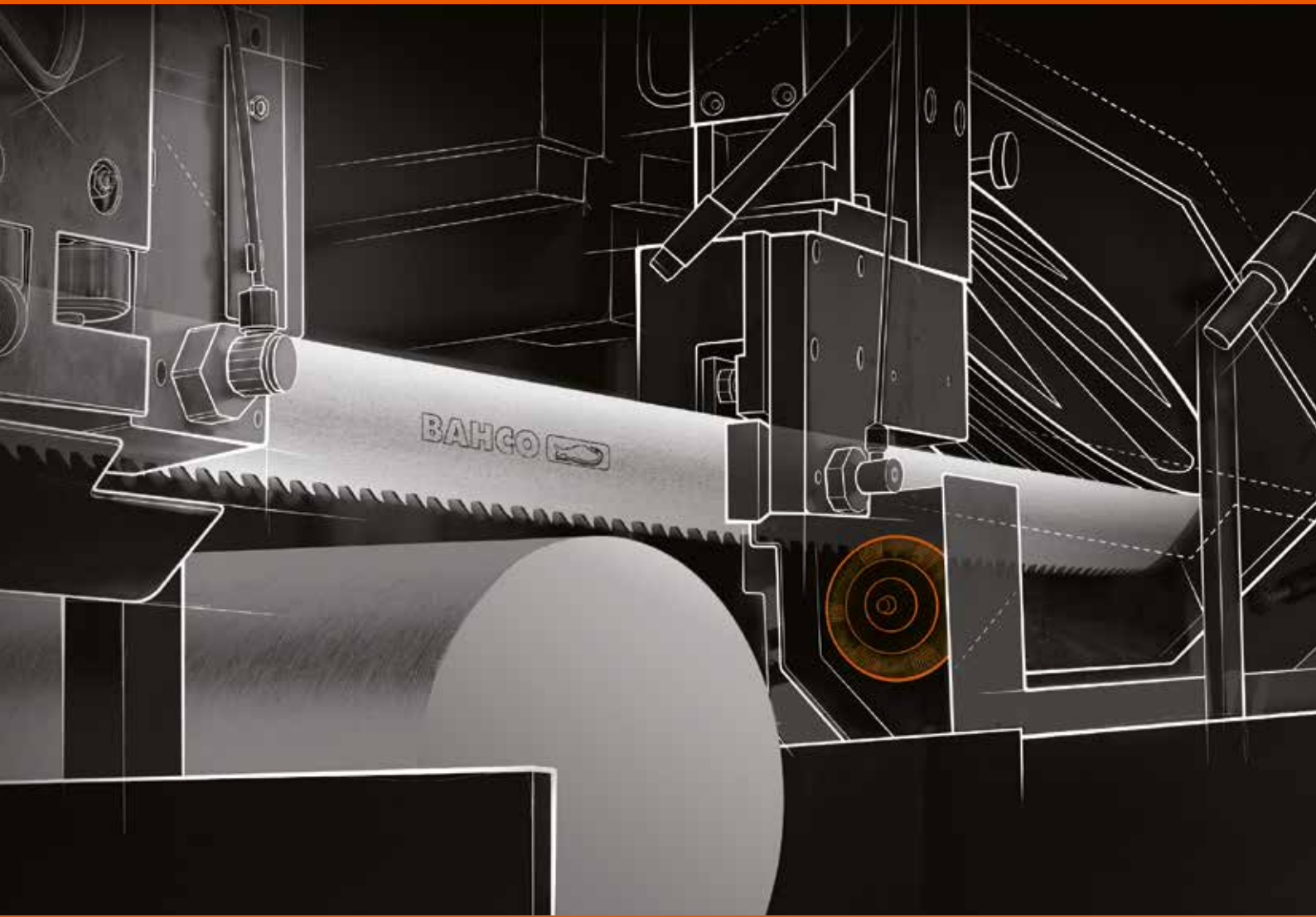
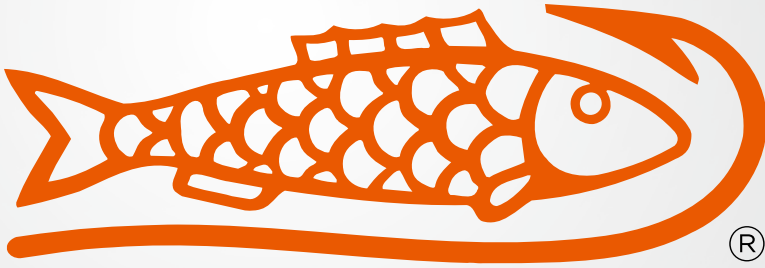


