DISSTON®

A Cut Above Since 1840

BLU-MOL® | BLU-MOL XTREME® DISSTON | Aggressor® | RemGrit®

OUR HAND-MADE HISTORY

From the beginning, Henry Disston knew that to compete with the then superior English tools, he would need to make the best saw the world had ever known. That was 1840. With superior manufacturing, a vision for innovation, and an earnestness of spirit, Disston created saws manufactured to usher in a new industrial age. Today, Disston is a global manufacturer of hole saws, bandsaw blades, jig saw blades, reciprocating saw blades, drill bits, and other hand and power tool related accessories for the DIY, contractor and industrial markets. Its domestic operation is a state-of-the-art production facility in South Deerfield, MA. The company also operates fabrication and production enterprises overseas. Disston's international manufacturing and distribution capabilities combined with its history and tradition as a brand leader in the tool category for over 165 years provide its customers the optimum blend of value, performance and integrity.

Table of Contents

HOLE SAWS

Disston offers a wide range of hole saw types and sizes to fit your job. Hole saws and accessories are available in individual packaging and convenient sets.

Types of Hole Saws

Blu-Mol Xtreme® Bi-Metal

Features a revolutionary design that increases visibility, accuracy and improves battery and machine life. Diamond-shaped sidewall cutouts increase visibility while large openings on the backing plate allow for quick removal of cut materials. Fleem ground teeth for longer life.

Blu-Mol® Bi-Metal

Features high speed steel teeth for a sharper and longer lasting tool. Suitable for both wood and metal cutting.

Blu-Mol® Sheet Metal

Special eight teeth per inch ensures smoother cuts in sheet metal. Made to work with impact drivers. Ideal for the electrical tradesman.

Blu-Mol® Tungsten Carbide Tipped Hole Cutters

Cutting is based on new metal cutting technology. Tungsten Carbide Tip (TCT) cuts holes in thick metals for very fast boring. Available in Tri-Cut and Standard styles.

Blu-Mol® Carbide Tipped

Efficiently cuts abrasive materials with greater heat and wear resistance than bi-metal saws. Three teeth per inch delivers aggressive cut.

Blu-Mol® Carbon Steel

Patented arbored design is packaged in clamshells. Hole saws and accessories also available in convenient sets. Specifically developed for the occasional user.

RemGrit® Carbide Grit

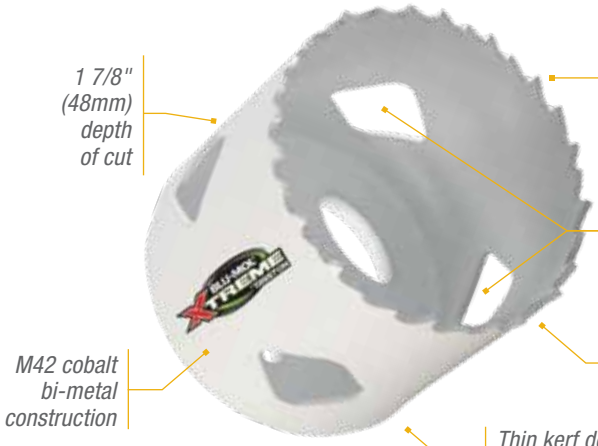
Carbide grit offers the greatest wear and heat resistance. Ideal for materials that other saws will not cut, this saw cuts extremely abrasive materials with no teeth to chip or dull.

RemGrit® Carbide Grit Recessed Light Installation Kit

Carbide grit cutting edge easily cuts through ceiling tile and drywall. Everything you need to install recessed lighting fixtures fast.

BI-METAL HOLE SAWS

Large openings on the backing plate allow for quick removal of cut materials. The diamond-shaped sidewall cutouts increase visibility while cutting. Patented design.



COBALT INDUSTRIAL GRADE M42 STEEL

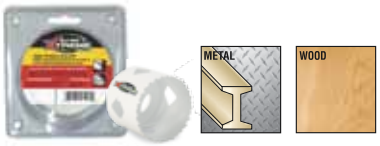
UP TO 24% LONGER LIFE

13 Piece Journeyman's Bi-Metal Hole Saw Kit Model # D9596

METAL WOOD

Blu-Mol® Xtreme Bi-Metal Hole Saw Kits

KIT DESCRIPTION	MODEL#	PRODUCT CODE
7 Pc. Handyman's Kit Kit Includes: 5 Hole Saws: 7/8"(22mm), 1"(25mm), 1-1/8"(29mm), 1-1/4"(32mm), 1-1/2"(38mm); Mandrel (1), Mandrel Adapter (1), in Heavy Duty Case.	D9595	E0212169
9 Pc. Locksmith's Kit Kit Includes: 6 Hole Saws: 7/8"(22mm), 1"(25mm), 1-1/4"(32mm), 1-1/2"(38mm), 1 3/4"(44mm), 2-1/8"(54mm); Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	D9591	E0212165
9 Pc. Plumber's Kit Kit Includes: 6 Hole Saws: 3/4"(19mm), 7/8"(22mm), 1-1/8"(29mm), 1-1/2"(38mm), 1-3/4"(44mm), 2-1/4"(57mm); Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	D9592	E0212166
9 Pc. Electrician's Kit Kit Includes: 6 Hole Saws: 7/8"(22mm), 1-1/8"(29mm), 1-3/8"(35mm), 1-3/4"(44mm), 2"(51mm), 2-1/2"(64mm); Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	D9593	E0212167
9 Pc. Electrician's Kit - Metric Kit Includes: 6 Hole Saws: 16mm (5/8"), 20mm, 25mm (1"), 32mm (1-1/4"), 40mm (1-9/16"), 51mm (2"); Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	D9593M	E0212168
13 Pc. Journeyman's Kit Kit Includes: 9 Hole Saws: 3/4"(19mm), 7/8"(22mm), 1-1/8"(29mm), 1-3/8"(35mm), 1-1/2"(38mm), 1-3/4"(44mm), 2"(51mm), 2-1/4"(57mm), 2-1/2"(64mm); Mandrels (2), Mandrel Adapter (1), Pilot Drill (1), in Heavy Duty Case.	D9596	E0212170
20 Pc. Industrial Kit Kit Includes: 15 Hole Saws: 3/4"(19mm), 7/8"(22mm), 1-1/8"(29mm), 1-3/8"(35mm), 1-1/2"(38mm), 1-3/4"(44mm), 2"(51mm), 2-1/4"(57mm), 2-1/2"(64mm), 3"(76mm), 3-1/4"(83mm), 3-5/8"(92mm), 3-3/4"(95mm), 4-1/8"(105mm), 4-1/2"(114mm), Mandrels (2), Mandrel Adapter (1), Pilot Drill (1), 12" Extension (1), in Heavy Duty Steel Case.	D9599	E0212171



Blu-Mol® Xtreme Bi-Metal Hole Saws (Clamshelled)

DIAMETER INCHES	DIAMETER MM	MODEL#	PRODUCT CODE
9/16	14	5855B	E0211309
5/8	16	5856B	E0211311
11/16	17	5857B	E0211312
3/4	19	5127B	E0212714
--	20	5888B	E0211342
13/16	21	5858B	E0211313
7/8	22	5128B	E0210492
15/16	24	5859B	E0211314
1	25	5197B	E0210642
1-1/16	27	5860B	E0211315
1-1/8	29	5130B	E0210509
1-3/16	30	5861B	E0211316
1-1/4	32	5131B	E0210511
1-5/16	33	5862B	E0211317
1-3/8	35	5132B	E0210513
1-7/16	37	5863B	E0211318
1-1/2	38	5198B	E0210644
1-9/16	40	5864B	E0211319
1-5/8	41	5133B	E0210515
1-11/16	43	5865B	E0211320
1-3/4	44	5134B	E0210517
--	45	M5134B	E0214033
1-13/16	46	5866B	E0211321
1-7/8	48	5135B	E0210519
--	50	M5136B	E0214034
2	51	5136B	E0210521
2-1/16	52	5867B	E0211322
2-1/8	54	5199B	E0210646
--	55	M5199B	E0214035
2-1/4	57	5137B	E0210523
2-5/16	59	5868B	E0211323
2-3/8	60	5139B	E0210527
2-1/2	64	5138B	E0210525
2-9/16	65	5869B	E0211324
2-5/8	67	5870B	E0211325
--	68	M5149B	E0212405
2-3/4	70	5871B	E0211327
2-7/8	73	5872B	E0211328
--	75	M5150B	E0214036
3	76	5150B	E0210560
3-1/8	79	5873B	E0211329
3-1/4	83	5874B	E0211330
3-3/8	86	5875B	E0211331
3-1/2	89	5151B	E0210562
3-5/8	92	5876B	E0211332
3-3/4	95	5877B	E0211333
3-7/8	98	5878B	E0211334
--	100	M5152B	E0214037
4	102	5152B	E0210564
4-1/8	105	5879B	E0211335
4-1/4	108	5880B	E0211336
4-3/8	111	5881B	E0211337
4-1/2	114	5153B	E0210566
4-3/4	121	5882B	E0211338
5	127	5154B	E0210567
5-1/2	140	5155B	E0210568
5-3/4	146	5883B	E0211339
6	152	5156B	E0210569

BI-METAL HOLE SAW DISPLAY

NEW!

Unique point-of-purchase merchandiser to maximize your sale. Everything you need to get started, including header, vinyl, peg hooks and 2 pieces of each product.

NEW!

E0320098
Dimensions: 32" x 39" (813mm x 991mm)

DIAMETER INCHES	MM	QTY PER DISPLAY	XTREME (E0320098)
5/8	16	2	E0211311
3/4	19	2	E0212714
7/8	22	2	E0210492
1	25	2	E0210642
1-1/16	27	2	E0211315
1-1/8	29	2	E0210509
1-1/4	32	2	E0210511
1-3/8	35	2	E0210513
1-1/2	38	2	E0210644
1-5/8	41	2	E0210515
1-3/4	44	2	E0210517
1-7/8	48	2	E0210519
2	51	2	E0210521
2-1/8	54	2	E0210646
2-1/4	57	2	E0210523
2-1/2	64	2	E0210525
2-5/8	67	2	E0211325
3	76	2	E0210560
3-1/4	83	2	E0211330
3-1/2	89	2	E0210562
3-5/8	92	2	E0211332
3-3/4	95	2	E0211333
4	102	2	E0210564
4-1/8	105	2	E0211335
4-1/2	114	2	E0210566
4-3/4	121	2	E0211338
5	127	2	E0210567
6	152	2	E0210569
Mandrel (No Pin)	--	2	E0102457
Mandrel w/Pin	--	2	E0102460
Adapter/ Washer	--	2	E0102462
Pilot	--	5	E0114470
Journeymans Kit	--	2	E0212170
Vinyl	--	1	E2121331
Header	--	1	E2121330
Peg Hooks	--	36	E2121641

Application Information.

- Creates holes for pipe, tubing installations, door lock installations, electrical conduit, hoses and antennas.
- Ideal for plumbing, construction, aircraft, electrical, maintenance and automotive applications.
- Heavy duty use in metals,woods and plastics.

