



Industrial Metalsawing



Bandsaw Blades



Welcome to the Bahco Bandsaw Blade Catalog

We are pleased to present the latest assortment of Bahco industrial bandsaw blades. Our dedication to research and development has resulted in a wide range of cutting solutions. Whether you represent a machine shop, foundry, or general purpose bandsaw user, there is a Bahco bandsaw blade designed to reduce your cost per cut.

Let us cater a blade to your specific cutting needs. Do you supply the military or aerospace industries? Are you working with hard-to-cut, advanced alloys such as Titanium? Consider one of our patented carbide-tipped products such as the 3860 TMC. Or are you more of a general purpose cut shop, cutting a wide variety of materials, shapes and sizes? Our unique 3857 Easy-Cut ensures long blade life and fewer blade changes.

Quality. Consistency. Bahco strives to maintain the quality of its products and deliver cost per cut savings consistently. We do so by operating in a quality forward system, using the ISO 9001-2000 framework. We take a Rapid Continuous Improvement (RCI) approach to our production processes, which reflects in the quality and performance of our product.

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Our Bandsaw Manufacturing Processes

Tooth Forming

High technology milling and grinding processes are used for precision tooth forming, enabling the production of sharper and stronger teeth.

Setting

Computer controlled measuring devices and camera monitoring systems check every tooth. This information is collated and displayed on a visual monitor which:

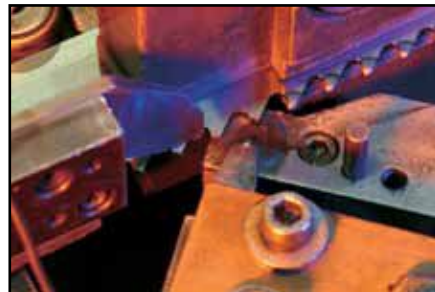
- Measures the set against the permissible tolerance (has an automatic shut-off function)
- Ensures a highly consistent set
- Provides a traceability for every coil
- Creates a permanent record in our quality data base



Heat Treatment

The latest technology heat treatment processes ensure:

- High consistency
- Easier welding alignment
- Tighter manufacturing tolerances



Research and Development

The Research & Development (R & D) department has been paramount in Bahco becoming a global leader in bandsaw blade technology. With increased demands of the machines, the material, and the industry, Bahco is ready for the challenge.

Our state-of-the-art facility is located in Lidköping, Sweden, and is capable of testing our products against some of the world's toughest materials.

The center is actively involved in research activities, such as the joint study of metal cutting with a major university to improve and better understand the science of the industry.

Research & Development works side-by-side with end users on specific applications to develop sawing solutions for the future.



For less demanding applications.

Flexback Carbon Steel Blades - Hook Teeth

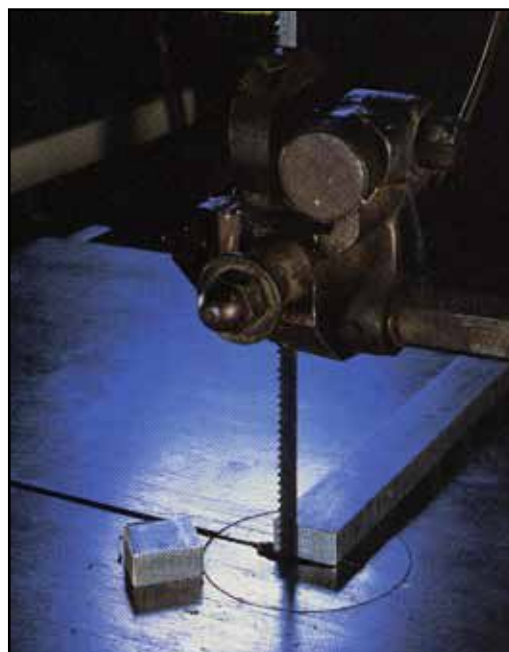
DIMENSIONS INCHES	MM	TEETH PER INCH	PRODUCT CODE
1/4 x .025	6 x 0.6	4	3849-6-0.6-H-4
1/4 x .025	6 x 0.6	6	3849-6-0.6-H-6
3/8 x .025	10 x 0.6	3	3849-10-0.6-H-3
3/8 x .025	10 x 0.6	4	3849-10-0.6-H-4
3/8 x .025	10 x 0.6	6	3849-10-0.6-H-6
1/2 x .025	13 x 0.6	3	3849-13-0.6-H-3
1/2 x .025	13 x 0.6	4	3849-13-0.6-H-4
1/2 x .025	13 x 0.6	6	3849-13-0.6-H-6
3/4 x .032	20 x 0.8	3	3849-20-0.8-H-3
3/4 x .032	20 x 0.8	6	3849-20-0.8-H-6
1 x .035	25 x 0.9	2	3849-25-0.9-H-2
1 x .035	25 x 0.9	3	3849-25-0.9-H-3

High Hard Carbon Steel Blades - Regular Teeth

DIMENSIONS INCHES	MM	TEETH PER INCH	PRODUCT CODE
1/4 x .025	6 x 0.6	10	3847-6-0.6-R-10
1/4 x .025	6 x 0.6	14	3847-6-0.6-R-14
1/4 x .025	6 x 0.6	18	3847-6-0.6-R-18
1/4 x .025	6 x 0.6	24	3847-6-0.6-R-24
3/8 x .025	10 x 0.6	8	3847-10-0.6-R-8
3/8 x .025	10 x 0.6	10	3847-10-0.6-R-10
3/8 x .025	10 x 0.6	14	3847-10-0.6-R-14
3/8 x .025	10 x 0.6	18	3847-10-0.6-R-18
1/2 x .025	13 x 0.6	6	3847-13-0.6-R-6
1/2 x .025	13 x 0.6	10	3847-13-0.6-R-10
1/2 x .025	13 x 0.6	14	3847-13-0.6-R-14
1/2 x .025	13 x 0.6	18	3847-13-0.6-R-18
1/2 x .025	13 x 0.6	24	3847-13-0.6-R-24
3/4 x .032	20 x 0.8	6	3847-20-0.8-R-6
3/4 x .032	20 x 0.8	8	3847-20-0.8-R-8
3/4 x .032	20 x 0.8	10	3847-20-0.8-R-10
3/4 x .032	20 x 0.8	14	3847-20-0.8-R-14
3/4 x .032	20 x 0.8	18	3847-20-0.8-R-18
1 x .035	25 x 0.9	6	3847-25-0.9-R-6
1 x .035	25 x 0.9	8	3847-25-0.9-R-8
1 x .035	25 x 0.9	10	3847-25-0.9-R-10
1 x .035	25 x 0.9	14	3847-25-0.9-R-14

Friction Cutting

DIMENSIONS INCHES	MM	TEETH PER INCH	PRODUCT CODE
1 x .035	25 x 0.9	10	3858-25-0.9-R-10



Manufactured from M42 High Speed Steel for durability and longer tool life.

- Perfect for solids, bundles, pipes, profiles and castings
- Multi-purpose tooth shapes for a variety of applications
- Designed for production and general purpose sawing



Combo tooth shape traditional shape tooth with 0° rake angle. Suitable for multipurpose cutting of thin-walled tubes and profiles in most materials.



Combo PR, with a 5-10° rake angle, is mainly used on medium sized to large workpieces when vibration may occur.



Hook. Traditional tooth design with 10° rake angle, used for non-ferrous metals, wood and plastics.

