blade front to get stuck in close by wood beams, when cutting nails in damaged parts of the pallet
- The packing quantities are 10 pieces or 100 pieces in plastic tubes



Bandsaw blades for mineral wool

Designed for insulation industry

3852 Sandflex® TwinTip Insulation Bandsaw

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Product code
27 x 0.9	3	INS	3852-27-0.9-INS-3
34 x 1.1	3	INS	3852-34-1.1-INS-3



Unique Designed Bandsaw Blade for Mineral Wool Insulation

- Special tooth design for cutting Mineral wool insulation
- Increased HSS tooth base improves the blade life compared to standard bandsaw blades
- Maximum cutting performance from the specially designed TwinTip tooth design
- Special TwinTip tooth shape reduces dust
- The tooth design with TwinTip increase abrasive wear resistance with increase blade life
- Increased hardness and surface treatment gives a combination of higher hardness and higher toughness for long tool life
- HSS tooth material for long tool life

Sandflex® Twin Tip



Accessories

3870 Chip brush



For cleaning the gaps between the teeth of the saw bands to ensure optimum cutting performance of the band. Correct use of the chip brush extends the service life of the band.

Product code	Outer diameter / bore
3870-BRUSH-60-6	60 / 6
3870-BRUSH-80-6	80 / 6
3870-BRUSH-80-8	80 / 8
3870-BRUSH-80-10	80 / 10
3870-BRUSH-100-10	100 / 10
3870-BRUSH-100-12	100 / 12
3870-BRUSH-100-13	100 / 13
3870-BRUSH-100-10-HEX	100 / HEX

3870 Wedge



The 75 mm long steel wedge prevents jamming of the saw band, for example when cutting materials in which high internal stresses occur.

Product code	Length
3870-WEDGE-3	75 mm, 3"

3870 Tensiometer



Correct blade tension is necessary to achieve straight cuts and long blade life, while reducing the cost per cut. The blade tension gauge allows easy, accurate measurement of the correct blade tension on all bandsaws.

Product code
3870-TENSION METER

3870 Refractometer



The correct concentration of cooling lubricant is just as important as the band speed or feed rate. It can be easily checked with the refractometer.

Product code
3870-REFRACTOMETER

3870 Tachometer



For instant determination of belt speed on an LED display. Measures in m/min & ft/min.