Blu-Mol® Xtreme Hole Saw Accessories

TYPE/SIZE	BLU-MOL BOXED	
MANDRELS	MODEL#	PRODUCT CODE
3/8" Hex for Hole Saws 9/16" - 1-3/16"	5514	E0102457
3/8" Hex for Hole Saws 1-1/4" - 4"	5519	E0102458
3/8" Hex Shank Quick Change Pinned for Hole Saws 1-1/4" - 6"	5546	E0102460
Mandrel Adapter (Carded)	5511	E0102462

TYPE/SIZE	10/BOX		CARDED	
PILOT DRILLS	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
3-1/4" x 1/4"	8534	E0102463	6524	E0114470

TYPE/SIZE	BOXED		CARDED	
EXTENSIONS	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
3/8" x 12" Extension	6558	E0101668	--	--

PARTS (Mandrel Set Screws)	MODEL#	PRODUCT CODE
Replacement set screw pack includes: (3 for Mandrel #'s 5514, 5519 and 3 for Mandrel #'s 5546)	SS1	E0103109

5511

5514

5519

5546

8534

12" Extension for Round and Hex Shanks

www.disstontools.com

BLU-MOL® BI-METAL HOLE SAWS

M42 cobalt bi-metal cutting edge provides shock resistant teeth and resists tooth strippage. 4/6 positive tooth configuration allows for fast, smooth cuts and less vibration.

4/6 variable tooth configuration

1 7/8" (48 mm) depth of cut

M42 cobalt bi-metal construction

3/16" (5 mm) thick heavy-duty backing plate eliminates need for drive plate

Thin kerf design
- *0.044" thickness for faster cutting*
- *Prolongs battery life when used on cordless tools*

COBALT INDUSTRIAL GRADE M42 STEEL

UP TO 24% LONGER LIFE

13 Piece Journeyman's Bi-Metal Hole Saw Kit Model # 9596

Blu-Mol® Bi-Metal Hole Saw Kits

KIT DESCRIPTION	MODEL#	PRODUCT CODE
7 Pc. Handyman's Kit Kit Includes: 5 Hole Saws: 7/8"(22mm), 1"(25mm), 1-1/8"(29mm), 1-1/4"(32mm), 1-1/2"(38mm); Mandrel (1), Mandrel Adapter (1), in Heavy Duty Case.	9595	E0103111
9 Pc. Locksmith's Kit Kit Includes: 6 Hole Saws: 7/8"(22mm), 1"(25mm), 1-1/4"(32mm), 1-1/2"(38mm), 1 3/4"(44mm), 2-1/8"(54mm); Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	9591	E0103112
9 Pc. Plumber's Kit Kit Includes: 6 Hole Saws: 3/4"(19mm), 7/8"(22mm), 1-1/8"(29mm), 1-1/2"(38mm), 1-3/4"(44mm), 2-1/4"(57mm); Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	9592	E0103113
9 Pc. Electrician's Kit Kit Includes: 6 Hole Saws: 7/8"(22mm), 1-1/8"(29mm), 1-3/8"(35mm), 1-3/4"(44mm), 2"(51mm), 2-1/2"(64mm); Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	9593	E0103114
9 Pc. Electrician's Kit - Metric Kit Includes: 6 Hole Saws: 16mm (5/8"), 20mm, 25mm (1"), 32mm (1-1/4"), 40mm (1-9/16"), 51mm (2"); Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	9593M	E0103115
13 Pc. Journeyman's Kit Kit Includes: 9 Hole Saws: 3/4"(19mm), 7/8"(22mm), 1-1/8"(29mm), 1-3/8"(35mm), 1-1/2"(38mm), 1-3/4"(44mm), 2"(51mm), 2-1/4"(57mm), 2-1/2"(64mm); Mandrels (2), Mandrel Adapter (1), Pilot Drill (1), in Heavy Duty Case.	9596	E0103116
20 Pc. Industrial Kit Kit Includes: 15 Hole Saws: 3/4"(19mm), 7/8"(22mm), 1-1/8"(29mm), 1-3/8"(35mm), 1-1/2"(38mm), 1-3/4"(44mm), 2"(51mm), 2-1/4"(57mm), 2-1/2"(64mm), 3"(76mm), 3-1/4"(83mm), 3-5/8"(92mm), 3-3/4"(95mm), 4-1/8"(105mm), 4-1/2"(114mm), Mandrels (2), Mandrel Adapter (1), Pilot Drill (1), 12" Extension (1), in Heavy Duty Steel Case.	9599	E0103117

Blu-Mol® Bi-Metal Hole Saws (Boxed)

DIAMETER INCHES	MM	MODEL#	PRODUCT CODE
9/16	14	509	E0102399
5/8	16	510	E0102400
11/16	17	511	E0102401
3/4	19	512	E0102402
--	20	M513	E0102403
13/16	21	513	E0102404
7/8	22	514	E0102405
15/16	24	515	E0102406
1	25	516	E0102407
1-1/16	27	517	E0102408
1-1/8	29	518	E0102409
1-3/16	30	519	E0102410
1-1/4	32	520	E0102411
1-5/16	33	521	E0102412
1-3/8	35	522	E0102413
1-7/16	37	523	E0102414
1-1/2	38	524	E0102415
1-9/16	40	525	E0102416
1-5/8	41	526	E0102417
1-11/16	43	527	E0102418
1-3/4	44	528	E0102419
--	45	M528	E0102420
1-13/16	46	529	E0102421
1-7/8	48	530	E0102422
--	50	M532	E0102423
2	51	532	E0102424
2-1/16	52	533	E0102425
2-1/8	54	534	E0102426
--	55	M534	E0102427
2-1/4	57	536	E0102428
2-5/16	59	537	E0102429
2-3/8	60	538	E0102430
2-1/2	64	540	E0102431
2-9/16	65	541	E0102432
2-5/8	67	542	E0102433
--	68	M542	E0102434
2-3/4	70	544	E0102435
2-7/8	73	546	E0102436
--	75	M548	E0102437
3	76	548	E0102438
3-1/8	79	550	E0102439
3-1/4	83	552	E0102440
3-3/8	86	554	E0102441
3-1/2	89	556	E0102442
3-5/8	92	558	E0102443
3-3/4	95	560	E0102444
3-7/8	98	562	E0102445
--	100	M564	E0102446
4	102	564	E0102447
4-1/8	105	566	E0102448
4-1/4	108	568	E0102449
4-3/8	111	570	E0102450
4-1/2	114	572	E0102451
4-3/4	121	576	E0102452
5	127	580	E0102453
5-1/2	140	588	E0102454
5-3/4	146	592	E0102455
6	152	596	E0102456

BLU-MOL® BI-METAL HOLE SAW DISPLAY NEW!

Unique point-of-purchase merchandiser to maximize your sale. Everything you need to get started, including header, vinyl, peg hooks and 2 pieces of each product.

NEW!

E0320097
Dimensions: 32" x 39" (813mm x 991mm)

DIAMETER INCHES	DIAMETER MM	QTY PER DISPLAY	BLU-MOL (E0320097)
5/8	16	2	E0102400
3/4	19	2	E0102402
7/8	22	2	E0102405
1	25	2	E0102407
1-1/16	27	2	E0102408
1-1/8	29	2	E0102409
1-1/4	32	2	E0102411
1-3/8	35	2	E0102413
1-1/2	38	2	E0102415
1-5/8	41	2	E0102417
1-3/4	44	2	E0102419
1-7/8	48	2	E0102422
2	51	2	E0102424
2-1/8	54	2	E0102426
2-1/4	57	2	E0102428
2-1/2	64	2	E0102431
2-5/8	67	2	E0102433
3	76	2	E0102438
3-1/4	83	2	E0102440
3-1/2	89	2	E0102442
3-5/8	92	2	E0102443
3-3/4	95	2	E0102444
4	102	2	E0102447
4-1/8	105	2	E0102448
4-1/2	114	2	E0102451
4-3/4	121	2	E0102452
5	127	2	E0102453
6	152	2	E0102456
Mandrel (No Pin)	--	2	E0102457
Mandrel w/Pin	--	2	E0102460
Adapter/ Washer	--	2	E0102462
Pilot	--	5	E0114470
Journeymans Kit	--	2	E0103116
Vinyl	--	1	E2121633
Header	--	1	E2121253
Peg Hooks	--	36	E2121641

Application Information.

- Creates holes for pipe, tubing installations, door lock installations, electrical conduit, hoses and antennas.
- Ideal for plumbing, construction, aircraft, electrical, maintenance and automotive applications.
- Use in steel, aluminum, brass, cast iron, plastic or wood.

Blu-Mol® Hole Saw Accessories

TYPE/SIZE	BLU-MOL BOXED	
MANDRELS	MODEL#	PRODUCT CODE
3/8" Hex for Hole Saws 9/16" - 1-3/16"	5514	E0102457
3/8" Hex for Hole Saws 1-1/4" - 4"	5519	E0102458
3/8" Hex Shank Quick Change Pinned for Hole Saws 1-1/4" - 6"	5546	E0102460
Mandrel Adapter (Carded)	5511	E0102462

TYPE/SIZE	10/BOX		CARDED	
PILOT DRILLS	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
3-1/4" x 1/4"	8534	E0102463	6524	E0114470

TYPE/SIZE	BOXED		CARDED	
EXTENSIONS	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
3/8" x 12" Extension	6558	E0101668	--	--

PARTS (Mandrel Set Screws)	MODEL#	PRODUCT CODE
Replacement set screw pack includes: (3 for Mandrel #'s 5514, 5519 and 3 for Mandrel #'s 5546)	SS1	E0103109

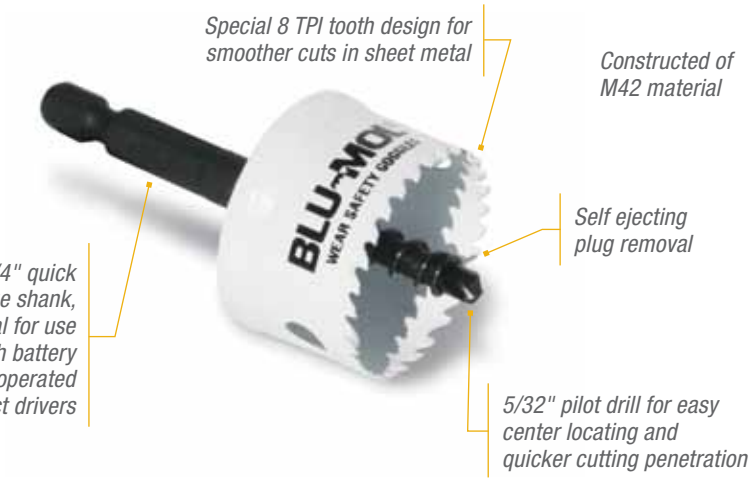
5511

5514 5519 5546 8534

12" Extension for Round and Hex Shanks

BLU-MOL® SHEET METAL HOLE SAWS

Ideal for the electrical and plumbing tradesman. Hole saw has a thin .020" (0.5 mm) sidewall blade thickness, which allows for faster cutting and longer battery life. Ideal for chargeable impact drivers.



Blu-Mol® Sheet Metal Hole Saws* (Boxed)

SHEET METAL

DIAMETER INCHES	MM	MODEL#	PRODUCT CODE
5/8"	16	6918	E0102325
3/4"	19	6919	E0102326
--	20	6920	E0102327
7/8"	22	6921	E0102328
1"	25	6922	E0102329
1-1/16"	27	6923	E0102330
1-1/8"	29	6924	E0102331
1-3/16"	30	6925	E0102332
1-1/4"	32	6926	E0102333
1-3/8"	35	6927	E0102334
1-1/2"	38	6928	E0102335

Application Information.