Sandflex[®] M42

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1/4 x .025	6 x 0.6	10/14	Combo	M42-6-0.6-10/14
1/4 x .025	6 x 0.6	14/18	Combo	M42-6-0.6-14/18
1/4 x .025	6 x 0.6	6	Hook	M42-6-0.6-H-6
1/4 x .035	6 x 0.9	10/14	Combo	M42-6-0.9-10/14
1/4 x .035	6 x 0.9	6	Hook	M42-6-0.9-H-6
3/8 x .025	10 x 0.6	10/14	Combo	M42-10-0.6-10/14
3/8 x .025	10 x 0.6	4	Hook	M42-10-0.6-H-4
3/8 x .025	10 x 0.6	6	Hook	M42-10-0.6-H-6
3/8 x .035	10 x 0.9	10/14	Combo	M42-10-0.9-10/14
3/8 x .035	10 x 0.9	4	Hook	M42-10-0.9-H-4
3/8 x .035	10 x 0.9	6	Hook	M42-10-0.9-H-6
1/2 x .020	13 x 0.5	10/14	Combo	M42-13-0.5-10/14
1/2 x .020	13 x 0.5	14/18	Combo	M42-13-0.5-14/18
1/2 x .025	13 x 0.6	10/14	Combo	M42-13-0.6-10/14
1/2 x .025	13 x 0.6	6/10	Combo	M42-13-0.6-6/10
1/2 x .025	13 x 0.6	8/12	Combo	M42-13-0.6-8/12
1/2 x .025	13 x 0.6	14/18	Combo	M42-13-0.6-14/18
1/2 x .025	13 x 0.6	3	Hook	M42-13-0.6-H-3
1/2 x .025	13 x 0.6	4	Hook	M42-13-0.6-H-4
1/2 x .025	13 x 0.6	6	Hook	M42-13-0.6-H-6
1/2 x .035	13 x 0.9	10/14	Combo	M42-13-0.9-10/14
1/2 x .035	13 x 0.9	6/10	Combo	M42-13-0.9-6/10
1/2 x .035	13 x 0.9	3	Hook	M42-13-0.9-H-3
1/2 x .035	13 x 0.9	4	Hook	M42-13-0.9-H-4
1/2 x .035	13 x 0.9	6	Hook	M42-13-0.9-H-6
3/4 x .035	20 x 0.9	10/14	Combo	M42-20-0.9-10/14
3/4 x .035	20 x 0.9	4/6	Combo	M42-20-0.9-4/6
3/4 x .035	20 x 0.9	5/8	Combo	M42-20-0.9-5/8
3/4 x .035	20 x 0.9	6/10	Combo	M42-20-0.9-6/10
3/4 x .035	20 x 0.9	8/12	Combo	M42-20-0.9-8/12
1 x .035	27 x 0.9	10/14	Combo	M42-27-0.9-10/14
1 x .035	27 x 0.9	2/3	Combo	M42-27-0.9-2/3
1 x .035	27 x 0.9	3/4	Combo	M42-27-0.9-3/4
1 x .035	27 x 0.9	4/6	Combo	M42-27-0.9-4/6
1 x .035	27 x 0.9	5/8	Combo	M42-27-0.9-5/8
1 x .035	27 x 0.9	6/10	Combo	M42-27-0.9-6/10
1 x .035	27 x 0.9	8/12	Combo	M42-27-0.9-8/12
1-1/4 x .042	34 x 1.1	2/3	Combo	M42-34-1.1-2/3
1-1/4 x .042	34 x 1.1	3/4	Combo	M42-34-1.1-3/4
1-1/4 x .042	34 x 1.1	4/6	Combo	M42-34-1.1-4/6
1-1/4 x .042	34 x 1.1	5/8	Combo	M42-34-1.1-5/8
1-1/4 x .042	34 x 1.1	6/10	Combo	M42-34-1.1-6/10
1-1/2 x .050	41 X 1.3	2/3	Combo	M42-41-1.3-2/3
1-1/2 x .050	41 X 1.3	3/4	Combo	M42-41-1.3-3/4
1-1/2 x .050	41 X 1.3	4/6	Combo	M42-41-1.3-4/6
1-1/2 x .050	41 X 1.3	5/8	Combo	M42-41-1.3-5/8
1-1/2 x .050	41 X 1.3	6/10	Combo	M42-41-1.3-6/10
2 x .062	54 x 1.6	1.4/2	Combo PR	M42-54-1.6-1.4/2
2 x .062	54 x 1.6	2/3	Combo PR	M42-54-1.6-2/3
2 x .062	54 x 1.6	3/4	Combo	M42-54-1.6-3/4
2 x .062	54 x 1.6	4/6	Combo	M42-54-1.6-4/6



WARNING



• Wear Safety Goggles (users and bystanders)



• Wear hearing protection (users and bystanders)



• Avoid prolonged exposure to vibration.



Easy-Cut® blades cut almost anything without changing blades!

Bahco Easy-Cut® M42 Bi-metal Bandsaw Blades are designed exclusively for general purpose sawing in tool rooms, machine shops, maintenance rooms, fabricating shops and welding shops.

Bahco's perfect "recipe" combines the science of rake angle, unique patented tooth geometry & M42 high speed steel material to produce the tough, resilient and versatile Easy-Cut® blade.

- Tool Steel
- Mild Steel
- Stainless Steel
- Aluminum
- Copper
- Brass
- Wood
- Plastic
- Sheet Metal
- Tubing
- Solids
- Bundles
- Pipe
- Channel
- Angle Iron
- I Beams
- H Beams
- Drill Rods

Easy to order – simply specify blade width and length. The unique patented tooth design cuts any shape or size in virtually any material, while eliminating the need to specify pitch or tooth form.

Easy to use – patented anti-tooth-stripping design and M-42 tooth tips combine to create a blade that lasts longer and will not strip teeth like other blades, allowing the operator to spend more time cutting and less time changing saw blades.

Easy to decide – save time and money by reducing blade inventory, operator labor, and machine down time.

Choose Easy-Cut® for all general-purpose bandsaw applications – the choice is easy.

3857-Easy-Cut®

DIMENSIONS INCHES	MM	TEETH PER INCH	PRODUCT CODE
1/2 x .025	13 x 0.6	MEDIUM	3857-13-0.6-EZ-M
3/4 x .035	20 x 0.9	MEDIUM	3857-20-0.9-EZ-M
1 x .035	27 x 0.9	MEDIUM	3857-27-0.9-EZ-M
1 1/4 x .042	34 x 1.1	MEDIUM	3857-34-1.1-EZ-M



EZ, This patented design gives a very versatile blade, able to cut all common materials in addition to being very resistant to tooth stripping. Ideal for small workshops cutting different sizes in a wide range of materials.