**BAHCO®**



***BANDSAWS***





# 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										Carbide									
	3851 PRX	3854 PHX	3854 PQ	3858 P9000 PHX	3858 P9000 PQ	3853 TOP Fabricator	3853 TOP Fabricator – W & WS	3857 Easy-Cut	3850 M42	3859 EZX	3869 TS	3868 TSX	3868 TSS	3881 THQ	3881 THS	3860 TMC on carbide-tipped machines	3860 TMC-S on carbide-tipped machines	3860 TCD on carbide-tipped machines	3860 TCZ on carbide-tipped machines	3860 TCA on carbide-tipped machines
Catalogue page	4	6	7	8	9	10	11	12	13	16	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!** Band saw blades specially developed for maximum cutting performance in wood.

# Bi-metal Sandflex®

## 3851 PRX

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

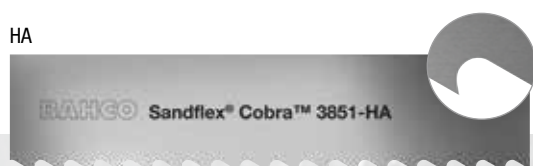
It is suitable for sawing a wide range of materials from aluminium to stainless steel. The stable tooth design ensures maximum cutting performance. Different tooth shapes are available depending on the application:

- **Hook:** Traditional tooth shape for cutting non-ferrous metals, wood and plastics
- **HA:** Further development of the Hook tooth design for cutting machining of 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

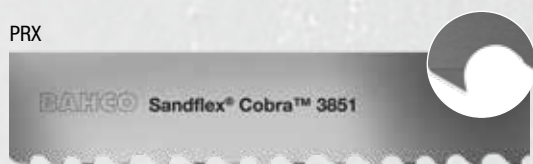
Hook



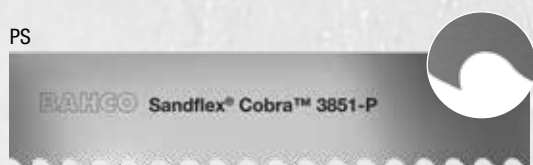
HA



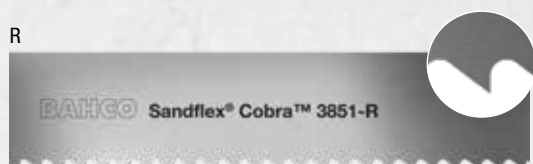
PRX



PS



R

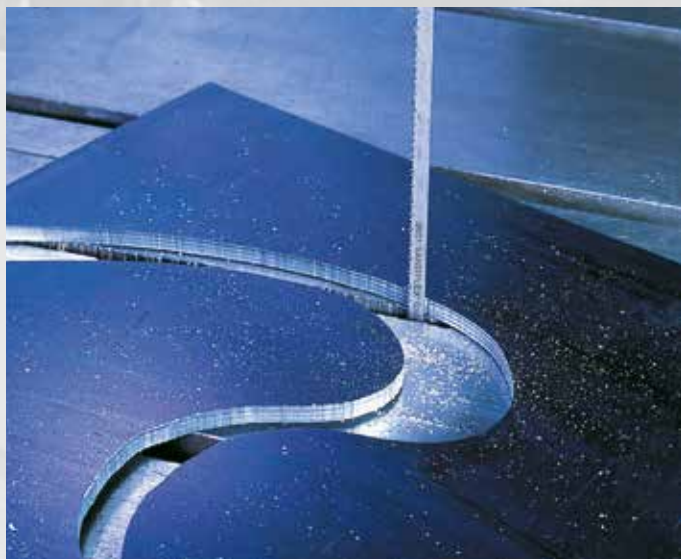


Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
6 x 0.6	6	Hook	<b>3851-6-0.6-H-6</b>
	10/14	PRX	<b>3851-6-0.6-10/14</b>
6 x 0.9	6	Hook	<b>3851-6-0.9-H-6</b>
	10/14	PRX	<b>3851-6-0.9-10/14</b>
10 x 0.6	4	Hook	<b>3851-10-0.6-H-4</b>
	6	Hook	<b>3851-10-0.6-H-6</b>
	10/14	PRX	<b>3851-10-0.6-10/14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