Product code
3870-TACHOMETER2

Software and accessories

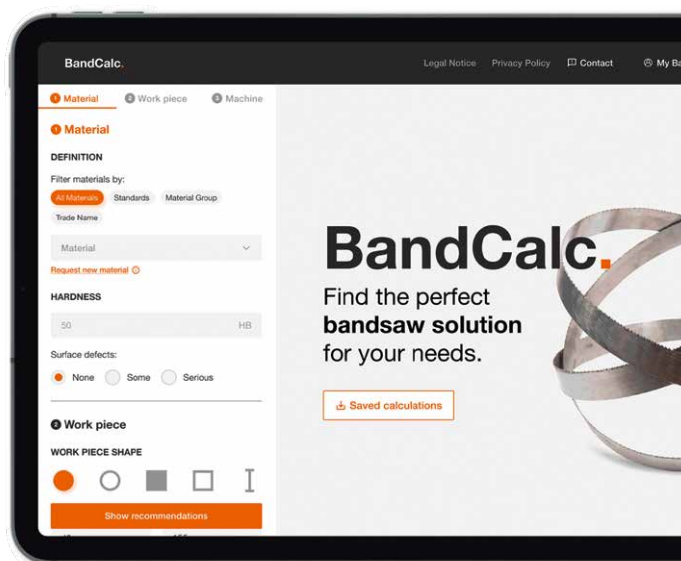
BandCalc™

Optimal saw band selection

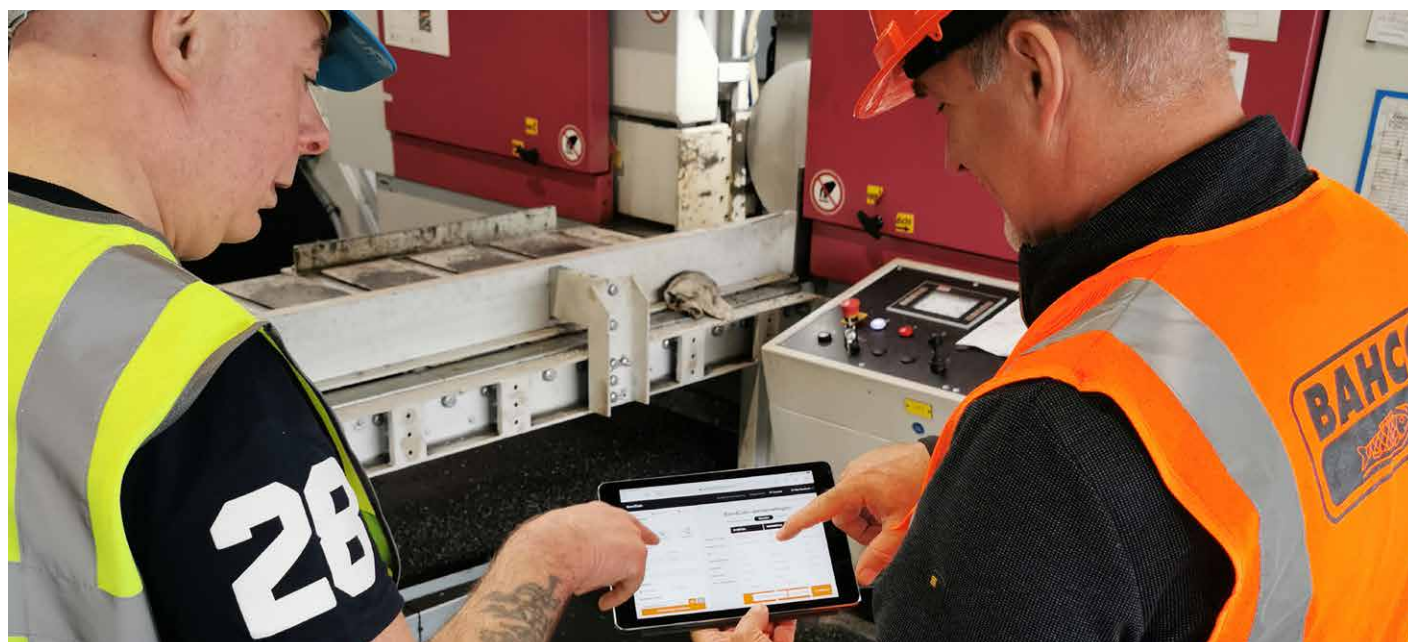
Selecting the right band saw blade is not always an easy task. With the help of our patented BandCalc™ software, you can quickly determine the right band saw blade for your application.

Select your cutting parameters and BandCalc™ calculates the most productive solution for your requirements.

The program helps select bandsaw blades for more than 2,500 bandsaw machines and makes recommendations regarding band speed, feed rate and cutting performance. BandCalc™ suggests a choice of TPI (teeth per inch) and modifies the cutting data accordingly to ensure that the user receives the optimum recommendation for each application.

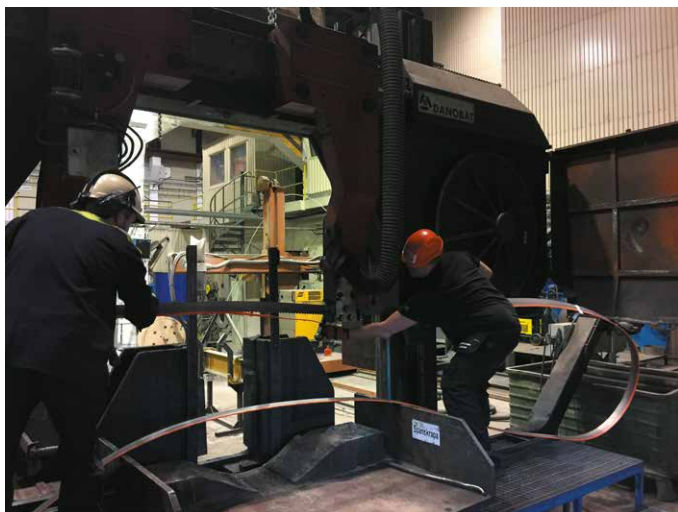


For more information and
free registration visit:
https://bandcalc.bahco.com/en_gb



Service

Your advantages at a glance



Personal customer service

Our application engineers and technical sales consultants will be happy to support you in optimising your sawing process and advise you on the use of our band saw blades.

- Get in touch with us:
E-mail: info@snaeurope.com



Training Center

We regularly hold training courses on the subject of band saw blades in our professional training centres.