3853-TOP Fabricator

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1 x 0.35	27 x 0.9	3/4*	Combo PF	3853-27-0.9-3/4
1 x 0.35	27 x 0.9	4/6	Combo PF	3853-27-0.9-4/6
1 x 0.35	27 x 0.9	5/8	Combo PF	3853-27-0.9-5/8
1-1/4 x .042	34 x 1.1	2/3*	Combo PF	3853-34-1.1-2/3
1-1/4 x .042	34 x 1.1	3/4*	Combo PF	3853-34-1.1-3/4
1-1/4 x .042	34 x 1.1	4/6	Combo PF	3853-34-1.1-4/6
1-1/4 x .042	34 x 1.1	5/8	Combo PF	3853-34-1.1-5/8
1-1/2 x .050	41 X 1.3	2/3*	Combo PF	3853-41-1.3-2/3
1-1/2 x .050	41 X 1.3	3/4*	Combo PF	3853-41-1.3-3/4
1-1/2 x .050	41 X 1.3	4/6	Combo PF	3853-41-1.3-4/6
1-1/2 x .050	41 X 1.3	5/8	Combo PF	3853-41-1.3-5/8
2 x .050	54 x 1.3	3/4*	Combo PF	3853-54-1.3-3/4
2 x .050	54 x 1.3	4/6	Combo PF	3853-54-1.3-4/6
2 x .050	54 x 1.3	5/8	Combo PF	3853-54-1.3-5/8
2 X .062	54 X 1.6	2/3*	Combo PF	3853-54-1.6-2/3
2 X .062	54 X 1.6	3/4*	Combo PF	3853-54-1.6-3/4
2 X .062	54 X 1.6	4/6	Combo PF	3853-54-1.6-4/6
2-5/8 x .062	67 x 1.6	2/3*	Combo PF	3853-67-1.6-2/3
2-5/8 x .062	67 x 1.6	3/4*	Combo PF	3853-67-1.6-3/4
2-5/8 x .062	67 x 1.6	4/6	Combo PF	3853-67-1.6-4/6

*Wide Set–used for heavy structurals to eliminate pinching



Combo PF, specifically designed for cutting bundles of tubes and profiles with excellent capacity and tool life. Very strong tooth with 6 degree positive rake angle.

3853 TOP Fabricator For Tubes Or Profiles

Cuts:

- Channel
- Bundles
- Angle Iron
- I Beam
- H Beam
- Structural Steel
- Square and Round Tubes

Reduces:

- Out of square cutting
- Stripped teeth
- Broken blades
- Vibration
- Pinching

Features:

- Patented tooth design makes the teeth stronger, more resistant to tooth stripping, and longer lasting.
- M42 bi-metal material offers longer blade life.



WARNING



• Wear Safety Goggles
(users and bystanders)



• Wear hearing protection
(users and bystanders)



• Avoid prolonged exposure
to vibration.

For high productivity cutting of large or small workpieces and contour cutting.

- Specially designed tooth shapes for maximum cutting performance.
- M42 tooth tips offer heat and wear resistance for long blade life.
- Excellent choice for production cutting of the toughest materials.



3851-Cobra™

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1/4 x .025	6 x 0.6	10/14	Combo	3851-6-0.6-10/14
1/4 x .025	6 x 0.6	6	Hook	3851-6-0.6-H-6
1/4 x .035	6 x 0.9	10/14	Combo	3851-6-0.9-10/14
1/4 x .035	6 x 0.9	6	Hook	3851-6-0.9-H-6
3/8 x .025	10 x 0.6	10/14	Combo	3851-10-0.6-10/14
3/8 x .025	10 x 0.6	4	Hook	3851-10-0.6-H-4
3/8 x .025	10 x 0.6	6	Hook	3851-10-0.6-H-6
3/8 x .035	10 x 0.9	10/14	Combo	3851-10-0.9-10/14
3/8 x .035	10 x 0.9	4	Hook	3851-10-0.9-H-4
3/8 x .035	10 x 0.9	6	Hook	3851-10-0.9-H-6
1/2 x .020	13 x 0.5	10/14	Combo	3851-13-0.5-10/14
1/2 x .020	13 x 0.5	14/18	Combo	3851-13-0.5-14/18
1/2 x .025	13 x 0.6	10/14	Combo	3851-13-0.6-10/14
1/2 x .025	13 x 0.6	5/8	Combo	3851-13-0.6-5/8
1/2 x .025	13 x 0.6	6/10	Combo	3851-13-0.6-6/10
1/2 x .025	13 x 0.6	8/12	Combo	3851-13-0.6-8/12
1/2 x .025	13 x 0.6	6	Hook	3851-13-0.6-H-6
1/2 x .025	13 x 0.6	4	Hook	3851-13-0.6-H-4
1/2 x .035	13 x 0.9	10/14	Combo	3851-13-0.9-10/14
1/2 x .035	13 x 0.9	6/10	Combo	3851-13-0.9-6/10
1/2 x .035	13 x 0.9	3	Hook	3851-13-0.9-H-3
1/2 x .035	13 x 0.9	4	Hook	3851-13-0.9-H-4
1/2 x .035	13 x 0.9	6	Hook	3851-13-0.9-H-6
3/4 x .035	20 x 0.9	10/14	Combo	3851-20-0.9-10/14
3/4 x .035	20 x 0.9	4/6	Combo	3851-20-0.9-4/6
3/4 x .035	20 x 0.9	5/8	Combo	3851-20-0.9-5/8
3/4 x .035	20 x 0.9	6/10	Combo	3851-20-0.9-6/10
3/4 x .035	20 x 0.9	8/12	Combo	3851-20-0.9-8/12
3/4 x .035	20 x 0.9	3	Hook	3851-20-0.9-HA-3
1 x .035	27 x 0.9	10/14	Combo	3851-27-0.9-10/14
1 x .035	27 x 0.9	2/3	Combo	3851-27-0.9-2/3

3851-Cobra™

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1 x .035	27 x 0.9	3/4	Combo	3851-27-0.9-3/4
1 x .035	27 x 0.9	4/6	Combo	3851-27-0.9-4/6
1 x .035	27 x 0.9	5/8	Combo	3851-27-0.9-5/8
1 x .035	27 x 0.9	6/10	Combo	3851-27-0.9-6/10
1 x .035	27 x 0.9	8/12	Combo	3851-27-0.9-8/12
1 x .035	27 x 0.9	3	Hook	3851-27-0.9-H-3
1-1/4 x .042	34 x 1.1	2/3	Combo	3851-34-1.1-2/3
1-1/4 x .042	34 x 1.1	3/4	Combo	3851-34-1.1-3/4
1-1/4 x .042	34 x 1.1	4/6	Combo	3851-34-1.1-4/6
1-1/4 x .042	34 x 1.1	5/8	Combo	3851-34-1.1-5/8
1-1/4 x .042	34 x 1.1	6/10	Combo	3851-34-1.1-6/10
1-1/2 x .050	41 X 1.3	2/3	Combo	3851-41-1.3-2/3
1-1/2 x .050	41 X 1.3	3/4	Combo	3851-41-1.3-3/4
1-1/2 x .050	41 X 1.3	4/6	Combo	3851-41-1.3-4/6
1-1/2 x .050	41 X 1.3	5/8	Combo	3851-41-1.3-5/8
1-1/2 x .050	41 X 1.3	1.4/2	Combo	3851-41-1.3-1.4/2
1-1/2 x .050	41 X 1.3	2	PS	3851-41-1.3-P-2
1-1/2 x .050	41 X 1.3	3	PS	3851-41-1.3-P-3
2 x .050	54 x 1.3	2/3	Combo	3851-54-1.3-2/3
2 x .062	54 x 1.6	1.4/2	Combo PR	3851-54-1.6-1.4/2
2 x .062	54 x 1.6	1/1.4	Combo PR	3851-54-1.6-1/1.4
2 x .062	54 x 1.6	2/3	Combo	3851-54-1.6-2/3
2 x .062	54 x 1.6	3/4	Combo	3851-54-1.6-3/4
2-5/8 x .062	67 x 1.6	.7/1	Combo PR	3851-67-1.6-.7/1
3-1/8 x .062	80 x 1.6	.7/1	Combo PR	3851-80-1.6-.7/1
3-1/8 x .062	80 x 1.6	1/1.4	Combo PR	3851-80-1.6-1/1.4
3-1/8 x .062	80 x 1.6	1.4/2	Combo PR	3851-80-1.6-1.4/2



Combo tooth shape traditional shape tooth with 0° rake angle. Suitable for multipurpose cutting of thin-walled tubes and profiles in most materials.