# Bi-metal Sandflex®

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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	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
	10/14	PRX	3851-27-0.9-10/14
34 x 1.1	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	Order number
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	.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	.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

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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	.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	.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	.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



# Bi-metal Sandflex®

## 3854 PQ™

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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	.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	.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	.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 in 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



# Bi-metal Sandflex®

## 3858 P9000 PHX

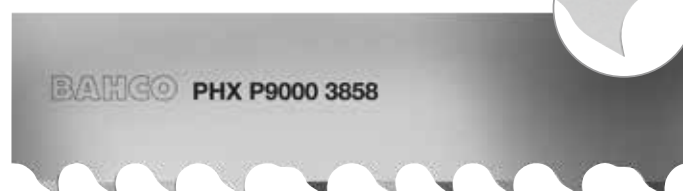
Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
34 x 1.1	1.4/2	PHX	3858-34-1.1-PHX-1.4/2
	2/3	PHX	3858-34-1.1-PHX-2/3
	3/4	PHX	3858-34-1.1-PHX-3/4
41 x 1.3	1.4/2	PHX	3858-41-1.3-PHX-1.4/2
	2/3	PHX	3858-41-1.3-PHX-2/3
	3/4	PHX	3858-41-1.3-PHX-3/4
54 x 1.3	1.4/2	PHX	3858-54-1.3-PHX-1.4/2
	2/3	PHX	3858-54-1.3-PHX-2/3
	3/4	PHX	3858-54-1.3-PHX-3/4
54 x 1.6	.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	.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	.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





# Bi-metal Sandflex®

## 3858 P9000 PQ™

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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	.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	.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	.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



# Bi-metal Sandflex®

## 3853 TOP Fabricator™

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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
- Significantly reduces:
  - stray cuts
  - broken teeth
  - vibrations
  - wedging

PF



# Coated Bi-metal Sandflex®

## 3853 TOP Fabricator™ – with wide set (W)

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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
- Excellent tool life
- Extra wide set prevents jamming on large workpieces with inherent tension

**NEW**

## 3853 TOP Fabricator™ – with superior coating (S)

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
54 x 1.6	3/4	PF	3853-54-1.6-3/4S
	4/6	PF	3853-54-1.6-4/6S

- Superior coating for even higher cutting performance
- Very good resistance to high temperatures
- Excellent tool life

## 3853 TOP Fabricator™ – with wide set and superior coating (WS)

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
41 x 1.3	2/3	PF	3853-41-1.3-2/3-WS
	3/4	PF	3853-41-1.3-3/4-WS
54 x 1.6	2/3	PF	3853-54-1.6-2/3-WS
	3/4	PF	3853-54-1.6-3/4-WS
67 x 1.6	2/3	PF	3853-67-1.6-2/3-WS
	3/4	PF	3853-67-1.6-3/4-WS

- Superior coating for even higher cutting performance
- Extra wide set prevents jamming on large workpieces with inherent tension
- Very good resistance to high temperatures
- Excellent tool life



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

Article number + 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**

Band saw blade with superior coating:

**3853-54-1.6-3/4S-6300**

Band saw blade with wide set & superior coating:

**3853-41-1.3-3/4-WS-6300**

# Bi-metal Easy-Cut

## 3857 Easy-Cut

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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 hand tools.

Dimensions in mm (width x thickness)	Tooth pitch	Blade length	Tooth shape	Order number
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).