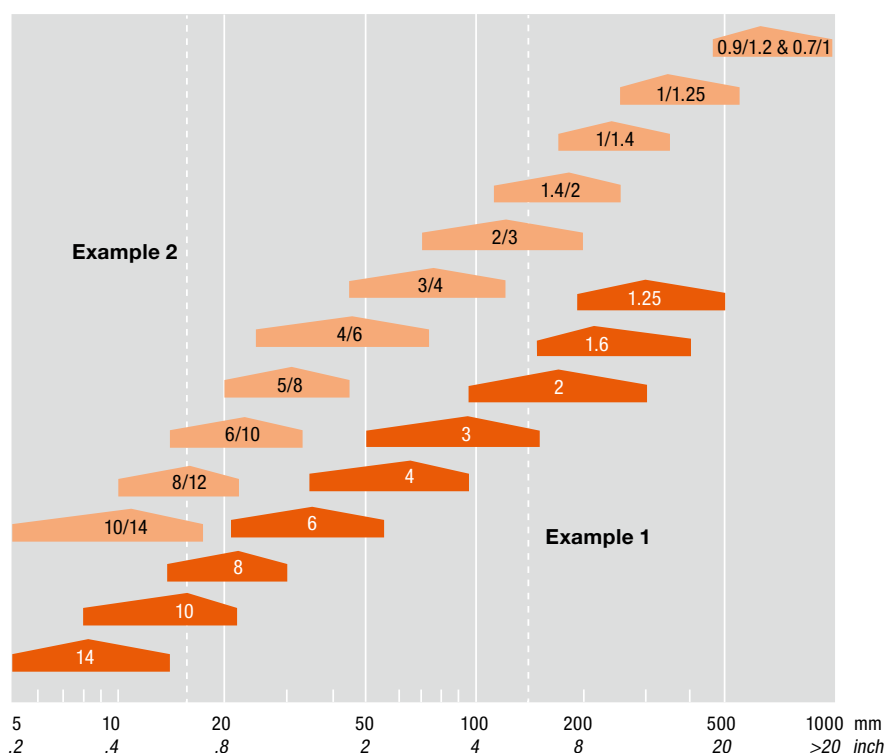
Short reaction and delivery times for special dimensions due to our own welding centres

We have strategically positioned our welding centres worldwide to provide our partners with a reliable and fast delivery service. Our welding centres are equipped with:

- High-tech welding machines and tempering control
- Automatic welding and grinding systems
- Quality laboratories

Selection guide

Tooth pitch



Tooth spacing for solid workpieces

The diagram helps you to select the correct tooth spacing for sawing solid workpieces. The ideal selection is represented by the widest point in each field.

Example 1:

When sawing a material with 150 mm Ø, use 2 TPI if you prefer a saw blade with constant tooth spacing. If you choose a band with variable tooth spacing, you should use 2/3 TPI or 1.4/2 TPI.

Example 2:

When sawing soft materials such as plastic, aluminium or wood, choose a tooth spacing that is two steps coarser than recommended.

To cut a 13-20 mm thick aluminium part, use a 5/8 TPI or 6 TPI bandsaw blade.

Cutting tubes and profiles

The recommended tooth pitch for sawing tubes and profiles can be found in the following table:

Outer diameter mm		20	40	60	80	90	100	110	120	130	140	150	160	170	180	190	200	220	250	300	350	400	500	600	700	800
Wall thickness mm		20	40	60	80	90	100	110	120	130	140	150	160	170	180	190	200	220	250	300	350	400	500	600	700	800
2		14/18	14/18	14/18	14/18	14/18	14/18	14/18	14/18	10/14	10/14	10/14	10/14	10/14	10/14	10/14	10/14	10/14	8/12	8/12	8/12	8/12	8/12	8/12	8/12	8/12
4		10/14	10/14	10/14	10/14	8/12	8/12	8/12	8/12	6/10	6/10	6/10	6/10	6/10	6/10	6/10	6/10	6/10	5/8	5/8	5/8	5/8	5/8	5/8	5/8	5/8
6		10/14	8/12	8/12	8/12	6/10	6/10	6/10	6/10	5/8	5/8	5/8	5/8	5/8	5/8	5/8	5/8	5/8	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6
8			6/10	6/10	6/10	5/8	5/8	5/8	5/8	5/8	5/8	5/8	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6
10			5/8	5/8	5/8	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4
15				5/8	4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4
25				4/6	4/6	4/6	4/6	4/6	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3
35					3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3
50									3/4	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3	2/3
65											2/3	2/3	2/3	2/3	2/3	2/3	1.4/2	1.4/2	1.4/2	1.4/2	1.4/2	1.4/2	1.4/2	1.4/2	1.4/2	1.4/2
75													2/3	2/3	2/3	2/3	2/3	2/3	1.4/2	1.4/2	1.4/2	1.4/2	1.4/2	1.4/2	1.4/2	1.4/2
100																			1.4/2	1.4/2	1.4/2	1.4/2	0.7/1	0.7/1	0.7/1	0.7/1
130																				1.4/2	1.4/2	1.4/2	0.7/1	0.7/1	0.7/1	0.7/1
150																					1.4/2	1.4/2	0.7/1	0.7/1	0.7/1	0.7/1