Hook. Traditional tooth design with 10° rake angle, used for non-ferrous metals, wood and plastics.



PS. High productivity design with a 10-15° rake angle. A high wedge angle and a large gullet space makes it excellent to cut large workpieces.



Combo PR, with a 5-10° rake angle, is mainly used on medium sized to large workpieces when vibration may occur.



WARNING



• Wear Safety Goggles
(users and bystanders)



• Wear hearing protection
(users and bystanders)



• Avoid prolonged exposure
to vibration.

3851-Cobra™ PSG Ground Tooth Technology

Ideal choice for the production cutting of medium to large sections of alloyed and stainless steels.

- Smooth surface finish is ensured not only by the latest ground tooth technology but also by the precise set.
- Special combination tooth design and sharp cutting edges allow easy penetration while the M42 tooth tips withstand high heat.



3851-Cobra™ PSG

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1 x .035	27 x 0.9	2/3	PSG	3851-27-0.9-PSG-2/3
1 x .035	27 x 0.9	3/4	PSG	3851-27-0.9-PSG-3/4
1 x .035	27 x 0.9	4/6	PSG	3851-27-0.9-PSG-4/6
1-1/4 x .042	34 x 1.1	2/3	PSG	3851-34-1.1-PSG-2/3
1-1/4 x .042	34 x 1.1	3/4	PSG	3851-34-1.1-PSG-3/4
1-1/4 x .042	34 x 1.1	4/6	PSG	3851-34-1.1-PSG-4/6
1-1/2 x .050	41 X 1.3	1.4/2	PSG	3851-41-1.3-PSG-1.4/2
1-1/2 x .050	41 X 1.3	2/3	PSG	3851-41-1.3-PSG-2/3
1-1/2 x .050	41 X 1.3	3/4	PSG	3851-41-1.3-PSG-3/4
1-1/2 x .050	41 X 1.3	4/6	PSG	3851-41-1.3-PSG-4/6
2 x .062	54 x 1.6	1.4/2	PSG	3851-54-1.6-PSG-1.4/2
2 x .062	54 x 1.6	2/3	PSG	3851-54-1.6-PSG-2/3
2 x .062	54 x 1.6	3/4	PSG	3851-54-1.6-PSG-3/4



PSG is a ground tooth shape with positive rake angle. It is the ideal tooth shape for production cutting medium to large sections of a wide range of materials and especially on alloyed and stainless steels.



For high performance cutting of large and difficult to cut work pieces.

3854-King Cobra™ PHG™

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1 x .035	27 x 0.9	3/4	PHG	3854-27-0.9-PHG-3/4
1 x .035	27 x 0.9	4/6	PHG	3854-27-0.9-PHG-4/6
1-1/4 x .042	34 x 1.1	2/3	PHG	3854-34-1.1-PHG-2/3
1-1/4 x .042	34 x 1.1	3/4	PHG	3854-34-1.1-PHG-3/4
1-1/4 x .042	34 x 1.1	4/6	PHG	3854-34-1.1-PHG-4/6
1-1/2 x .050	41 X 1.3	1.4/2	PHG	3854-41-1.3-PHG-1.4/2
1-1/2 x .050	41 X 1.3	2/3	PHG	3854-41-1.3-PHG-2/3
1-1/2 x .050	41 X 1.3	3/4	PHG	3854-41-1.3-PHG-3/4
1-1/2 x .050	41 X 1.3	4/6	PHG	3854-41-1.3-PHG-4/6
2 x .062	54 x 1.6	.7/1	PHG	3854-54-1.6-PHG-.7/1
2 x .062	54 x 1.6	1.4/2	PHG	3854-54-1.6-PHG-1.4/2
2 x .062	54 x 1.6	1/1.4	PHG	3854-54-1.6-PHG-1/1.4
2 x .062	54 x 1.6	2/3	PHG	3854-54-1.6-PHG-2/3
2-5/8 x .062	67 x 1.6	1.4/2	PHG	3854-67-1.6-PHG-1.4/2
2-5/8 x .062	67 x 1.6	.7/1	PHG	3854-67-1.6-PHG-.7/1
2-5/8 x .062	67 x 1.6	1/1.4	PHG	3854-67-1.6-PHG-1/1.4
2-5/8 x .062	67 x 1.6	2/3	PHG	3854-67-1.6-PHG-2/3

- Developed for cutting harder materials.
- Ground tooth for precise and consistent tooth height.
- For high performance cutting of large and difficult to cut work pieces.
- Special design combined with sharp cutting edges for high penetration rate into the work pieces.

- Inconel
- Monel
- Zirconium
- Titanium
- Beryllium Copper
- Stainless Steels
- Tool Steels
- Cold Rolled Steels



PHG is a patented ground tooth shape with positive rake angle designed for good penetration of large sections of tough-to-cut alloys and work hardening materials.

3854-King Cobra™ PQ

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1 x .035	27 X 0.9	3/4	PQ	3854-27-0.9-PQ-3/4
1 x .035	27 X 0.9	4/6	PQ	3854-27-0.9-PQ-4/6
1-1/4 x .042	34 x 1.1	2/3	PQ	3854-34-1.1-PQ-2/3
1-1/4 x .042	34 x 1.1	3/4	PQ	3854-34-1.1-PQ-3/4
1-1/4 x .042	34 x 1.1	4/6	PQ	3854-34-1.1-PQ-4/6
1-1/2 x .050	41 X 1.3	2/3	PQ	3854-41-1.3-PQ-2/3
1-1/2 x .050	41 X 1.3	3/4	PQ	3854-41-1.3-PQ-3/4
1-1/2 x .050	41 X 1.3	4/6	PQ	3854-41-1.3-PQ-4/6
1-1/2 x .050	41 X 1.3	1.4/2	PQ	3854-41-1.3-PQ-1.4/2
2 x .062	54 x 1.6	2/3	PQ	3854-54-1.6-PQ-2/3
2 x .062	54 x 1.6	3/4	PQ	3854-54-1.6-PQ-3/4
2 x .062	54 x 1.6	1.4/2	PQ	3854-54-1.6-PQ-1.4/2
2-5/8 x .062	67 x 1.6	2/3	PQ	3854-67-1.6-PQ-2/3
2-5/8 x .062	67 x 1.6	1.4/2	PQ	3854-67-1.6-PQ-1.4/2
3-1/8 x .062	80 x 1.6	2/3	PQ	3854-80-1.6-PQ-2/3
3-1/8 x .062	80 x 1.6	1.4/2	PQ	3854-80-1.6-PQ-1.4/2

- M42 tooth material provides long life and good resistance to tooth strippage.
- Patented set levels produce a multi chip cutting profile which reduces cutting forces and improves blade life.

- Bearing Steels
- Carbon Steels
- Stainless Steels
- Tool Steels
- Mold Steels
- Alloy Steels
- Cold Rolled Steels



Positive Quad PQ Very aggressive 17° positive tooth design intended to give good penetration on difficult to cut material such as stainless steels, bearing steels, tool steels and special alloys with work hardening properties.