Order number	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

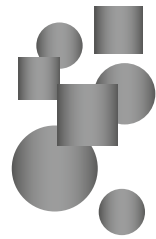


## 3850 M42

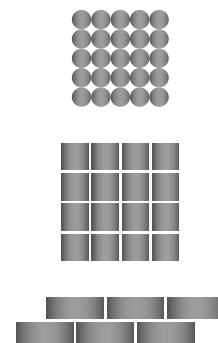
Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
13 x 0.6	6/10	Combo	3850-13-0.6-6/10
	8/12	Combo	3850-13-0.6-8/12
	10/14	Combo	3850-13-0.6-10/14
	14/18	Combo	3850-13-0.6-14/18
13 x 0.9	6/10	Combo	3850-13-0.9-6/10
	8/12	Combo	3850-13-0.9-8/12
20 x 0.9	4/6	Combo	3850-20-0.9-4/6
	5/8	Combo	3850-20-0.9-5/8
	6/10	Combo	3850-20-0.9-6/10
	8/12	Combo	3850-20-0.9-8/12
	10/14	Combo	3850-20-0.9-10/14
27 x 0.9	2/3	Combo	3850-27-0.9-2/3
	3/4	Combo	3850-27-0.9-3/4
	4/6	Combo	3850-27-0.9-4/6
	5/8	Combo	3850-27-0.9-5/8
	6/10	Combo	3850-27-0.9-6/10
	8/12	Combo	3850-27-0.9-8/12
	10/14	Combo	3850-27-0.9-10/14
34 x 1.1	2/3	Combo	3850-34-1.1-2/3
	3/4	Combo	3850-34-1.1-3/4
	4/6	Combo	3850-34-1.1-4/6
	5/8	Combo	3850-34-1.1-5/8
	6/10	Combo	3850-34-1.1-6/10
	8/12	Combo	3850-34-1.1-8/12
41 x 1.3	2/3	Combo	3850-41-1.3-2/3
	3/4	Combo	3850-41-1.3-3/4
	4/6	Combo	3850-41-1.3-4/6
	5/8	Combo	3850-41-1.3-5/8
	6/10	Combo	3850-41-1.3-6/10
54 x 1.6	1.4/2	Combo	3850-54-1.6-1.4/2
	2/3	Combo	3850-54-1.6-2/3
	3/4	Combo	3850-54-1.6-3/4
	4/6	Combo	3850-54-1.6-4/6

Universal bi-metal saw blade with vibration-damping, variable tooth pitch made of particularly wear-resistant HSS bi-metal M42. Suitable for cutting small, medium and also larger workpieces, for high productivity when cutting solid materials, profiles, etc. cutting solid materials, profiles, bundles and tubes as well as for demanding workshop use.

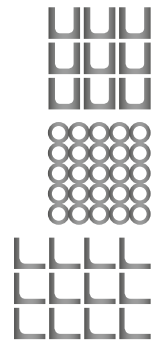
- Precise tooth setting ensures clean surface finish and long blade life
- Durable blade spine and M42 tooth cutting material ensure excellent cutting properties



Thick bar steel



Small, solid workpieces and bundles



Tubes, cast profiles





# Carbide Easy-Cut Xtreme TriMetal

**NEW**

## 3859 Carbide Easy-Cut EZX

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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

EZX





# Carbide Carbide

## 3869 TS

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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