Selection guide

Band Speed

Bi-metal

Metres/minute at Ø mm

Material	10 – 65	100 – 300	400 – 800	> 1000	Coolant
Structural steels, free-cutting steels	100	85–95	60–75	40–60	6 %
Structural steels, quenched and tempered steels	80	70–80	60–68	40–50	6 %
Case hardening steels, spring steels, quenched and tempered steels	75–100	60–80	45–65	30–40	8 %
Non-alloy tool steel, ball bearing steel	60–65	55–60	35–45	25–35	8 %
High-speed steel	45–50	40–45	30–35	20–25	8 %
Cold work tool steel	30–35	25–30	20–25	15–20	DRY
Tool steels, alloyed	45–65	45–60	40–60	20–40	8 %
Nitriding steels, high-alloy hot work tool steels	40–45	35–40	25–30	20–25	8 %
Cast iron	50–60	45–50	30–40	25–30	DRY
Stainless and acid-resistant steels (light)	40–45	40–45	35–40	30–40	10 %
Stainless and acid resistant steels (heavy)	35–40	30–35	20–30	19–22	10 %
Duplex and hot work steels	25–30	20–25	15–20	14–16	10 %
Nickel and nickel-cobalt alloys	15–20	13–15	10–12	10	10 %
Titanium, titanium alloys, aluminium bronze	30–35	25–30	20–25	16–18	10 %
Horizontal machines, aluminium, aluminium alloys	120	120	120	120	25 %
Vertical machines, aluminium, aluminium alloys	3000	2100–2500	1250–2000	500–1200	25 %
Brass	120	120	90–120	80–100	4 %
Copper	120	110	80–100	60–80	15 %

The larger the material, the lower the speed

Carbide

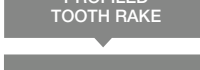
Metres/minute at Ø mm

Material	10 – 65	100 – 300	400 – 800	> 1000	Coolant
Structural steels, free-cutting steels	200	160–190	110–150	60–90	12 %
Structural steels, quenched and tempered steels	140	120–140	85–115	50–70	12 %
Case hardening steels, spring steels, quenched and tempered steels	120–130	110–120	75–110	40–60	10 %
Non-alloy tool steel, ball bearing steel	100–120	90–100	60–90	40–50	10 %
High-speed steel	100–110	80–90	60–75	50–60	10 %
Cold work tool steel	80–100	60–90	60–75	45–65	DRY
Tool steels, alloyed	85–95	80–90	60–70	50–60	8 %
Nitriding steels, high-alloy hot work tool steels	75–85	70–80	60–70	45–60	8 %
Cast iron	90–105	90–95	60–75	40–55	12 %
Stainless and acid-resistant steels (light)	80–110	80–100	70–95	65–80	12 %
Stainless and acid resistant steels (heavy)	80–90	70–80	60–70	40–50	13 %
Duplex and hot work steels	100–115	80–100	65–80	50–60	12 %
Nickel and nickel-cobalt alloys	30–40	25–30	20–28	15–20	12 %
Titanium, titanium alloys, aluminium bronze	50–60	40–50	35–45	16–18	12 %
Horizontal machines, aluminium, aluminium alloys	250	250	250	250	25 %
Vertical machines, aluminium, aluminium alloys	5000	4000–5000	3000–4000	2000–3000	25 %
Brass	250	250	180–240	140–160	4 %
Copper	240	220	130–190	100–120	15 %

The larger the material, the lower the speed

Selection guide

Toothpitch and material dimension

1 Inch / 2,5 cm	Number of teeth/inch	Solid Material 	Solid Material 	Profiles / tubes 
HIGH RAKE ANGLE	Recommended TPI	Cut diameter D (mm)	Cut Width W (mm)	Cut Width T (mm)
	1.0-1.25	300-600	300-600	X
	1.4-2	100-300	100-300	60-90
	2-3	60-200	60-200	30-60
	3-4	40-150	40-150	15-30
	4-6	25-80	25-80	25-80
	5-8	15-40	15-40	5-8
	6-10	15-30	15-30	4-6
	8-12	10-20	10-20	3-5
	10-14	7-15	7-15	2-3
	14	5-9	5-9	1-3
	18	0-5	0-5	0-2
PROFIED TOOTH RAKE	Recommended TPI	Cut diameter D (mm)	Cut Width W (mm)	Cut Width T (mm)
	2-3	70-200	70-200	15-40
	3-4	50-100	50-100	10-20
	4-6	30-70	30-70	4-15
	5-8	20-40	20-40	3-5
	8-11	2-10	2-10	1-3

BAHCO®



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