WARNING



• Wear Safety Goggles (users and bystanders)



• Wear hearing protection (users and bystanders)

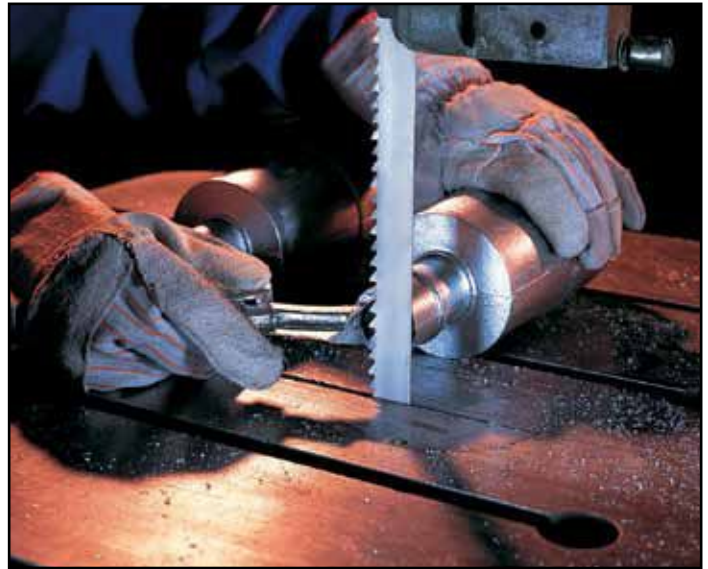


• Avoid prolonged exposure to vibration.

Foundry bandsaw blade for non-ferrous and abrasive materials

Perfect for aluminum, gates and risers, magnesium, zirconium, beryllium, bronze, copper, abrasive materials and plastics.

- Deflects chips away from machine operator
- Carbide tipped teeth with triple set configuration
- Fast cutting
- Easy feeding
- Special design for foundry use.
- For use on smaller machines for difficult-to-cut materials.
- Straight and radius cutting



3869-Carbide Triple Set®

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1/2 x .035	13 x 0.9	3	TS	3869-13-0.9-TS-3
3/4 x .035	20 x 0.9	3	TS	3869-20-0.9-TS-3
3/4 x .035	20 x 0.9	4	TS	3869-20-0.9-TS-4
1 x .035	27 x 0.9	3	TS	3869-27-0.9-TS-3
1 x .035	27 x 0.9	4	TS	3869-27-0.9-TS-4
1-1/4 x .042	34 x 1.1	3	TS	3869-34-1.1-TS-3



TS, This triple chip tooth design has a rake angle of 7° and is designed for foundry use but works very well in narrow band applications cutting stainless and high alloy steels.

3860 Multi-Chip Unset Carbide Tipped bandsaw blade developed specifically for cutting Titanium Alloys

Performs extremely well cutting Titanium solids and blocks, stainless steels and aluminum.

- Special tooth geometry designed for Titanium applications
- Unset teeth provide a superior surface finish, long life and eliminate secondary operations
- Special grade of carbide tooth material provides maximum life and cutting performance
- Tooth tips are fine ground to give a sharp edge essential for cutting Titanium
- High heat resistance allows high speed cutting even in large solids
- Special grade backing material gives long life and excellent fatigue resistance.



Tooth from a 3860 Multi-Chip Unset Carbide Tipped bandsaw blade.



TMC. This tooth design is used for our unset carbide blade. It has a 7 chip design and excels in difficult to cut alloys on stable machines.

3860 - Multi-Chip Unset Carbide Tipped - TMC

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1-1/2 x .050	41 x 1.3	1.4/2	TMC	3860-41-1.3-TMC-1.4/2
2 X .062	54 X 1.6	1/1.25	TMC	3860-54-1.6-TMC-1/1.25
2 X .062	54 X 1.6	1/4.2	TMC	3860-54-1.6-TMC-1.4/2
2 X .062	54 X 1.6	2/3	TMC	3860-54-1.6-TMC-2/3
2-5/8 X .062	67 X 1.6	1/1.25	TMC	3860-67-1.6-TMC-1/1.25
2-5/8 X .062	67 X 1.6	1.4/2	TMC	3860-67-1.6-TMC-1.4/2
2-5/8 X .062	67 X 1.6	2/3	TMC	3860-67-1.6-TMC-2/3
3-1/8 X .062	80 X 1.6	.7/1	TMC	3860-80-1.6-TMC-.7/1
3-1/8 X .062	80 X 1.6	1/1.25	TMC	3860-80-1.6-TMC-1/1.25
3-1/8 X .062	80 X 1.6	1.4/2	TMC	3860-80-1.6-TMC-1.4/2
3-1/8 X .062	80 X 1.6	2/3	TMC	3860-80-1.6-TMC-2/3



WARNING



• Wear Safety Goggles
(users and bystanders)



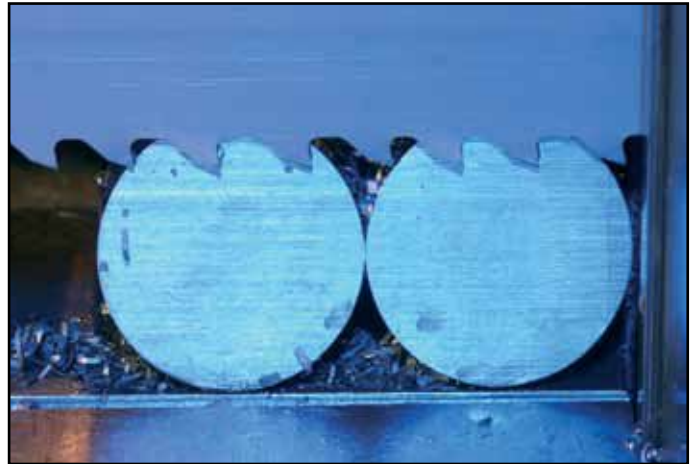
• Wear hearing protection
(users and bystanders)



• Avoid prolonged exposure
to vibration.

TSX (Triple Set Extra)

- The teeth of the 3868 are tipped with a special grade of carbide to cut the most difficult materials.
- Carbide is very tough so the edges can withstand the high impact forces of bandsawing without breaking or chipping.
- Carbide is superior to bimetal blades with higher cutting rates, lower cost per cut and extended tool life.
- Carbide will save you money by cutting material faster and lasting longer than any other bi-metal blade- that is how Bahco reduces your cost per cut.
- Patented ground blade design features a triple chip blade with set teeth.
- Provides clearance for good chip removal
- Perfect for cutting titanium alloys, high nickel alloys, stainless steel, abrasive tool steel, abrasive graphite alloy, aluminum with high silicon or matrix alloys, aerospace alloys.