- 0.02" blade thickness made to use with chargeable impact drivers.
- Ideal for the electrical and plumbing tradesman, construction, aircraft, maintenance and automotive applications.
- Use in thin applications of mild steel, brass, aluminum, stainless steel, or plastic.

SMOOTH AND FAST CUTTING

Specially designed tooth geometry assures increased performance and better wear resistance.

THE POWER OF THE THIN BLADE

Lightweight blades maximize the use of chargeable impact drivers by using a reduced motor and operation load.

Safety collar stop helps prevent cutting too deep

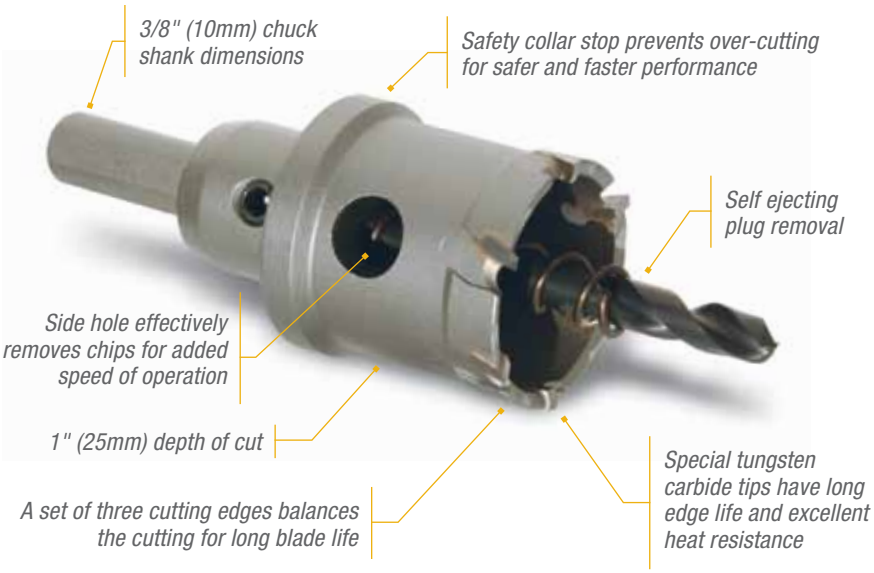
SAFETY COLLAR STOP

Safety collar stop helps prevent damage to wires when drilling into electrical boxes.

Lead times may vary. Please contact your Sales Representative for more information.

TRI-CUT TUNGSTEN CARBIDE TIPPED HOLE CUTTERS

Tungsten carbide tips with three distinct cutting edges balances the cutting for longer blade life and heat resistance. For cutting steels up to 1" (25mm) thick.



Tri-Cut Tungsten Carbide Hole Cutters (Clamshelled)

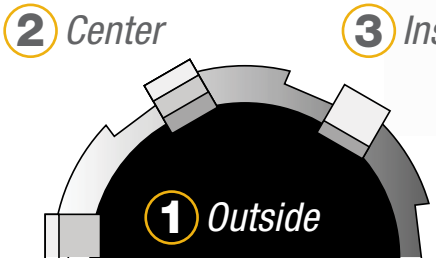
DIAMETER INCHES	MM	MODEL#	PRODUCT CODE
5/8"	16	3140	E0102336
11/16"	17	3141	E0102337
3/4"	19	3142	E0102338
--	20	3205	E0102554
13/16"	21	3143	E0102339
7/8"	22	3144	E0102340
15/16"	24	3145	E0102341
1"	25	3146	E0102342
1-1/16"	27	3147	E0102343
1-1/8"	29	3148	E0102344
1-3/16"	30	3149	E0102345
1-1/4"	32	3150	E0102346
1-5/16"	33	3151	E0102347
1-3/8"	35	3152	E0102348
1-7/16"	37	3153	E0102349
1-1/2"	38	3154	E0102350
1-9/16"	40	3155	E0102351
1-5/8"	41	3156	E0102352
1-11/16"	43	3157	E0102353
1-3/4"	44	3158	E0102354
1-13/16"	46	3159	E0102355
1-7/8"	48	3160	E0102356
1-15/16"	49	3161	E0102357
2"	51	3162	E0102358

Application Information.

- For cutting thick steel, iron, aluminum, steel plate, pipe and stainless steel up to 1" (25mm) thick.

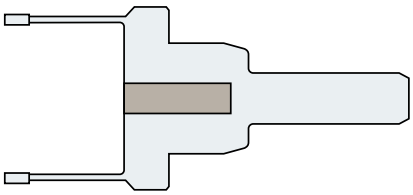
Blu-Mol® Tri-Cut Tungsten Carbide Tipped Hole Cutter Accessories (Carded)

KIT DESCRIPTION	MODEL#	PRODUCT CODE
Pilot Drill, Spring & Set Screw for Tri-Cut TCT Cutter	3163	E0102323



TRI-CUT SYSTEM

There are three different edged cutting blades. One blade slanted outward, one inward and one that peaks in the center. This arrangement balances the cutting effort for smooth boring, better control and less chance of excess drag.

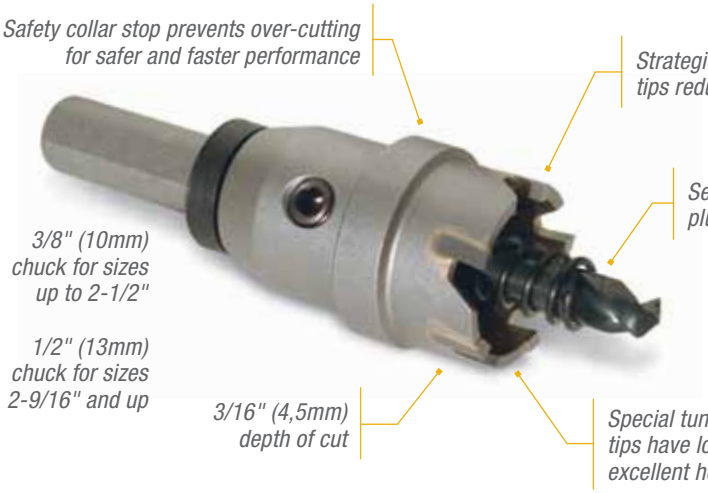


UNI-BODY CONSTRUCTION

The arbored hole cutter has solid construction that eliminates play between the shank and the body, resulting in sharp, crisp, smooth cutting.

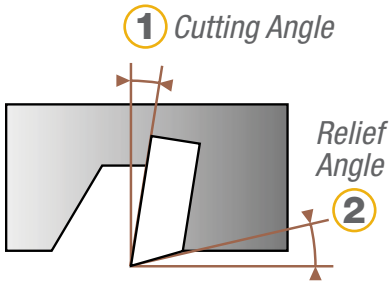
BLU-MOL® STANDARD TUNGSTEN CARBIDE TIPPED HOLE CUTTERS

Tungsten carbide tips have excellent wear and heat resistance. Light, smooth cutting entry with great boring speed. For cutting steels up to 3/16" (4,5mm) thick.



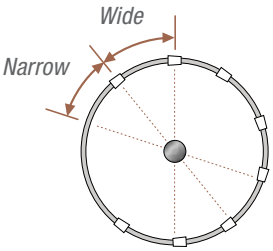
Application Information.

- For cutting stainless steel, steel, aluminum and cast iron up to 3/16" (4,5mm) thick.

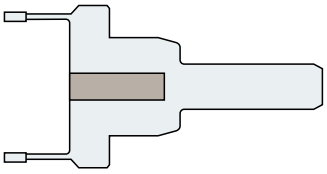


LIGHT AND SMOOTH CUTTING

The tungsten carbide tips are excellent in durability due to ideal blade angles based on the latest metal cutting technology.

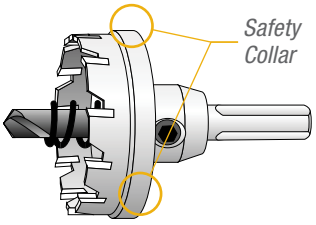


Variable tip placement reduces vibration.



UNI-BODY CONSTRUCTION

The arbored hole cutter has solid construction that eliminates play between the shank and the body, resulting in sharp, crisp, smooth cutting.



SAFE DESIGN

For both safety and prevention of damage to the material being cut, there is a safety collar, which acts as a stop. It prevents over-cutting and loss of control.

Standard Tungsten Carbide Hole Cutters (Clamshelled)

DIAMETER INCHES	MM	MODEL#	PRODUCT CODE
9/16"	14	3164	E0102359
5/8"	16	3165	E0102360
11/16"	17	3166	E0102361
3/4"	19	3167	E0102362
--	20	3206	E0102555
13/16"	21	3168	E0102363
7/8"	22	3169	E0102364
15/16"	24	3170	E0102365
1"	25	3171	E0102366
1-1/16"	27	3172	E0102367
1-1/8"	29	3173	E0102368
1-3/16"	30	3174	E0102369
1-1/4"	32	3175	E0102370
1-5/16"	33	3176	E0102371
1-3/8"	35	3177	E0102372
1-7/16"	37	3178	E0102373
1-1/2"	38	3179	E0102374
1-9/16"	40	3180	E0102375
1-5/8"	41	3181	E0102376
1-11/16"	43	3182	E0102377
1-3/4"	44	3183	E0102378
1-13/16"	46	3184	E0102379
1-7/8"	48	3185	E0102380
1-15/16"	49	3186	E0102381
2"	51	3187	E0102382
2-1/16"	52	3188	E0102383
2-1/8"	54	3189	E0102384
2-3/16"	56	3190	E0102385
2-1/4"	57	3191	E0102386
2-5/16"	59	3192	E0102387
2-3/8"	60	3193	E0102388
2-7/16"	62	3194	E0102389
2-1/2"	64	3195	E0102390
2-9/16"	65	3196	E0102391
2-5/8"	67	3197	E0102392
2-11/16"	68	3198	E0102393
2-3/4"	70	3199	E0102394
2-7/8"	73	3201	E0102396
3"	76	3203	E0102398

Blu-Mol® Standard Tungsten Carbide Tipped Hole Cutter Accessories (Carded)

KIT DESCRIPTION	MODEL#	PRODUCT CODE
Pilot Drill, Spring & Set Screw for Std. TCT Cutter	3204	E0102324

Lead times may vary. Please contact your Sales Representative for more information.

HOLE SAWS

BLU-MOL® CARBIDE TIPPED HOLE SAWS

Carbide tip allows for greater heat and wear resistance than bi-metal. Provides up to 10 times greater tool life on abrasive materials.

3/16" (5 mm) thick heavy-duty backing plate eliminates the need for drive plate

3 teeth per inch for aggressive cutting.

1 5/8" (41 mm) depth of cut

Application Information.

- Ideal for plumbing, marine and aircraft applications.
- Use in wood laminates, fiberglass, plywood and tile.