# Carbide Carbide

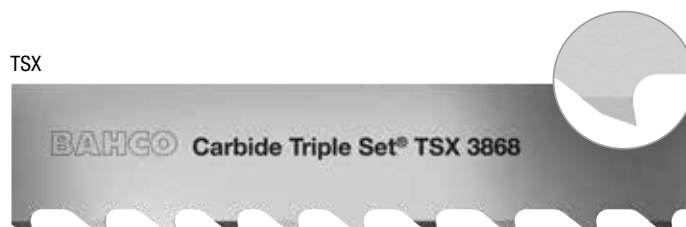
## 3868 TSX

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

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



# Carbide Carbide

## 3868 TSS

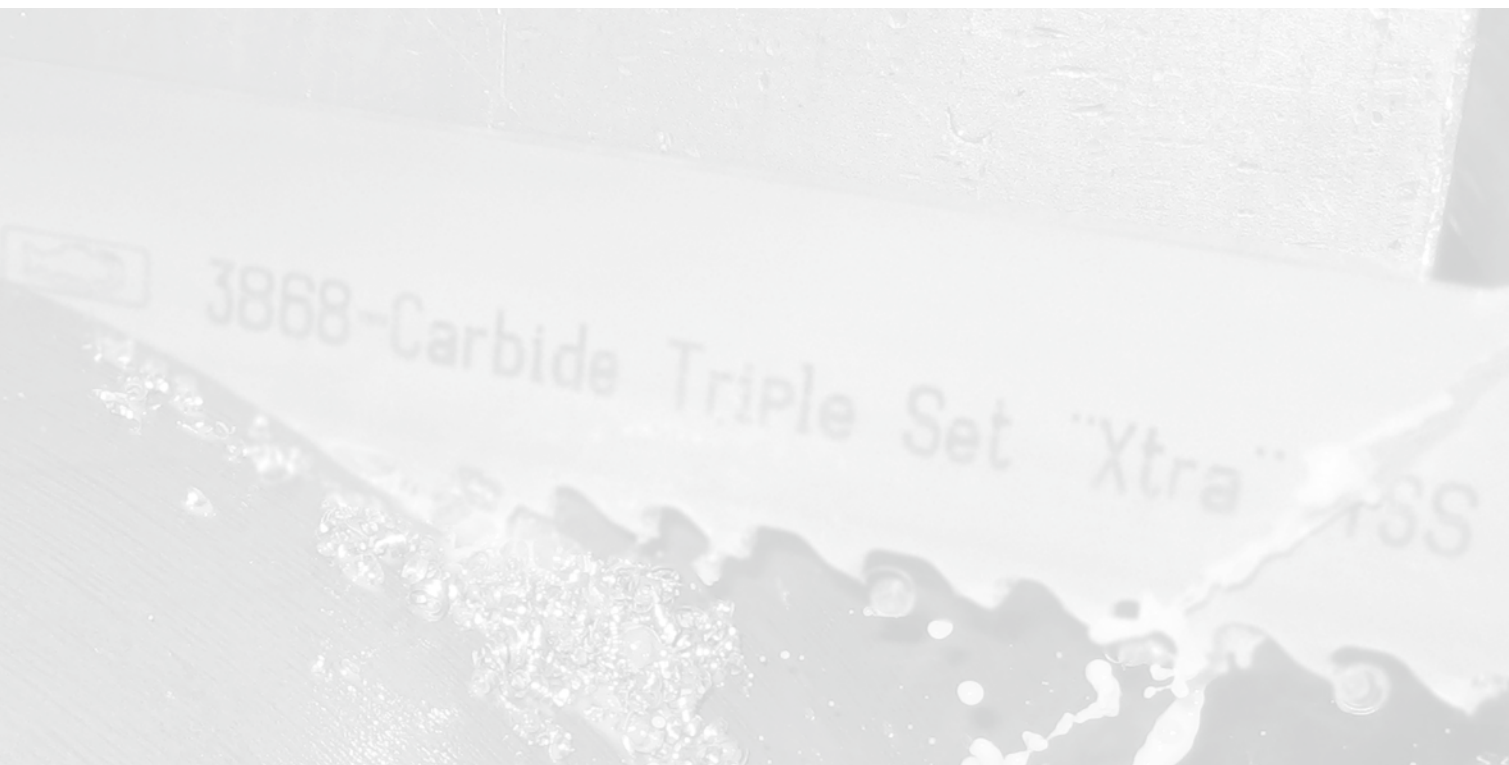
Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
27 x 0.9	3/4	TSS	3868-27-0.9-TSS-3/4
34 x 1.1	2/3	TSS	3868-34-1.1-TSS-2/3
	3/4	TSS	3868-34-1.1-TSS-3/4
41 x 1.3	1.4/2	TSS	3868-41-1.3-TSS-1.4/2
	2/3	TSS	3868-41-1.3-TSS-2/3
54 x 1.6	1/1.25	TSS	3868-54-1.6-TSS-1/1.25
	1.4/2	TSS	3868-54-1.6-TSS-1.4/2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



# Carbide Carbide

## 3881 THQ

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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	.7/1	THQ	3881-80-1.6-THQ-.7/1
	1/1.25	THQ	3881-80-1.6-THQ-1/1.25
	1.4/2	THQ	3881-80-1.6-THQ-1.4/2
	1.4/1.6	THQ	3881-80-1.6-THQ-1.4/1.6
	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