3868-Carbide Triple Set® “Xtra”™ TSX

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1-1/4 x .042	34 x 1.1	2	TSX	3868-34-1.1-TSX-2
1-1/4 x .042	34 x 1.1	2/3	TSX	3868-34-1.1-TSX-2/3
1-1/4 x .042	34 x 1.1	3/4	TSX	3868-34-1.1-TSX-3/4
1-1/2 x .050	41 X 1.3	1.6	TSX	3868-41-1.3-TSX-1.6
1-1/2 x .050	41 X 1.3	2	TSX	3868-41-1.3-TSX-2
1-1/2 x .050	41 X 1.3	1.4/2	TSX	3868-41-1.3-TSX-1.4/2
1-1/2 x .050	41 X 1.3	2/3	TSX	3868-41-1.3-TSX-2/3
1-1/2 x .050	41 X 1.3	3/4	TSX	3868-41-1.3-TSX-3/4
2 x .062	54 x 1.6	1.4/2	TSX	3868-54-1.6-TSX-1.4/2
2 x .062	54 x 1.6	2	TSX	3868-54-1.6-TSX-2
2 x .062	54 x 1.6	1.6	TSX	3868-54-1.6-TSX-1.6
2 x .062	54 x 1.6	1/1.25	TSX	3868-54-1.6-TSX-1/1.25
2 x .062	54 x 1.6	2/3	TSX	3868-54-1.6-TSX-2/3
2 x .062	54 x 1.6	3/4	TSX	3868-54-1.6-TSX-3/4
2-5/8 x .062	67 x 1.6	2/3	TSX	3868-67-1.6-TSX-2/3
2-5/8 x .062	67 x 1.6	.7/1	TSX	3868-67-1.6-TSX-.7/1
2-5/8 x .062	67 x 1.6	1.4/2	TSX	3868-67-1.6-TSX-1.4/2
2-5/8 x .062	67 x 1.6	1/1.25	TSX	3868-67-1.6-TSX-1/1.25
3-1/8 x .062	80 x 1.6	.7/1	TSX	3868-80-1.6-TSX-.7/1



TSX. This triple chip tooth design has a rake angle of 10° and is ideal for cutting large difficult and abrasive materials. The advantage of a set blade is that it is much more forgiving in less stable machines compared with unset blades. This is a unique and patented tooth design.

TSS (Triple Set Stainless - Honed)

- Patented edge preparation (honed) eliminates the need for break in
- Reduces vibration/extremely low noise level
- Designed specifically for production cutting of stainless steels
- For high efficiency cutting of difficult and abrasive materials.
- Triple set tooth design and good kerf clearance help eliminate tooth loss.
- Proven to increase productivity dramatically
- Greatly improved blade life



3868-Carbide Triple Set® TSS

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1-1/4 x .042	34 x 1.1	2/3	TSS	3868-34-1.1-TSS-2/3
1-1/2 x .050	41 x 1.3	1.4/2	TSS	3868-41-1.3-TSS-1.4/2
1-1/2 x .050	41 x 1.3	2/3	TSS	3868-41-1.3-TSS-2/3
2 x .062	54 x 1.6	1.4/2	TSS	3868-54-1.6-TSS-1.4/2
2 x .062	54 x 1.6	2/3	TSS	3868-54-1.6-TSS-2/3
2 x .062	54 x 1.6	1/1.25	TSS	3868-54-1.6-TSS-1/1.25
2-5/8 x .062	67 x 1.6	.7/1	TSS	3868-67-1.6-TSS-.7/1
2-5/8 x .062	67 x 1.6	1.4/2	TSS	3868-67-1.6-TSS-1.4/2
2-5/8 x .062	67 x 1.6	1/1.25	TSS	3868-67-1.6-TSS-1/1.25
2-5/8 x .062	67 x 1.6	2/3	TSS	3868-67-1.6-TSS-2/3
3-1/8 x .062	67 x 1.6	.7/1	TSS	3868-80-1.6-TSS-.7/1



TSS. Same design as TSX, but pre “run in” at the factory. Designed to remove the need for running in on the machine allowing full speed, feed operation from the first cut in stainless steel. This is a unique and patented tooth design. Not suitable for titanium applications.



WARNING



• Wear Safety Goggles
(users and bystanders)



• Wear hearing protection
(users and bystanders)



• Avoid prolonged exposure
to vibration.

THQ (Triple High Quad)

Performs extremely well cutting Titanium Alloys, Aerospace Alloys, Stainless Steel, High Nickel Chrome Alloys and Abrasive Tool Steel

- Quad grind enables cutting of scaled surfaces
- Patented set levels improves the chip removal and extends blade life.



THQ. Multi-chip tooth is designed for cutting Inconel, Waspaloy and titanium. It is wide set as standard, where pinching is a problem and produces 7 chips to reduce cutting forces and increase life. Applications in medium to large size materials.



3881-Carbide Triple Set® THQ

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1-1/4 X.042	34 x 1.1	2/3	THQ	3881-34-1.1-THQ-2/3
1-1/2 X.050	41 X 1.3	1.4/2	THQ	3881-41-1.3-THQ-1.4/2
1-1/2 X.050	41 X 1.3	2/3	THQ	3881-41-1.3-THQ-2/3
2 X.062	54 X 1.6	1.4/2	THQ	3881-54-1.6-THQ-1.4/2
2-5/8 x .062	67 x 1.6	1.4/2	THQ	3881-67-1.6-THQ-1.4/2
2-5/8 x .062	67 x 1.6	2/3	THQ	3881-67-1.6-THQ-2/3
3-1/8 x .062	80 x 1.6	1.4/2	THQ	3881-80-1.6-THQ-1.4/2
3-1/8 x .062	80 x 1.6	2/3	THQ	3881-80-1.6-THQ-2/3

THS (Triple High Quad - Honed)

Performs extremely well cutting Stainless Steel, High Nickel Chrome Alloys, Aerospace Alloys and Abrasive Tool Steel

- Patented edge preparation
- Eliminates breaking in
- Reduces tooth strippage on breakthrough



THS. Same design as THQ, but with an extremely low noise level. Not suitable for titanium applications.



3881-Carbide Triple Set® THS

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1-1/2 X .050	41 X 1.3	1.4/2	THS	3881-41-1.3-THS-1.4/2
2 X .062	54 X 1.6	1/1.25	THS	3881-54-1.6-THS-1/1.25
2-5/8 x .062	67 x 1.6	1/1.25	THS	3881-67-1.6-THS-1/1.25
2-5/8 x .062	67 x 1.6	2/3	THS	3881-67-1.6-THS-2/3
3-1/8 x .062	80 x 1.6	.7/1	THS	3881-80-1.6-THS-.7/1
3-1/8 x .062	80 x 1.6	1.4/2	THS	3881-80-1.6-THS-1.4/2
3-1/8 x .062	80 x 1.6	2/3	THS	3881-80-1.6-THS-2/3



WARNING



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(users and bystanders)



• Wear hearing protection
(users and bystanders)



• Avoid prolonged exposure
to vibration.

Chip Load Per Tooth Formula

$$\frac{\text{HEIGHT OF CUT (INCHES)}}{(12 \times \text{AVE. TPI}) \times \text{SFPM} \times \text{CUT TIME}} = \text{CHIP LOAD}$$

Use your specific cutting data to apply a numeric value to your chip size.

- HEIGHT OF CUT: height of the material being cut in inches
- AVE. TPI: average teeth per inch, multiplied by 12. If the blade you are using has a 2/3 pitch, your average TPI is 2.5. $2.5 \times 12 = 30$
- SFPM: surface feet per minute, or the speed at which the blade is traveling. Most bandsaws read blade speed as SFPM.
- CUT TIME: How long it takes to cut the workpiece, in minutes. For example, if your cut takes 4 minutes, 30 seconds, enter 4.5 minutes.

You can now compare your chip load to this list of common “target” chip loads, depending on your material:

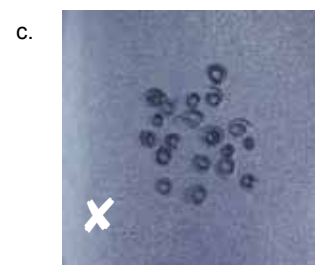
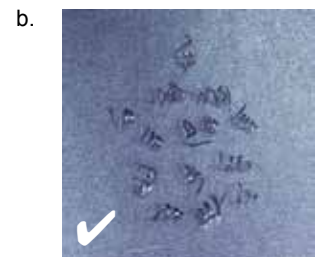
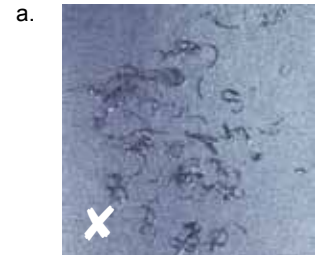
• Inco	=	.000098”
• Titanium	=	.00019”
• Tool Steels	=	.00013”
• Stainless steels	=	.00019”
• Low Alloys/Alloy steel	=	.00031”
• Bronze/Copper/Aluminium	=	.00047”

Feed Rate/Chips

It is important that each tooth of the bandsaw blade cuts a chip with the right thickness.