13 Piece Carbide Tipped Hole Saw Kit Model # C9596

Blu-Mol® Carbide Tipped Hole Saw Kit

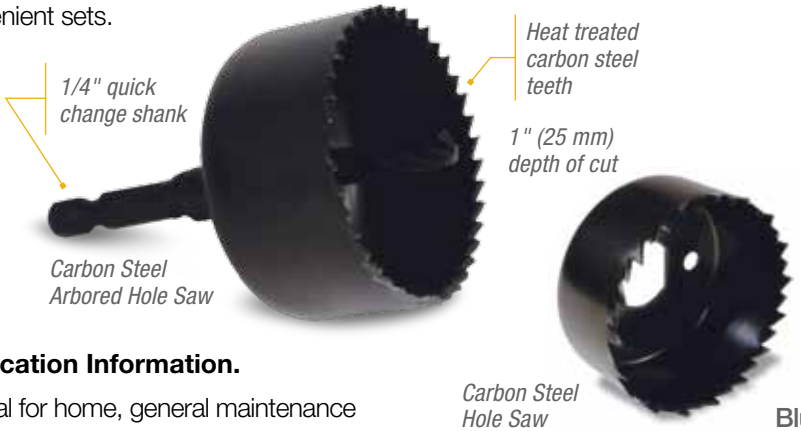
KIT DESCRIPTION	MODEL#	PRODUCT CODE
13 Pc Carbide Tipped Hole Saw Kit Includes: 1 each 3/4"(19mm), 7/8"(22mm), 1-1/8"(29mm), 1-3/8"(35mm), 1-1/2"(38mm), 1-3/4"(44mm), 2"(51mm), 2-1/4"(57mm) & 2-1/2"(64mm) hole saws; 2 mandrels; mandrel adapter and carbide tipped pilot drill bits in a plastic case	C9596	E0212384

Blu-Mol® Carbide Tipped Hole Saws (Boxed)

DIAMETER INCHES	DIAMETER MM	MODEL#	PRODUCT CODE
11/16	17	C11	E0103118
3/4	19	C12	E0103119
7/8	22	C14	E0103120
1	25	C16	E0103121
1-1/8	29	C18	E0103122
1-1/4	32	C20	E0103123
1-3/8	35	C22	E0103124
1-1/2	38	C24	E0103125
1-5/8	41	C26	E0103126
1-3/4	44	C28	E0103127
2	51	C32	E0103128
2-1/8	54	C34	E0103129
2-1/4	57	C36	E0103130
2-3/8	60	C38	E0103131
2-1/2	64	C40	E0103132
2-9/16	65	C41	E0103133
2-5/8	67	C42	E0103134
3	76	C48	E0103135
3-1/4	83	C52	E0103136
3-3/8	86	C54	E0103137
3-1/2	89	C56	E0103138
3-5/8	92	C58	E0103139
3-3/4	95	C60	E0103140
4	102	C64	E0103141
4-1/8	105	C66	E0103142
4-1/4	108	C68	E0103143
4-1/2	114	C72	E0103144
4-3/4	121	C76	E0103145
5	127	C80	E0103146
5-1/2	140	C88	E0103147
6	152	C96	E0103148

BLU-MOL® CARBON STEEL HOLE SAWS

Specifically developed for the occasional user. Patented arbored design is packaged in clamshells. Hole saws and accessories also available in convenient sets.



1/4" quick change shank

Heat treated carbon steel teeth

1" (25 mm) depth of cut

Carbon Steel Arbored Hole Saw

Carbon Steel Hole Saw

Application Information.

- Ideal for home, general maintenance and light duty applications.
- Use in wood, wallboard and plastic.

5 Piece Carbon Steel Hole Saw Set Model # 6560

7 Piece Carbon Steel Hole Saw Set Model # 6561

Blu-Mol® Carbon Steel Arbored Hole Saws (Clamshelled)

DIAMETER INCHES	DIAMETER MM	MODEL#	MINIMUM ORDER QTY.	PRODUCT CODE
1	25	6501	5	E0114453
1-1/4	32	6502	5	E0114454
1-1/2	38	6503	5	E0114455
1-3/4	44	6504	5	E0114456
2	51	6506	5	E0114457
2-1/8	54	6507	5	E0114458
2-1/4	57	6508	5	E0114459
2-1/2	64	6509	5	E0114460

Blu-Mol® Carbon Steel Hole Saw Kits

KIT DESCRIPTION	MODEL#	MINIMUM ORDER QTY.	PRODUCT CODE
5 Pc Carbon Hole Saw Kit Includes: 1 each 1-1/4"(32mm), 1-1/2"(38mm), 1-3/4"(44mm) & 2-1/8"(54mm) holes saws; mandrel w/pilot drill in a plastic storage tube	6560	5	E0114489
7 Pc Carbon Hole Saw Kit Includes: 1 each 1-1/4"(32mm), 1-3/8"(35mm), 1-1/2"(38mm), 1-3/4"(44mm), 2"(51mm) & 2-1/8"(54mm) hole saws; mandrel w/pilot drill in a plastic case	6561	5	E0114490

RemGrit® CARBIDE GRIT HOLE SAWS

Cuts extremely hard abrasive materials. Cutting edge of tungsten carbide particles bonded to alloy steel back. High heat and abrasion resistance, no teeth to dull or chip, resists snagging, smooth cutting, greater wear resistance.

3/16" (5 mm) thick heavy-duty backing plate eliminates drive hole elongation and the need for drive plate

RemGrit hole saws (without arbors) feature a gulleted grit edge

1-7/16" (37 mm) depth of cut

Application Information.

- Recommended for cutting laminates, fiberglass, ceramic tile, marble, slate, cast iron and composites.
- Ideal for plumbing, construction, marine and aircraft applications.

One-Piece Arbored 1-1/4" Hole Saw Model # OGC20BL

RemGrit arbored hole saws feature a continuous grit edge

1/4" quick change shank

7/8" (22 mm) depth of cut

RemGrit® Carbide Grit Arbored Hole Saws (Clamshelled)

TILE | CAST IRON | FIBERGLASS

DIAMETER INCHES	DIAMETER MM	MODEL#	MINIMUM ORDER QTY.	PRODUCT CODE
1	25	OGC16BL	2	E0104577
1-1/4	32	OGC20BL	2	E0104578
1-1/2	38	OGC24BL	2	E0104579
1-3/4	44	OGC28BL	2	E0104580
2	51	OGC32BL	2	E0104581
2-1/8	54	OGC34BL	2	E0104582
2-1/4	57	OGC36BL	2	E0104583
2-1/2	64	OGC40BL	2	E0104584

TILE | CAST IRON | FIBERGLASS

RemGrit® Carbide Grit Hole Saws (Boxed)

DIAMETER INCHES	DIAMETER MM	MODEL#	PRODUCT CODE
5/8	16	G010M	E0206026
3/4	19	G012	E0206001
--	20	G013M	E0206027
7/8	22	G014	E0206002
1	25	G016	E0206003
1-1/8	29	G018	E0206004
1-1/4	32	G020	E0206005
1-3/8	35	G022	E0206006
1-1/2	38	G024	E0206007
1-3/4	44	G028	E0206008
1-7/8	48	G030	E0206023
2	51	G032	E0206009
2-1/8	54	G034	E0206010
2-1/4	57	G036	E0206011
2-3/8	60	G038	E0206024
2-1/2	64	G040	E0206022
2-3/4	70	G044	E0206013
3	76	G048	E0206014
3-1/4	83	G052	E0206015
3-3/8	86	G054	E0206016
3-3/4	95	G060	E0206025
4	102	G064	E0206017
4-1/2	114	G072	E0206018

RemGrit® Carbide Grit Hole Saw Mandrels (Boxed) & Pilot Drills (Carded)

TYPE/SIZE	MODEL#	PRODUCT CODE
MANDRELS		
3/8" Hex Shank for Hole Saws 9/16" - 1-3/16"	5519RG	E0102841
3/8" Hex Shank Quick Change Pinned for Hole Saws 1-1/4" - 6"	5546RG	E0102855
PILOT DRILLS		
3-1/4" x 1/4" Carbide Tipped	8538RG	E0103107

RemGrit® CARBIDE GRIT RECESSED LIGHT INSTALLATION KITS

Complete kits for any recessed light installation job. The carbide grit cutting edge easily cuts through ceiling tile and drywall. Recessed light kits are available for 4", 5" and 6" lighting fixtures.

FIBERGLASS

4" Carbide Grit Hole Saw Kit Model # GRL402

RemGrit® Carbide Grit Recessed Light Installation Kits & Accessories

KIT DIAMETER INCHES	KIT DIAMETER MM	MODEL#	PRODUCT CODE
4-3/8	111	GRL402	E0101680
5-3/8	137	GRL502	E0101681
6-3/8	162	GRL602	E0101682

Driller Dust Bowl Model # DB-1

RemGrit® Carbide Grit Recessed Light Installation Kits & Accessories

ACCESSORY	MODEL#	PRODUCT CODE
Dust Bowl	DB-1	E0215000

BLU-MOL®
LOCK INSTALLATION KITS

TYPE/SIZE	MODEL#	MINIMUM ORDER QTY.	PRODUCT CODE
Professional Bi-Metal Lock Installation Kit Includes: 1 each 1" & 2-1/8" hole saws, guide, assembled mandrel and mandrel adapter	6574	5	E0101949
Door Latch Mortise Tool	6575	5	E0101959
Bi-Metal Lock Installation Kit Includes: 1 each 1" & 2-1/8" hole saws, guide, assembled mandrel and mandrel adapter	6556	6	E0114493

Metal/Wood Door Lock Installation Kit Model # 6556

Door Latch Mortise Tool Model # 6575

Professional Door Lock Installation Kit Model # 6574

Tech Tips for Hole Saws

- Always wear eye protection.
- Always be sure that the pilot drill extends beyond the cutting edge of the saw by at least 1/8".
- Be sure to secure the material to be cut to keep it from spinning or slipping.
- Be sure to start the cutting process with the saw square to the material being cut. This will ensure that all teeth begin to cut at the same time and will help prevent premature wear and damage to the saw.
- Be sure to follow the recommended operating speed for the saw size and the material being cut.
- Operator should feed the saw in and out to allow the material shavings to clear out of the hole being cut.
- Cutting oils or lubricants should be used to extend the life of the saw, except when cutting wood or cast iron.
- Occasionally check the mandrel's drive pins to be sure they are still fully engaged in the saw and that they have not vibrated out of the drive holes in the saw.
- When sawing in wood, finish the hole from the opposite side to prevent splintering. Once the pilot drill has broken through the other side, you can use this hole to guarantee you are in line with where you have already started cutting.
- When sawing resistant and difficult to cut materials, drill a couple of small holes on the circumference to allow chips to clear.
- Keep an oil soaked sponge inside the hole saw if you:
  - Cannot lubricate in the normal way
  - Operate in stainless steel
  - Operate in a vertical position from above

Tech Tips for Pipe Tap & Pipe Entrance

- Pipe Taps are used for threading holes created by a hole saw to receive a threaded pipe. Reference the product charts for proper selection. To cut a hole for a 1" pipe tap, select a 1-1/8" hole saw.
- Pipe Entrance is the diameter for the hole through which a pipe of a given diameter will pass during installation or repair.
- Pipe Size is defined by the inside diameter. Reference chart on page 16 for proper selection. To cut a hole through which a ¾" pipe may be passed, a 1-1/8" hole saw is used.
- Tubing Size is defined by the outside diameter. To cut an entrance hole of a given tubing diameter, the same diameter hole saw should be used.

Lead times may vary. Please contact your Sales Representative for more information.