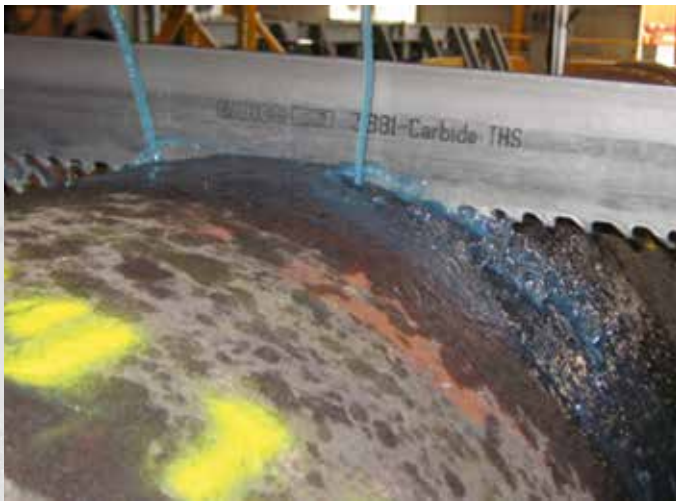
# Carbide Carbide

## 3881 THS

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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	.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	.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	.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



# Carbide Carbide

## 3860 TMC

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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	1/1.25	TMC	3860-80-1.6-TMC-1/1.25
	1.4/2	TMC	3860-80-1.6-TMC-1.4/2
	.7/1	TMC	3860-80-1.6-TMC-.7/1
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



# Coated Carbide Coated Carbide

## 3860 TMC - SUPERIOR

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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	1.4/2	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.



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

**S** – with superior coating

Article number + **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-7.200**

# Carbide Carbide

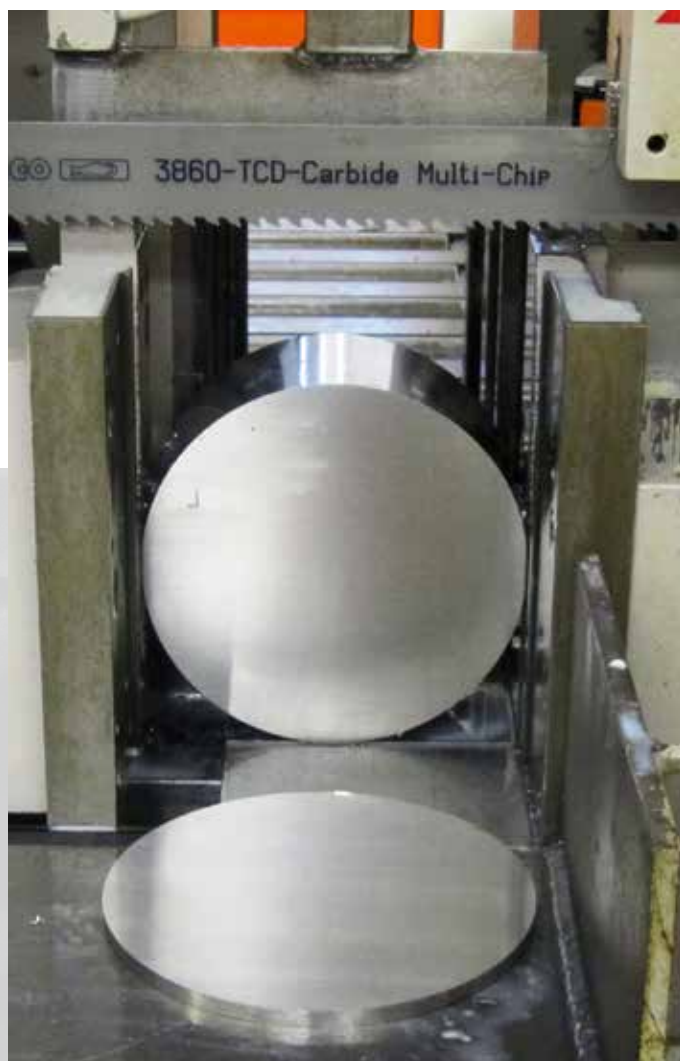
## 3860 TCD

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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	.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
- Un set teeth for best surface finish and long service life