This is determined by the selection of tooth pitch, band speed and feed rate.

- 1: Start by selecting the correct tooth pitch from the selection charts.
- 2: Then set your band speed and feed rate according to the Cutting Data Slide Chart (page 22).
- 3: Once cutting, you can adjust the feed rate by studying the chips that the saw is producing.
4. Compare them to the diagrams below.
 - a. Thin or pulverized chips – increase feed or decrease band speed
 - b. Loosely rolled chips – correct
 - c. Thick, heavy, or blue chips – decrease feed rate or increase band speed



Speed Selection Guide

Bimetal

Feet per minute

Material	3/8" - 2"	4" - 12"	16" - 31"	> 39"	Coolant
Structural steels, machining steel	328	279-312	197-246	131-197	6 %
Structural steels, quenched and tempered steels	262	230-262	197-223	131-164	6 %
Case hardened, spring steels, quenched and tempered steels	246-328	197-262	148-213	98-131	8 %
Unalloyed tool steel, ball and roller bearing steel	197-213	180-197	115-148	82-115	8 %
High speed steel	148-164	131-148	98-115	66-82	8 %
Cold work tool steel	98-115	82-98	66-82	49-66	DRY
Tool steels, alloyed	148-213	148-197	131-197	66-131	8 %
Nitriding steels, high alloyed hot working steels	131-148	115-131	82-98	66-82	8 %
Cast iron	164-197	148-164	98-131	82-98	DRY
Rust and acid resistant steels (lightly)	131-148	131-148	115-131	98-131	10 %
Rust and acid resistant steels (heavy)	115-131	98-115	66-98	62-72	10 %
Duplex and heat resistant steels	82-98	66-82	49-66	46-52	10 %
Nickel and nickel-cobalt alloys	49-66	43-49	33-39	33	10 %
Titanium, titanium alloys; aluminium bronze	98-115	82-98	66-82	52-59	10 %
Horizontal machines, aluminium, aluminium alloys	394	394	394	394	10 %
Vertical machines, aluminium, aluminium alloys	9843	6890-8203	4101-6562	1641-3937	10 %
Brass	394	394	295-394	262-328	4 %
Copper	394	361	262-328	197-262	15 %

The bigger the size, the lower the speed.

Carbide

Feet per minute

Material	3/8" - 2"	4" - 12"	16" - 31"	> 39"	Coolant
Structural steels, machining steel	656	525-623	361-492	197-295	12 %
Structural steels, quenched and tempered steels	459	394-459	279-377	164-230	12 %
Case hardened, spring steels, quenched and tempered steels	394-427	361-394	246-361	131-197	10 %
Unalloyed tool steel, ball and roller bearing steel	328-394	295-328	197-295	131-164	10 %
High speed steel	328-361	262-295	197-246	164-197	10 %
Cold work tool steel	262-328	197-295	197-246	148-213	DRY
Tool steels, alloyed	279-312	262-295	197-230	164-197	8 %
Nitriding steels, high alloyed hot working steels	246-279	230-262	197-230	148-197	8 %
Cast iron	295-345	295-312	197-246	131-180	12 %
Rust and acid resistant steels (lightly)	262-361	262-328	230-312	213-262	12 %
Rust and acid resistant steels (heavy)	262-295	230-262	197-230	131-164	13 %
Duplex and heat resistant steels	328-377	262-328	213-262	164-197	12 %
Nickel and nickel-cobalt alloys	98-131	82-98	66-92	49-66	12 %
Titanium, titanium alloys; aluminium bronze	164-197	131-164	115-148	52-59	12 %
Horizontal machines, aluminium, aluminium alloys	820	820	820	820	10 %
Vertical machines, aluminium, aluminium alloys	16405	13124-16405	9843-13124	6562-9843	10 %
Brass	820	820	591-787	459-525	4 %
Copper	787	722	427-623	328-33	15 %

The bigger the size, the lower the speed.



WARNING



• Wear Safety Goggles (users and bystanders)



• Wear hearing protection (users and bystanders)



• Avoid prolonged exposure to vibration.

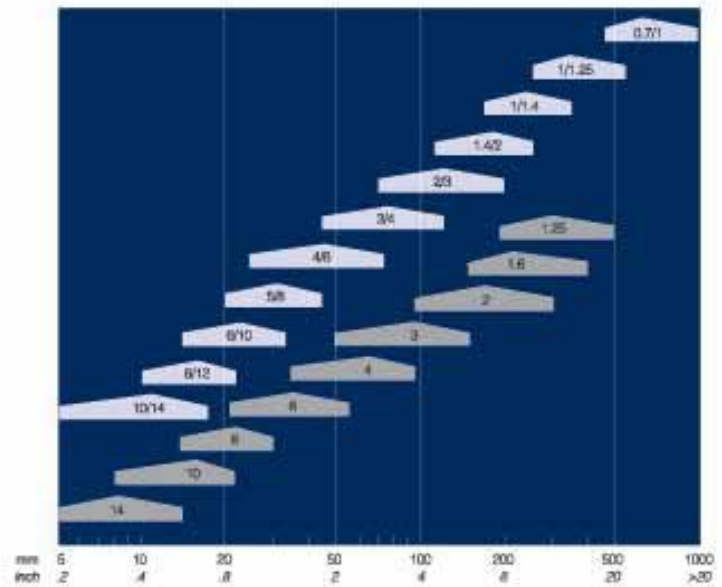
Tooth Pitch Selection Charts

Solid workpieces

The diagram will help you select the right pitch for cutting solids.

Example 1: When cutting a 6 inch (150 mm) bar, use 2 TPI, if an evenly pitched blade is your choice. Use a 2/3 TPI or a 1.4/2 TPI if you choose a variably pitched blade.

Example 2: If you are sawing in soft materials like plastics, aluminium or wood, choose a pitch two steps coarser than recommended. When cutting 1/2-3/4 inch (13-20 mm) thick pieces of aluminium, use a 6 TPI or a 5/8 TPI blade.



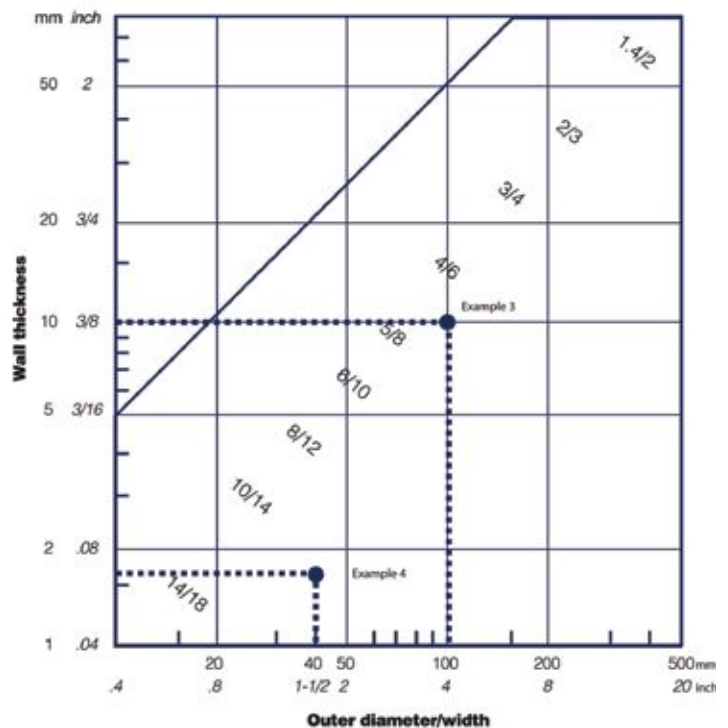
Cutting Pipes and Profiles

The diagram will help you select the right pitch for cutting pipes and profiles.