Hole Saw Size Reference Chart

Diameter		Pipe Tap Diameter		Pipe Entrance Diameter										
inches	mm	inches	mm	inches	mm	Xtreme	Blu-Mol	Sheet Metal	Xtreme Tri-Cut TCT	STD TCT	Carbide Tipped	Carbon Arbored	RemGrit	RemGrit Arbored
9/16	14	--	--	--	--	5855B	509			3164				
5/8	16	--	--	--	--	5856B	510	6918	3140	3165			G010M	
11/16	17	--	--	--	--	5857B	511		3141	3166	C11			
3/4	19	1/2	13	3/8	10	5127B	512	6919	3142	3167	C12		G012	
--	20	--	--	--	--	5888B	M513	6920	3205	3206			G013M	
13/16	21	--	--	--	--	5858B	513		3143	3168				
7/8	22	3/4	19	1/2	13	5128B	514	6921	3144	3169	C14		G014	
15/16	24	--	--	--	--	5859B	515		3145	3170				
1	25	--	--	--	--	5197B	516	6922	3146	3171	C16	6501	G016	OGC16BL
1-1/16	27	--	--	--	--	5860B	517	6923	3147	3172				
1-1/8	29	1	25	3/4	19	5130B	518	6924	3148	3173	C18		G018	
1-3/16	30	--	--	--	--	5861B	519	6925	3149	3174				
1-1/4	32	--	--	--	--	5131B	520	6926	3150	3175	C20	6502	G020	OGC20BL
1-5/16	33	--	--	--	--	5862B	521		3151	3176				
1-3/8	35	--	--	1	25	5132B	522	6927	3152	3177	C22		G022	
1-7/16	37	--	--	--	--	5863B	523		3153	3178				
1-1/2	38	1-1/4	32	--	--	5198B	524	6928	3154	3179	C24	6503	G024	OGC24BL
1-9/16	40	--	--	--	--	5864B	525		3155	3180				
1-5/8	41	--	--	--	--	5133B	526		3156	3181	C26			
1-11/16	43	--	--	--	--	5865B	527		3157	3182				
1-3/4	44	1-1/2	38	1-1/4	32	5134B	528		3158	3183	C28	6504	G028	OGC28BL
--	45	--	--	--	--	M5134B	M528							
1-13/16	46	--	--	--	--	5866B	529		3159	3184				
1-7/8	48	--	--	--	--	5135B	530		3160	3185			G030	
--	49	--	--	--	--				3161	3186				
--	50	--	--	--	--	M5136B	M532							
2	51	--	--	1-1/2	38	5136B	532		3162	3187	C32	6506	G032	OGC32BL
2-1/16	52	--	--	--	--	5867B	533			3188				
2-1/8	54	--	--	--	--	5199B	534			3189	C34	6507	G034	OGC34BL
--	55	--	--	--	--	M5199B	M534							
--	56	--	--	--	--					3190				
2-1/4	57	2	51	--	--	5137B	536			3191	C36	6508	G036	OGC36BL
2-5/16	59	--	--	--	--	5868B	537			3192				
2-3/8	60	--	--	--	--	5139B	538			3193	C38		G038	
2-7/16	62	--	--	--	--					3194				
2-1/2	64	--	--	2	51	5138B	540			3195	C40	6509	G040	OGC40BL
2-9/16	65	--	--	--	--	5869B	541			3196	C41			
2-5/8	67	2-1/2	64	--	--	5870B	542			3197	C42			
--	68	--	--	--	--	M5149B	M542			3198				
2-3/4	70	--	--	--	--	5871B	544			3199			G044	
2-7/8	73	--	--	--	--	5872B	546			3201				
--	75	--	--	--	--	M5150B	M548							
3	76	--	--	2-1/2	64	5150B	548			3203	C48		G048	
3-1/8	79	--	--	--	--	5873B	550							
3-1/4	83	3	76	--	--	5874B	552				C52		G052	
3-3/8	86	--	--	--	--	5875B	554				C54		G054	
3-1/2	89	--	--	--	--	5151B	556				C56			
3-5/8	92	--	--	3	76	5876B	558				C58			
3-3/4	95	3-1/2	89	--	--	5877B	560				C60		G060	
3-7/8	98	--	--	--	--	5878B	562							
--	100	--	--	--	--	M5152B	M564							
4	102	--	--	--	--	5152B	564				C64		G064	
4-1/8	105	--	--	3-1/2	89	5879B	566				C66			
4-1/4	108	4	102	--	--	5880B	568				C68			
4-3/8	111	--	--	--	--	5881B	570							
4-1/2	114	--	--	--	--	5153B	572				C72		G072	
4-3/4	121	4-1/2	114	4	102	5882B	576				C76			
5	127	--	--	--	--	5154B	580				C80			
5-1/2	140	--	--	5	127	5155B	588				C88			
5-3/4	146	--	--	--	--	5883B	592							
6	152	--	--	--	--	5156B	596				C96			

Recommended Operating Speeds for Hole Saws and Cutters.

These guidelines are provided by Disston Company as information on the generally recommended operating speeds for hole saws and cutters. Disston Company recommends that users always follow the specific recommendations of the hole saw manufacturer concerning hole saw and cutter use and operating speeds.

Recommended Bi-Metal Hole Saw Operating Speeds (RPM Table)

inches	mm	Length (Ft)	Mild Steel	Tool Steel & Stainless	Cast Iron	Brass	Aluminum	Wood
9/16	14	0.147	580	300	400	790	900	3000
5/8	16	0.164	550	275	365	730	825	3000
11/16	17	0.180	500	250	330	665	750	3000
3/4	19	0.196	460	230	300	600	690	3000
–	20	0.213	440	220	290	580	660	3000
7/8	22	0.229	390	195	260	520	585	3000
1	25	0.262	350	175	235	470	525	2700
1 1/16	27	0.278	325	160	215	435	480	2700
1 1/8	29	0.295	300	150	200	400	450	2700
1 3/16	30	0.311	285	145	190	380	425	2400
1 1/4	32	0.327	275	140	180	360	410	2400
1 5/16	33	0.344	260	135	175	345	390	2400
1 3/8	35	0.360	250	125	165	330	375	2400
1 7/16	37	0.376	240	120	160	315	360	2400
1 1/2	38	0.393	230	115	150	300	345	2400
1 9/16	40	0.409	220	110	145	290	330	2100
1 5/8	41	0.425	210	105	140	280	315	2100
1 11/16	43	0.442	205	100	135	270	305	2100
1 3/4	44	0.458	195	95	130	260	295	2100
1 13/16	46	0.475	190	95	125	250	285	2100
1 7/8	48	0.491	180	90	120	240	270	2100
2	51	0.524	170	85	115	230	255	2000
2 1/16	52	0.540	165	80	110	220	245	2000
2 1/8	54	0.556	160	80	105	210	240	2000
2 1/4	57	0.589	150	75	100	200	225	2000
2 5/16	59	0.605	145	75	95	195	225	2000
2 3/8	60	0.622	140	70	90	190	220	2000
2 1/2	64	0.655	135	65	85	180	205	1850
2 9/16	65	0.671	130	65	85	175	200	1850
2 5/8	67	0.687	130	65	85	170	195	1800
–	68	0.704	130	65	80	170	190	1800
2 3/4	70	0.720	125	60	80	160	185	1800
2 7/8	73	0.753	120	60	75	160	180	1800
3	76	0.785	115	55	70	150	170	1800
3 1/8	79	0.818	110	55	70	140	165	1500
3 1/4	83	0.851	105	50	65	140	155	1500
3 3/8	86	0.884	100	50	65	130	150	1500
3 1/2	89	0.916	95	45	60	130	145	1200
3 5/8	92	0.949	90	45	60	120	140	1200
3 3/4	95	0.982	90	45	60	120	135	1200
3 7/8	98	1.014	90	45	60	120	135	1200
4	102	1.047	85	40	55	110	130	1000
4 1/8	104	1.080	80	40	55	110	120	1000
4 1/4	108	1.113	80	40	55	110	120	900
4 3/8	111	1.145	80	40	50	100	120	900
4 1/2	114	1.178	75	35	50	100	105	900
4 3/4	121	1.244	75	35	50	92	95	900
5	127	1.309	65	30	45	90	90	800
5 1/2	140	1.440	60	25	40	85	85	800
5 3/4	146	1.505	55	25	35	75	75	800
6	152	1.571	55	25	35	75	75	800

Lead times may vary. Please contact your Sales Representative for more information.

Blu-Mol® TCT Cutter Operating Speeds (RPM Table)

DIAMETER		MATERIAL	
inches	mm	Steel	Stainless Steel
11/16 to 13/16	18mm to 21mm	700-1000	300-700
7/8 to 1-3/16	22mm to 30mm	500-800	200-450
1-1/4 to 1-9/16	31mm to 40mm	300-600	175-315
1-5/8 to 2	41mm to 50mm	200-500	120-225
2-1/16 to 2-3/8	51mm to 60mm	200-400	95-195
2-7/16 to 3	61mm to 76mm	150-300	80-150

RemGrit® Hole Saw Operating Speeds (RPM Table)

inches	mm	Brick Ceramic	Slate	Reinforced Plastics	Fiberglass
5/8	16	620	1540	2140	920
3/4	19	510	1280	1790	770
–	20	470	1180	1660	715
7/8	22	430	1090	1530	660
1	25	380	960	1340	580
1 1/8	29	340	850	1190	510
1 1/4	32	310	770	1070	460
1 3/8	35	280	700	980	420
1 1/2	38	260	640	890	390
1 3/4	44	220	550	770	330
1 7/8	48	200	510	720	310
2	51	190	480	670	290
2 1/8	54	180	450	630	280
2 1/4	57	170	430	600	270
2 3/8	60	160	400	570	250
2 1/2	64	150	380	540	230
2 3/4	70	140	350	500	210
3	76	130	320	450	190
3 1/4	83	120	295	415	180
3 3/8	86	115	285	400	175
3 3/4	95	102	255	350	160
4	102	95	240	330	150
4 1/2	114	82	215	290	125

Metal Cutting Safety (read this before using products)

Modern metal cutting operations involve high energy, high spindle or cutter speeds, and high temperatures and cutting forces. Hot, flying chips may be projected from the workpiece during metal cutting. Although advanced cutting tool materials are designed and manufactured to withstand the high cutting forces and temperatures that normally occur in these operations, they are susceptible to fragmenting in service, particularly if they are subjected to over-stress, severe impact or otherwise abused. Therefore, precautions should be taken to adequately protect workers, observers and equipment against hot, flying chips, fragmented cutting tools, broken workpieces or other similar projectiles. Machines should be fully guarded and personal protective equipment should be used at all times.

Disston has no control over the end use of its products or the environment into which those products are placed. Disston urges that its customers adhere to the recommended standards of use of their metal cutting operations. The information included throughout this catalog under the heading "Technical Data" and other recommendations on machining practices referred to herein are only advisory in nature and do not constitute representations or warranties and are not necessarily appropriate for any particular work environment or application.

RECIPROCATING SAW BLADES

Disston's superior collection of reciprocating saw blades make quick work of anything you can throw at it. Reciprocating saw blades are available in individual packages and handy multi-pack tubes.

Types of Reciprocating Saws

Blu-Mol® Xtreme Demolition Bi-Metal

Incredibly tough demolition reciprocating saw blades. These tough blades are made wider and thicker than normal reciprocating saw blades for heavy-duty applications such as demolition and rescue projects.

Blu-Mol® Bi-Metal

These Bi-Metal reciprocating saw blades are designed for efficient cutting in a wide variety of materials including wood, metal and plastic. These blades make quick and accurate cuts for general purpose projects.

RemGrit® Carbide Grit

Carbide particles bonded to a steel blade. This blade cuts extremely abrasive materials. Carbide grit offers the greatest wear and heat resistance. Ideal for materials that other blades will not cut.