TCD





# Carbide Carbide

## 3860 TCZ

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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

## 3860 TCA

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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
	2	TCA	3860-34-1.1-TCA-2
	3	TCA	3860-34-1.1-TCA-3
41 x 1.3	2/3	TCA	3860-34-1.1-TCA-2/3
	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
	1.4/2	TCA	3860-54-1.6-TCA-1.4/2
54 x 1.6	1/1.25	TCA	3860-54-1.6-TCA-1/1.25
	1.4/2	TCA	3860-54-1.6-TCA-1.4/2

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



# Wavy Back

## WB Wavy Back

The patented, wavy back reduces the contact between the saw blade and the workpiece. This results in less stress on the teeth, which leads to less wear and greater efficiency. This also greatly improves the sawing of difficult to cut materials, such as Inconel.

This technique can be used with bi-metal and carbide belts.

- Longer life
- Improved surface finish
- Faster and more precise cuts
- Noise reduction during sawing
- US Patent No. 9,731,366
- WB is manufactured individually according to customer requirements
- WB can be used with all bi-metal or carbide bandsaw blades
- Ideal for high temperature nickel alloys
- Ideal for superalloys

**The band saw blade is manufactured individually for your application. Please ask for your personal offer.**

Necessary information:

- Machine type
- Material to be cut (quality, diameter)
- Blade length, height, thickness, tooting
- Distance between the guides when sawing



WB Wavy Back



# Band saw blades for wood

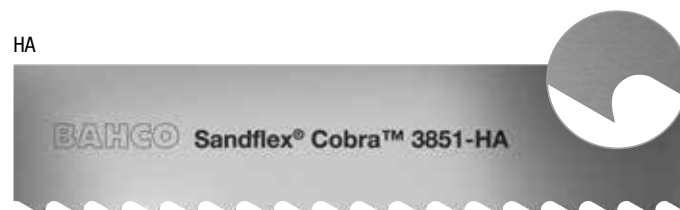
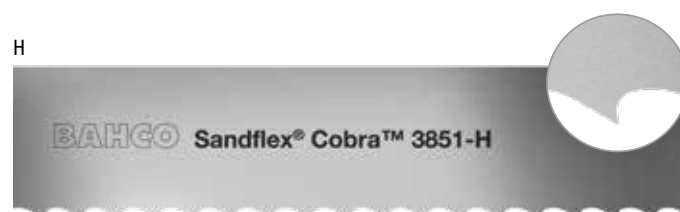
## Universal

**NEW**
**3851**

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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



# Band saw blades for wood

## Sandcut®

**NEW**

### 3861 Sandcut® Bi-metal

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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



### 3862 Sandcut® Solid

Dimensions in mm (width x thickness)	Tooth pitch	Tooth form	Order number
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



**NEW**

# 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.

Order number	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.

## 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.

Order number	Length
3870-WEDGE-3	75 mm, 3"

Order number
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.