The recommended tooth pitch for cutting profiles is found in the field where width meets the wall thickness of the profile.

Example 3: When cutting a 4" x 3/8" I-beam, select a 5/8 TPI or a 4/6 TPI blade. The recommended tooth pitch is found in the field where the outer diameter meets the wall thickness of the pipe to be cut.

Example 2: When cutting a 1-1/2" x 1/16" pipe, select a 10/14 TPI blades.

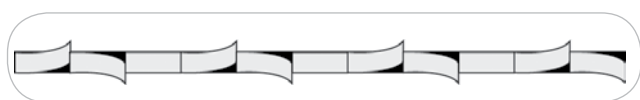


Bandsaw Blade Width

The band width is measured from the tip of the teeth to the back edge of the blade.

Bandsaw Blade Tooth Set

The set is the tilt, or angle, given to the teeth of the saw blade to provide clearance for the blade body and the tooth edges.



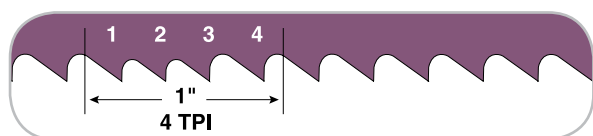
Teeth Per Inch (TPI)

The number of teeth per inch (TPI) defines the pitch of the blade and can vary from less than 1 to 24.

Thin-walled workpieces like tubes, pipes, sheet etc., require fine teeth, otherwise there is a risk of tooth damage or breakage.

Large cross sections should be cut with a coarse pitched saw, i.e. fewer teeth per inch. The fewer teeth engaged in the workpiece the higher the cutting capacity. This is because the penetration capacity of each individual tooth is greater if the saw's feed pressure is distributed over a fewer number of teeth. Therefore, a coarse pitch blade (few TPI) increases productivity and provides the desired large chip space.

Soft materials, such as aluminium and bronze, require a large chip space. A coarse pitch prevents the chips from building up and packing together in the gullets, which can impair sawing and damage the blade. Use the TPI selection guides to find the right pitch for your application.



Blade Break In - Bimetal

To obtain the maximum blade life always use the recommended band speed but lower the feed rate to 1/3-1/2 during the first 10 minutes of cutting.

During the next 10 minutes increase the feed rate in stages, until you have reached the recommended feed rate.

Blade Break In - Carbide

When breaking in Carbide blades start at normal Bimetal speeds and feeds and work up to nominal chip load. (Refer to page 18).

Do no break-in 3881 THS (see page 16) or 3868 TSS (see page 15), these products are run-in at the factory.

Bandsaw Machine Tips

Check frequently:

- The operation of the chip brush.
- The wear and alignment of the guides.
- The band tension with a tensionmeter (see page 22).
- The band speed with a tachometer (see page 22).
- The coolant concentration with a refractometer (see page 22).

Coolant / Cutting fluid

The coolant lubricates, cools and carries the chips from the cut. It is important to:

- Use good cutting fluid.
- Use recommended concentration of cutting fluid.
- Make sure that the cutting fluid reaches the cut with low pressure and large flow.

Workpiece

- Make sure that the workpiece is firmly clamped so that it cannot vibrate or rotate.
- Do not use bent or damaged workpieces.



WARNING



• Wear Safety Goggles (users and bystanders)



• Wear hearing protection (users and bystanders)



• Avoid prolonged exposure to vibration.



3870-Bandcalc - This software helps determine cutting solutions for your specific needs.



3870-Slidechart - Helps determine the proper blade speed and feed rate for your specific cutting conditions.



3870-Tensionmeter



3870-Safetyglasses



3870-Tachometer



MTT8674 - Multi-tool



3870-Gloves

Chip Brushes
High-performing, nylon chip brushes are long lasting and ensure chips are removed from the blade before re-entering the workpiece.



3870-Refractometer



3870-Wedges

Chip Brushes

PRODUCT CODE	EAN CODE	DIAMETER	WIDTH	BORE
CN3	9933850	3"	1/2"	1/2" x 3/8"
CN4	9933867	4"	1/2"	1/2" x 3/8"
CN6	9933874	6"	1/2"	5/8" x 1/2"

	Important Facts	Band breakage	Crooked sawing	Tooth breakage	Rough surface	Rapid tooth wear	Vibration	Band slips on wheel
Machine	Guides and Guidearms You have to check and adjust guides regularly. Check if worn out and replace if necessary. Position guidearms as close to work piece as possible	Guides worn out or guide setting to wide	Guides too far apart, work out, or poorly adjusted guidearm loose.				Guides poorly adjusted	
	Band Wheels The band wheels have to be kept in good condition and properly aligned.	Band wheels worn or too small - try thinner bands						Driving wheel is work out
	Chip Brush Check that the chip brush is properly adjusted and change it regularly			Chip brush does not work; gullets filled		Chip brush does not work		
	Band Tension The correct band tension is needed to get a straight cut. Measure with Bahco tensionmeter	Band tension too high	Band tension too low				Band tension too low	Band tension too low
	Coolant/Cutting Fluid Need to lubricate and to cool. Check concentration with a Bahco refractometer. Use good coolant. It should reach the cut with low pressure and with generous flow.					Too little coolant or incorrect concentration		
Cutting Data	Band Speed The band speed has to be chosen correctly. Check the band speed by using a bahco tachometer.		Band speed too low		Band speed too low	Band speed too high	Natural vibration band speed slightly high low	
	Feed Rate The feed rate has to be chosen so that the teeth of the bandsaw blade can work properly.	Feed rate too high	Feed rate too high	Feed rate too high	Feed rate too high	Feed rate too high or too low	Feed rate too high or too low	Feed rate too high
Bandsaw Blade	Tooth Pitch The selection of the right tooth pitch is just as important as choosing the right feed and speed.		Tooth pitch too fine	Tooth pitch too fine gullets filled	Tooth pitch too coarse	Tooth pitch too fine		
	Tooth Shape Every tooth shape has its ideal application.			Tooth shape too weak		Wrong tooth shape selection	Use Combo	
	Break-in A new bandsaw blade should be broken in to obtain maximum bandsaw lifetime. Never saw in old kerf.				Band not properly run in	Band not properly run in	Band not properly run in	
	Blade Life All blades wear out eventually. Look for signs of wear.		Blade worn out		Blade worn out			Blade worn out
Workpiece	Surface A bad surface (scale) of the work piece will shorten the life of the blade. Lower the band speed.					Surface defects, i.e. scale, rust, sand		
	Clamping Securely clamp work pieces, especially when bundle cutting. Do not use bent or damages work pieces			Work piece moves			Work piece not properly clamped	



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