Blu-Mol® Xtreme Pallet Bi-Metal

These Bi-Metal reciprocating saw blades are designed for high performance during pallet dismantling. Blades feature a special backer for greater flexibility when cutting block pallets.

Tech Tips for Reciprocating Saw Blades

- First decide on the length of saw blade you need for your application. We recommend that the blade be about 2" (50mm) more than the thickness or width of the material to be cut, to take into account the blade travel.
- Then refer to the cutting guide for the cross section you plan to cut and select the tooth pitch.
- Always wear eye protection.

DEMOLITION RECIPROCATING SAW BLADES

Make your mark with these demolition reciprocating saw blades. Xtreme® saw blades are wider and thicker and have been engineered for heavy-duty applications. Designed for tough, heavy duty cutting jobs and are built to last.

6 TPI Wood

- For cutting nail embedded wood, railroad ties and other tough materials.
- Wider (7/8") and thicker (.062) blades for demolition work.
- Available in 6", 9" and 12" lengths with 1/2" universal shanks.

Wood Cutting

SIZE			BULK (20/PK)		10/TUBE	
LENGTH		TEETH PER INCH	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
INCHES	MM					
6 x 7/8 x .062	150 x 22 x 1,60	6	6486	E0101329	6486-10T	E0102829
9 x 7/8 x .062	225 x 22 x 1,60	6	6487	E0101330	6487-10T	E0102831
12 x 7/8 x .062	305 x 22 x 1,60	6	6488	E0101331	6488-10T	E0102833

14 TPI Metal

- For cutting pipe, angle iron, nail embedded wood and structural steel.
- Wider (1") and thicker (.042) blades for demolition work.
- Available in 6", 9" and 12" lengths with 1/2" universal shanks.

Metal Cutting

SIZE			BULK (20/PK)		10/TUBE	
LENGTH		TEETH PER INCH	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
INCHES	MM					
6 x 1 x .042	150 x 22 x 1,60	14	6489	E0101332	6489-10T	E0102830
9 x 1 x .042	225 x 22 x 1,60	14	6490	E0101333	6490-10T	E0102832
12 x 1 x .042	305 x 22 x 1,60	14	6491	E0101334	6491-10T	E0102834

Model # E0320095

Display Only
Model # E2120728

Model # E0320099

Display Only
Model # E0320099E

NEW!

NEW!

Demolition Saw Blade Assortment

DEMOLITION RECIP BLADE ASSORTMENT SET INCLUDES	PRODUCT CODE
Demolition Recip Blade Assortment Contains: 20 each of 6"x 6T, 9"x 6T, & 12"x 6T, Wood Cutting blades, 20 each of 6"x 14T, 9"x 14T, & 12"x 14T Metal Cutting blades, Rack & Header	E0320095
Demolition Recip Blade Assortment Contains: 5 each of 6"x 6T, 9"x 6T, & 12"x 6T, Wood Cutting blades, 5 each of 6"x 14T, 9"x 14T, & 12"x 14T Metal Cutting blades, Rack & Header	E0320096
Reciprocating Saw Blade Display Contains: 10/tube of 6" X 6T & 9" X 6T Xtreme Wood Cutting, 10/tube of 6" X 14T & 9" X 14T Xtreme Metal Cutting, 5/tube of 6" X 6T, 9" X 6T, & 6" X 10T Standard Wood Cutting, 5/tube of 6" X 14T, 6" X 18T, & 6" X 24T Standard Metal Cutting, 5/tube of 8" X 10/14T & 12" X 10/14T Standard All-Purpose Cutting, Rack & Header	E0320099
Reciprocating Saw Blade Display Contains: 10/tube of 6" X 6T & 9" X 6T Xtreme Wood Cutting, 10/tube of 6" X 14T & 9" X 14T Xtreme Metal Cutting, 10/tube of 6" X 6T, 9" X 6T, & 6" X 10T Standard Wood Cutting, 10/tube of 6" X 14T, 6" X 18T, & 6" X 24T Standard Metal Cutting, 10/tube of 8" X 10/14T & 12" X 10/14T Standard All-Purpose Cutting, Rack & Header	E0320100

PALLET RECIPROCATING SAW BLADES

- High performance cutting for pallet dismantling
- M42 cutting edge with 8% cobalt for longer life
- Special heat treat for increased tooth life
- Unique tooth design for fast cutting
- Rounded nose for easy cutting and safer operation
- Special blade backer for greater flexibility when cutting block pallets

NEW!

Pallet Saw Blade

SIZE			BULK (250/PK)	
LENGTH		TEETH PER INCH	MODEL#	PRODUCT CODE
INCHES	MM			
8 x 3/4 x .035	203 x 19 X .9 25	10	6988	E0102533

RECIPROCATING SAW BLADES

BLU-MOL® BI-METAL RECIPROCATING SAW BLADES

Reciprocating saw blades are designed for efficient cutting in a wide variety of materials including wood, metal and plastic. All have the 1/2" universal shank that fits all standard 1/2" shank reciprocating saws. Made for quick and accurate cutting.

Wood Cutting

SIZE			1/CARD		5/TUBE		10/TUBE		BULK (50/PK)	
LENGTH		TEETH PER INCH	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
INCHES	MM									
6 x 3/4 x .050	150 x 20 x 1,30	5/7	--	--	6481-5T	E0104525	6481	E0114450	6481-50	E0102258
6 x 3/4 x .050	150 x 20 x 1,30	6	6446	E0102237	6480-5T	E0102813	6480	E0114449	6480-50	E0102814
6 x 3/4 x .050	150 x 20 x 1,30	10	--	--	6478-5T	E0102817	6478	E0114447	6478-50	E0102818
9 x 3/4 x .050	225 x 20 x 1,30	6	6447	E0102238	6482-5T	E0104526	6482	E0114451	6482-50	E0102252
12 x 3/4 x .050	300 x 20 x 1,30	6	6448	E0102239	6483-5T	E0104527	6483	E0114452	6483-50	E0102253

Metal Cutting

SIZE			1/CARD		5/TUBE		10/TUBE		BULK (50/PK)	
LENGTH		TEETH PER INCH	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
INCHES	MM									
3 x 5/16 x .035 scroll	90 x 8 x 0,90	14	--	--	6955-5T	E0102812	6955	E0102248	6955-50	E0102254
6 x 3/4 x .035	150 x 20 x 0,90	14	--	--	6475-5T	E0102819	6475	E0114444	6475-50	E0102820
6 x 3/4 x .035	150 x 20 x 0,90	18	6445	E0102236	6476-5T	E0102821	6476	E0114445	6476-50	E0102822
6 x 3/4 x .035	150 x 20 x 0,90	24	--	--	6477-5T	E0102823	6477	E0114446	6477-50	E0102824
8 x 3/4 x .035	200 x 20 x 0,90	18	--	--	6961-5T	E0102240	6961	E0102241	6961-50	E0100033
9 x 3/4 x .035	225 x 20 x 0,90	14	--	--	6958-5T	E0104528	6958	E0102827	6958-50	E0102255
12 x 3/4 x .035	300 x 20 x 0,90	18	--	--	6474-5T	E0104966	6474	E0104967	6474-50	E0104968

NEW!

All-Purpose Cutting

SIZE			5/TUBE		10/TUBE		BULK (50/PK)	
LENGTH		TEETH PER INCH	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
INCHES	MM							
8 x 3/4 x .035	200 x 20 x 0,90	10/14	6479-5T	E0102825	6479	E0114448	6479-50	E0102826
12 x 3/4 x .050	300 x 20 x 1,30	10/14	6959-5T	E0104529	6959	E0102828	6959-50	E0102256
NEW! 12 x 3/4 x .050 taper	300 x 20 x 1,30	10/14	6960-5T	E0103198	6960	E0103199	6960-50	E0100034

Plaster Cutting

SIZE			5/TUBE		10/TUBE		BULK (50/PK)	
LENGTH		TEETH PER INCH	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
INCHES	MM							
6 x 3/4 x .050	150 x 20 x 0,90	6	6956-5T	E0102815	6956	E0102249	6956-50	E0102257

RemGrit® CARBIDE GRIT RECIPROCATING SAW BLADES

Cuts extremely hard abrasive materials. The cutting edge of tungsten carbide particles is permanently bonded to an alloy steel back. These blades have high heat and abrasion resistance. There are no teeth to dull or chip and the blades cut on both strikes. Resists snagging and are always smooth cutters.

RemGrit® Reciprocating Saw Blades

SIZE			1/CARD		10/TUBE		BULK (50/PK)	
LENGTH		GRIT	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
INCHES	MM							
6 x 3/4 x .032	150 x 20 x 0,90	Coarse	GR24BL	E0406122	GR24-10T	E0102835	GR24-50	E0206112
8 x 3/4 x .042	200 x 20 x 0,90	Coarse	GR26BL	E0406123	GR26-10T	E0102251	GR26-50	E0206113

BLU-MOL® AIR SAW BLADES

Specially designed blades for use in pneumatic saws. Air Saw blades have fine teeth for cutting metal.

Air Saw Blades

SIZE			5/TUBE	
LENGTH		TEETH PER INCH	MODEL#	PRODUCT CODE
INCHES	MM			
3 x 1/2 x .025	75 x 12.5 x 0,64	18	6982	E0103178
3 x 1/2 x .025	75 x 12.5 x 0,64	24	6983	E0103179
3 x 1/2 x .025	75 x 12.5 x 0,64	32	6984	E0103180
4 x 1/2 x .025	100 x 12.5 x 0,64	18	6985	E0103181
4 x 1/2 x .025	100 x 12.5 x 0,64	32	6986	E0103182
5 x 1/2 x .025	125 x 12.5 x 0,64	18	6987	E0103183

Air Saw Blade Set

AIR BLADE SET INCLUDES	MODEL#	PRODUCT CODE
4Pc Air Saw Blade Set - Includes 1 each of 3" 24T, 3" 32T, 4" 18T & 4" 32T	6472	E0101319

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Blu-Mol jig saw blades are available in bi-metal, carbon, and grit-edge for cutting in a wide variety of materials. They also have various shank styles for use in most popular saws.

Types of Jig Saw Blades

Bi-Metal

Bi-metal jig saw blades are made with cobalt for heavy duty cutting in wood and metal. These bi-metal jig saw blades are very durable and long lasting.

Carbon / High Speed Steel

High carbon steel jig saw blades are designed for general purpose cutting in wood. Made for quick and accurate cutting. High Speed Steel for cutting in metal.

Carbide Grit

Carbide particles bonded to a steel blade. This saw cuts extremely abrasive materials with no teeth to chip or dull. Carbide grit offers the greatest wear and heat resistance. Ideal for materials that other blades will not cut.

Tech Tips for Jig Saw Blades

- Always wear eye protection.
- Thicker materials will require a blade with fewer teeth per inch and thinner materials are better cut with a blade having more teeth per inch.
- Determine the size of the blade needed by exceeding the thickness or width of the material to be cut by 1". This accounts for the distance the blade will be traveling up and down while cutting and makes certain that there are as many teeth as possible in the material while cutting.

JIG SAW BLADES

BLU-MOL® BI-METAL JIG SAW BLADES

Bi-metal jig saw blades are for cutting metals, steel and stainless steel. Their high strength steel cutting edges are hardened and offer the flexibility required for durable, longer lasting blades. Made for heavy duty cutting in wood and metal.