## 3870 Tachometer



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

Order number
3870-REFRACTOMETER

Order number
3870-TACHO METER



# Software and accessories

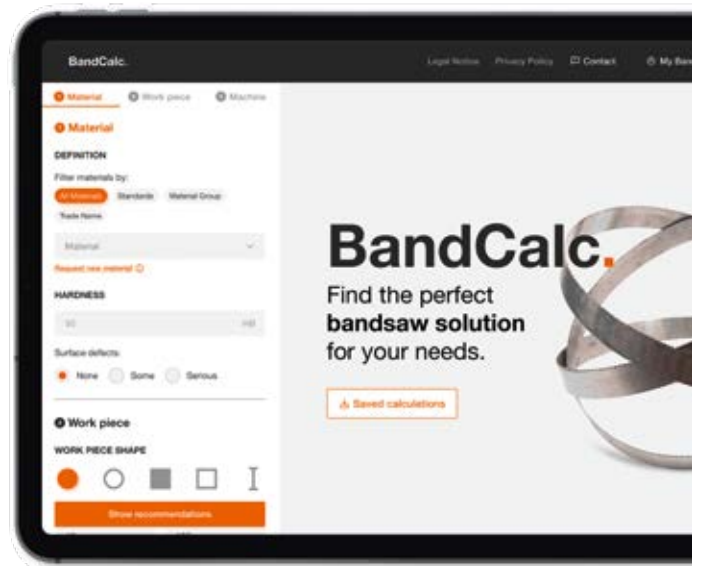
## BandCalc™

### 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.

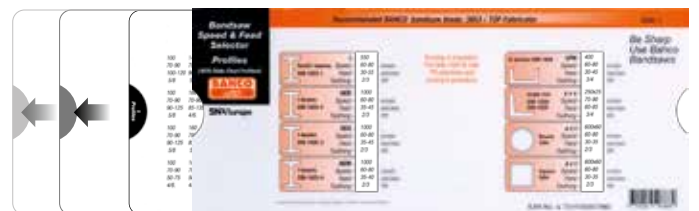
The program helps select bandsaw blades for more than 2,500 bandsaw machines and makes recommendations regarding band speed, feed rate and cutting performance. BandCalc™ suggests a choice of TPI (teeth per inch) and modifies the cutting data accordingly to ensure that the user receives the optimum recommendation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



### Data sliders for metal saw blades

The cutting data sliders for bi-metal and carbide bandsaw blades, as well as for tubes and profiles, offer practical help in determining the cutting parameters.

Order number	Application
3870-SLIDECHART	Bi-metal
3870-SLIDECHART-CARBIDE	Carbide
3870-SLIDECHART-PROFILES	Profiles





# 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:  
Tel: +44 (0) 1709 731731  
E-Mail: [info.uk@snaeurope.com](mailto:info.uk@snaeurope.com)



### **Training centre**

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



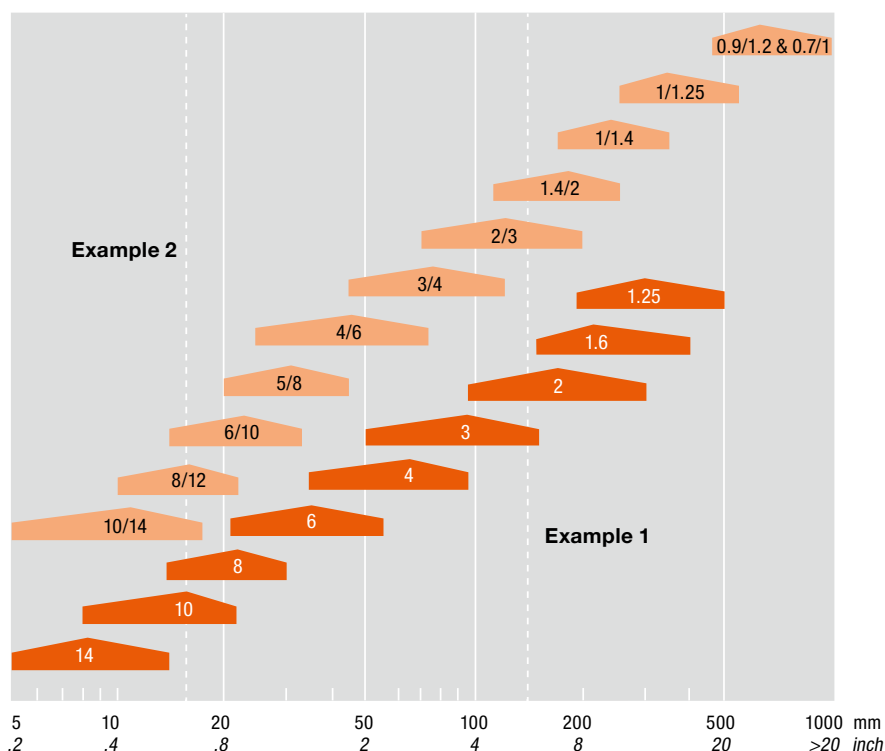
### **Short reaction and delivery times for special dimensions due to our own welding centres**

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 ZpZ if you prefer a saw blade with constant tooth spacing. If you choose a band with variable tooth spacing, you should use 2/3 ZpZ or 1.4/2 ZpZ.

#### 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 ZpZ or 6 ZpZ band.

### Cutting tubes and profiles

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

Wall thickness mm	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
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

## Belt 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

# BAHCO®

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