Blu-Mol® Bi-Metal Jig Saw Blades - Universal Shank

SIZE			APPLICATION		2/CARD		25/TUBE	
TEETH PER INCH	LENGTH INCHES	LENGTH MM	TYPE OF CUT	MATERIAL	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
6	3-1/2	89	Rough	Wood & Metal	6420	E0114415	6420-25T	E0102839
10/14	3-1/2	89	All Purpose	Wood & Metal	6421	E0114416	--	--
12	3-1/2	89	All Purpose	Wood & Metal	6422	E0114417	6422-25T	E0102840
14	3	76	Rough	Metal	6425	E0101950	--	--
18	3	76	All Purpose	Metal	6423	E0114418	--	--
24	3	76	Smooth	Metal	6424	E0114419	--	--
32	3	76	Smooth	Metal	6970	E0102843	6970-25T	E0102844

Blu-Mol® Bi-Metal Jig Saw Blades - T-Shank

SIZE			APPLICATION		2/CARD		25/TUBE	
TEETH PER INCH	LENGTH INCHES	LENGTH MM	TYPE OF CUT	MATERIAL	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
6	3-1/2	89	Rough	Wood & Metal	6977	E0102850	--	--
14	3	76	Rough	Metal	6978	E0102851	6978-25T	E0102852
24	3	76	Smooth	Metal	6980	E0102853	--	--

Blu-Mol® Bi-Metal Jig Saw Blades - Bayonet Shank

SIZE			APPLICATION		2/CARD		25/TUBE	
TEETH PER INCH	LENGTH INCHES	LENGTH MM	TYPE OF CUT	MATERIAL	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
14	3	76	Rough	Metal	6973	E0102846	6973-25T	E0102847
24	3	76	Smooth	Metal	6975	E0102848	--	--

BLU-MOL® CARBON JIG SAW BLADES

Carbon jig saw blades are used for cutting wood. These carbon jig saw blades provide a very clean and fast cut for most for general purpose cutting. High Speed Steel for cutting in metal.

Blu-Mol® Carbon Jig Saw Blades - Universal Shank

SIZE			APPLICATION		2/CARD	
TEETH PER INCH	LENGTH INCHES	LENGTH MM	TYPE OF CUT	MATERIAL	MODEL#	PRODUCT CODE
6	3-1/8	79	Rough	Wood	6412	E0114410
6	3-1/2	89	Rough	Wood	6401	E0114400
6	4 - Flush	102	Flush	Wood	6403	E0114402
6	6	152	Rough	Wood	6434	E0102319
8	2-3/4 - Flush	70	Flush	Wood	6453	E0102227
8	3-5/8	92	All Purpose	Plaster	6419	E0102228
8	4-1/8	105	Rough	Wood	6428	E0102229
10	2-3/4	70	All Purpose	Wood	6417	E0102232
10	2-3/4 - Scroll	70	Rough	Wood	6441	E0102225
10	3-1/8	79	Smooth	Formica	6408	E0114406
10	3-1/8	79	Smooth	Wood	6418	E0102233
10	3-1/8 - Scroll	79	Smooth	Wood	6411	E0114409
10	3-1/2	89	All Purpose	Wood	6407	E0114405
12*	2-3/4	70	All Purpose	Metal	6413	E0114411
12	3-1/8 - Reverse Tooth	79	Smooth	Wood	6465	E0102321
14	2-3/4 - Scroll	70	Smooth	Wood	6406	E0114404
19	2-3/4 - Scroll	70	Smooth	Wood	6444	E0102226
21*	2-3/4	70	Smooth	Metal	6415	E0114413
24*	3-1/8	79	Smooth	Metal	6454	E0102318
36*	2-3/4	70	Smooth	Metal	6416	E0114414

** Color denotes HSS material*

Blu-Mol® Carbon Jig Saw Blades - T-Shank

SIZE			APPLICATION		2/CARD	
TEETH PER INCH	LENGTH INCHES	LENGTH MM	TYPE OF CUT	MATERIAL	MODEL#	PRODUCT CODE
6	3-1/2	89	Rough	Wood	6963	E0102836
10	3-1/2	89	All Purpose	Wood	6964	E0102837
14	2-3/4 - scroll	70	Smooth	Wood	6965	E0102838

RemGrit® CARBIDE GRIT JIG SAW BLADES

Carbide grit jig saw blades cut extremely hard abrasive materials. Cutting edge of tungsten carbide particles bonded to alloy steel back. High heat and abrasion resistance; no teeth to dull or chip; resists snagging; smooth cutting; greater wear resistance.

RemGrit® Carbide Grit Jig Saw Blades - Universal Shank

SIZE			APPLICATION		1/CARD			BULK (50/PK)	
GRIT	LENGTH INCHES	LENGTH MM	TYPE OF CUT	MATERIAL	MODEL#	MIN ORDER QTY.	PRODUCT CODE	MODEL#	PRODUCT CODE
Coarse	2-7/8	73	Rough	Tile, Slate,Fiberglass	GJ6BL	5	E0406142	GJ6-50	E0206132
Medium	2-7/8	73	All Purpose	Tile, Slate,Fiberglass	GJ4BL	5	E0406141	GJ4-50	E0206131
Fine	2-7/8	73	Smooth	Tile, Slate,Fiberglass	GJ2BL	5	E0406140	--	--
Coarse	2-7/8 - scroll	73	Rough	Tile, Slate,Fiberglass	GJ10BL	5	E0406144	--	--
Fine	2-7/8 - scroll	73	Smooth	Tile, Slate,Fiberglass	GJ8BL	5	E0406143	--	--
Medium	4 - Flush	102	Rough	Tile, Slate,Fiberglass	GJ18BL	5	E0406146	--	--

RemGrit® Carbide Grit Jig Saw Blades - T-Shank

SIZE			APPLICATION		1/CARD			BULK (50/PK)	
GRIT	LENGTH INCHES	LENGTH MM	TYPE OF CUT	MATERIAL	MODEL#	MIN ORDER QTY.	PRODUCT CODE	MODEL#	PRODUCT CODE
Medium	3	76	All Purpose	Tile, Slate,Fiberglass	GJ12BL	5	E0406148	GJ12-50	E0206138
Coarse	3	76	Rough	Tile, Slate,Fiberglass	GJ14BL	5	E0406147	GJ14-50	E0206137

E0320062
* Available in three styles.
Reference pages 10, 17, 20, 21 & 22
for full description of each product.

RemGrit® Assortments

DESCRIPTION	PRODUCT CODE	ASST. 1 E0320062	ASST. 2 E0320063	ASST. 3 E0320065
7" Circular Saw Blade	E0206235	1	--	--
1-1/4" Arbored Hole Saw	E0104578	2	4	2
1-1/2" Arbored Hole Saw	E0104579	2	4	2
2" Arbored Hole Saw	E0104581	2	4	2
2-1/2" Arbored Hole Saw	E0104584	2	4	2
2-7/8" Jig Saw Blade Universal Shank	E0406141	5	5	2
2-7/8" Scroll Jig Saw Blade Universal Shank	E0406144	5	5	2
3" Jig Saw Blade T-Shank	E0406147	5	5	2
6" Reciprocating Saw Blade	E0406122	5	--	--
8" Reciprocating Saw Blade	E0406123	5	--	--
12" Hacksaw Blade	E0406160	10	--	--
12" Rodsaw Blade	E0406180	10	--	--

BLU-MOL® JIG SAW BLADE SETS

Blu-Mol Jig Saw blade assorted sets give you the right blades for any project you might have. Each set has been expertly matched to cut traditional wood, plastic or metal materials, from thin to thick, rough to smooth cut. Available in seven different set assortments.

Blu-Mol® Bi-Metal Jig Saw Sets

SET INCLUDES	TYPE OF CUT	MATERIAL	MODEL#	PRODUCT CODE
3Pc Bi-Metal Blades: (1) 3" x 14T, (1) 3" x 18T, (1) 3" x 24T	All Purpose	Metal	6426	E0102234
5Pc Carbon Blades: (1) 3-1/2" 6T, (2) 3-1/2" 10T,(2) 2-3/4" 14T scroll	All Purpose	Wood	6440	E0101729
5Pc Bi-Metal Blades: (2) 3" 14T, (2) 3" 18T, (1) 3" 24T	All Purpose	Metal	6443	E0101958
7Pc Bi-Metal Blades: (2) 3-1/2" x 6T, (2) 3-1/2" x 10/14T, (1) 3" x 14T, (1) 3" x 18T, (1) 3" x 24T	All Purpose	Wood & Metal	6427	E0102235
10Pc Carbon Blades: (2) 3-1/2" x 6T, (2) 3-1/2" x 10T, (1) 3-1/8" x 10T, 2-3/4" x 10T, (1) 2-3/4" x 14T scroll HSS Blades: (1) 2-3/4" x 12T, (1) 2-3/4" x 18T, (1) 2-3/4" x 21T	All Purpose	Wood & Metal	6433	E0102231
12Pc Carbon Blades: (2) 3-1/2" 6T, (2) 3-1/2" 10T,(2) 2-3/4" 14T scroll, Bi-Metal Blades: (1) 3-1/2" 10/14T,(2) 3" 14T, (2) 3" 18T, (1) 3" 24T	All-Purpose	Wood & Metal	6442	E0101730
25Pc Carbon Blades (5) 3-1/2" 6T, (5) 3-1/2" 10T, (5) 2-3/4" 14T-scroll, Bi-metal Blades: (5) 3-1/2" 10/14T, (5) 3" 18T	All Purpose	Wood & Metal	6437	E0114425

BLU-MOL® BI-METAL HACKSAW BLADES

Bi-metal hacksaw blades for heavy duty cutting. Cut medium gauge metals (1/16" to 1/4") such as sheet metal, angle iron, bolts, channels, drill rods, threaded rod, pipes and tubing. Blade is shatter resistant.

SIZE			2/CARD		10/TUBE		100/TUBE	
LENGTH X WIDTH X THICKNESS								
INCHES	MM	TPI	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
10 x 1/2 x .025	250 x 12,5 x 0,64	18	1018UL-2	E0102857	1018UL-10	E0102858	--	--
10 x 1/2 x .025	250 x 12,5 x 0,64	24	1024UL-2	E0102859	1024UL-10	E0102860	--	--
10 x 1/2 x .025	250 x 12,5 x 0,64	32	1032UL-2	E0102861	1032UL-10	E0102862	--	--
12 x 1/2 x .025	300 x 12,5 x 0,64	14	1214UL-2	E0102863	1214UL-10	E0102864	--	--
12 x 1/2 x .025	300 x 12,5 x 0,64	18	1218UL-2	E0102865	1218UL-10	E0102866	1218UL	E0102867
12 x 1/2 x .025	300 x 12,5 x 0,64	24	1224UL-2	E0102868	1224UL-10	E0102869	1224UL	E0102870
12 x 1/2 x .025	300 x 12,5 x 0,64	32	1232UL-2	E0102871	1232UL-10	E0102872	1232UL	E0102873
12 x 1/2 x .025	300 x 12,5 x 0,64	10/14	1212VT-2	E0102874	1212VT-10	E0102875	--	--
12 x 1/2 x .025	300 x 12,5 x 0,64	14/18	1216VT-2	E0102876	1216VT-10	E0102877	--	--
12 x 1/2 x .025	300 x 12,5 x 0,64	18/24	1220VT-2	E0102878	1220VT-10	E0102879	1220VT	E0102880
12 x 1/2 x .025	300 x 12,5 x 0,64	24/32	1228VT-2	E0102881	1228VT-10	E0102882	--	--

RemGrit® CARBIDE GRIT HACKSAW BLADES

Carbide particles bonded to a steel blade. This saw cuts extremely abrasive materials with no teeth to chip or dull. Carbide grit offers the greatest wear and heat resistance. Cuts on both strokes.

SIZE			1/CARD		50/TUBE	
LENGTH X WIDTH X THICKNESS						
INCHES	MM	GRIT	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
10 x 3/4 x .025	250 x 19 x 0,64	MEDIUM	GH10	E0406161	GH10-50T	E0206151
12 x 3/4 x .025	300 x 19 x 0,64	MEDIUM	GH12	E0406160	GH12-50T	E0206150

E0320062
* Available in three styles.
Reference pages 10, 17, 20, 21 & 22 for full description of each product.

RemGrit® Assortments

DESCRIPTION	PRODUCT CODE	ASST. 1 E0320062	ASST. 2 E0320063	ASST. 3 E0320065
7" Circular Saw Blade	E0206235	1	--	--
1-1/4" Arbored Hole Saw	E0104578	2	4	2
1-1/2" Arbored Hole Saw	E0104579	2	4	2
2" Arbored Hole Saw	E0104581	2	4	2
2-1/2" Arbored Hole Saw	E0104584	2	4	2
2-7/8" Jig Saw Blade Universal Shank	E0406141	5	5	2
2-7/8" Scroll Jig Saw Blade Universal Shank	E0406144	5	5	2
3" Jig Saw Blade T-Shank	E0406147	5	5	2
6" Reciprocating Saw Blade	E0406122	5	--	--
8" Reciprocating Saw Blade	E0406123	5	--	--
12" Hacksaw Blade	E0406160	10	--	--
12" Rodsaw Blade	E0406180	10	--	--

RemGrit® CARBIDE GRIT ROD SAW BLADES

Carbide particles bonded to an alloy steel rod. This saw cuts extremely abrasive materials with no teeth to chip or dull. Carbide grit offers the greatest wear and heat resistance. Ideal for materials that other saws will not cut. Rod design gets into tight areas and cuts on both strokes. Fits any standard hack frame.

SIZE LENGTH X DIAMETER			1/CARD		50/BULK	
INCHES	MM	GRIT	MODEL#	PRODUCT CODE	MODEL#	PRODUCT CODE
10 x .100	250 x 2,5	FINE GRIT	GG10	E0406181	GG10-50T	E0106174
12 x .100	300 x 2,5	MEDIUM	GG12	E0406180	GG12-50T	E0106175

RemGrit® CARBIDE GRIT CIRCULAR SAWS

Cuts extremely hard abrasive materials. Cutting edge of tungsten carbide particles bonded to alloy steel back. High heat and abrasion resistance; no teeth to dull or chip; resists snagging; smooth cutting; greater wear resistance.

SIZE DIAMETER			1/CARD			
INCHES	MM	GRIT	ARBOR SIZE	MODEL#	PRODUCT CODE	MAX RPM
1-3/4	44	FINE	1/4"	GC101	E0206220	26,200
1-3/4	44	MEDIUM	1/4"	GC103	E0206221	26,200
1-3/4	44	COARSE	1/4"	GC107	E0206223	26,200
2	51	MEDIUM	1/4"	GC200	E0206224	23,600
2-1/2	64	COARSE	7/16"	GC250	E0206226	18,400
3	76	COARSE	1/2"	GC302	E0206227	15,200
3	76	COARSE	3/8"	GC304	E0206228	15,200
4	102	COARSE	20mm	GC406	E0206229	11,500
4	102	COARSE	3/4"	GC404	E0206231	11,500
4	102	COARSE	5/8"	GC408	E0206232	11,500
6-1/2	165	COARSE	1/2"-5/8"	GC652	E0206234	7,000
7	178	MEDIUM	1/2"-5/8"	GC700	E0206235	6,500
7	178	COARSE	1/2"-5/8"	GC703	E0206236	6,500
8	203	MEDIUM	1/2"-5/8"	GC803	E0206237	5,700
10	254	COARSE	5/8"	GC507	E0206240	4,600
12	305	COARSE	3/4"-1" Rnd	GC915	E0206242	3,800

E0320062
* Available in three styles.
Reference pages 10, 17, 20, 21 & 22 for full description of each product.

RemGrit® Assortments

DESCRIPTION	PRODUCT CODE	ASST. 1 E0320062	ASST. 2 E0320063	ASST. 3 E0320065
7" Circular Saw Blade	E0206235	1	--	--
1-1/4" Arbored Hole Saw	E0104578	2	4	2
1-1/2" Arbored Hole Saw	E0104579	2	4	2
2" Arbored Hole Saw	E0104581	2	4	2
2-1/2" Arbored Hole Saw	E0104584	2	4	2
2-7/8" Jig Saw Blade Universal Shank	E0406141	5	5	2
2-7/8" Scroll Jig Saw Blade Universal Shank	E0406144	5	5	2
3" Jig Saw Blade T-Shank	E0406147	5	5	2
6" Reciprocating Saw Blade	E0406122	5	--	--
8" Reciprocating Saw Blade	E0406123	5	--	--
12" Hacksaw Blade	E0406160	10	--	--
12" Rodsaw Blade	E0406180	10	--	--

Aggressor® PORTABLE BANDSAWS

- Bi-Metal Portable Bandsaw Blades
- All teeth have uniform spacing and gulleted depth
- Improve cut quality and offer improved shock resistance
- Blades resist tooth strippage
- Cuts aluminum, cast iron, chrome, stainless steel, tungsten steel and other problem materials at low speed

Portable Bandsaw Blades (Matrix II)

LENGTH X WIDTH X THICKNESS			VARIABLE PITCH						CONSTANT PITCH							
			Model Number	Product Code	Model Number	Product Code	Model Number	Product Code	Model Number	Product Code	Model Number	Product Code	Model Number	Product Code	Model Number	Product Code
INCH	(MM)	QUANTITY PER BOX	10/14		14/18		18/24		10 Raker		14 Raker		18 Raker		24 Raker	
44-7/8 x 1/2 x .020	(1140mm x 12.5mm x .50mm)	3	AG4412	E0102953	AG4416	E0102954	AG4420	E0102955	B4410	E0102956	B4414	E0102957	B4418	E0102958	B4424	E0102959
44-7/8 x 1/2 x .020	(1140mm x 12.5mm x .50mm)	100	AG4412-100	E0102960	AG4416-100	E0102961	AG4420-100	E0102962	B4410-100	E0102963	B4414-100	E0102964	B4418-100	E0102965	B4424-100	E0102966

Aggressor® BI-METAL BANDSAW BLADES

Bi-Metal Bandsaw Blades by Aggressor® have high speed steel teeth for a sharper cut and give you a longer lasting blade. HSS edge contains 8% cobalt. Available in coils or custom-welded to length.

Narrow Width Bands M-42

- Solids and thick wall tubing of medium to difficult material, such as stainless steels
- 5° positive rake for easier penetration and reduced vibration
- Narrow width from 1/4" to 1/2" for contour and miter cutting
- Narrow width and gauge can be welded by customer for die building and internal cutting re-use
- HSS Edge contains 8% cobalt

0° Rake

Narrow Bands M-42

WIDTH x GAUGE			VARIABLE PITCH			CONSTANT PITCH						
INCH	(MM)	COIL LENGTH	Model Number 6/10	Model Number 8/12	Model Number 10/14	Model Number 4 Hook	Model Number 6 Positive	Model Number 10 Raker	Model Number 14 Raker	Model Number 18 Wavy	Model Number 24 Raker	Model Number 24 Wavy
1/4 x .035	(6,00 x 0,90)	250 ft.	--	--	--	--	--	A906	A907	--	--	--
3/8 x .035	(10,0 x 0,90)	250 ft.	--	--	A915	A911	--	--	--	--	--	--
1/2 x .020	(12,5 x 0,51)	250 ft.	--	--	A821*	--	--	A822*	A823*	A824*	A826*	A825*
1/2 x .025	(12,5 x 0,64)	250 ft.	A902	A905	A901	--	--	--	A931	A900	--	--
1/2 x .035	(12,5 x 0,90)	250 ft.	--	A919	A936	A937	A908	--	A933	--	--	--

*Color denotes Matrix II material

M-1000 M-42 (Straight Tooth)

- All-purpose band for moderate to difficult to cut materials
- Provides higher heat and wear durability
- 0° for smoother cutting and general applications

M-1000 M-42 (Straight Tooth)

WIDTH x GAUGE			VARIABLE PITCH						CONSTANT PITCH	
INCH	(MM)	COIL LENGTH	Model Number 3/4	Model Number 4/6	Model Number 5/8	Model Number 6/10	Model Number 8/12	Model Number 10/14	Model Number 10 Raker	Model Number 14 Wavy
3/4 x .035	(19,0 x 0,90)	250 ft.	--	--	--	A934	A932	A952	A943	A944
1 x .035	(27,0 x 0,90)	250 ft.	A976	A974	A975	A970	A971	A920	--	A973
1-1/4 x .042	(34,0 x 1,10)	250 ft.	A965	A964	A966*	A967	--	--	--	--
1-1/2 x .050	(41,0 x 1,27)	150 ft.	--	A980	--	--	--	--	--	--

0° Rake

** A966 material is available in 450 ft. master coils.*

M-2000 M-42 (Positive Rake Tooth)

- Solids and thick wall tubing of medium to difficult material, such as stainless steels
- 5° positive rake for easier penetration and reduced vibration

M-2000 M-42 (Positive Tooth)

WIDTH x GAUGE			VARIABLE PITCH						CONSTANT PITCH
INCH	(MM)	COIL LENGTH	Model Number 2/3	Model Number 3/4	Model Number 4/6	Model Number 5/7	Model Number 2 Hook	Model Number 6 Raker	Model Number 8 Raker
3/4 x .035	(19,0 x 0,90)	250 ft.	--	--	A9035	A904	--	--	--
1 x .035	(27,0 x 0,90)	250 ft.	A9275	A9285	A9295	A930	A916	A922	A923
1-1/4 x .042	(34,0 x 1,10)	250 ft.	A9605	A9615	A9625	A963	--	A955*	--
1-1/2 x .050	(41,0 x 1,27)	150 ft.	A9775	A9785	A9795	--	--	--	--

5° Positive Rake

** A955 material is available in 450 ft. master coils.*

- *Ordering by the listed Product Codes, is for coil stock only.*
- *When ordering custom welded lengths use the Model # followed by a "W" and your exact weld length.*

M-3000 M-42 (High Positive Rake Tooth)

- High production band for difficult to cut materials, such as monels, titanium, inconels, and stainless steels, etc.
- Greater beam strength
- Specially engineered relief angle
- 10° high positive rake for faster cutting time

M-3000 M-42 (High Positive Rake Tooth)

WIDTH x GAUGE			VARIABLE PITCH		
INCH	(MM)	COIL LENGTH	Model Number 2/3	Model Number 3/4	Model Number 4/6
3/4 x .035	(19,0 x 0,90)	250 ft.	--	--	A903
1 x .035	(27,0 x 0,90)	250 ft.	A927	A928	A929
1-1/4 x .042	(34,0 x 1,10)	250 ft.	A960	A961	A962
1-1/2 x .050	(41,0 x 1,27)	150 ft.	A977	A978	A979
2 x .063	(54,0 x 1,60)	150 ft.	A981	A982	A983

10° high positive rake with DUPLEX tooth design for maximum strength when cutting difficult material such as super alloys

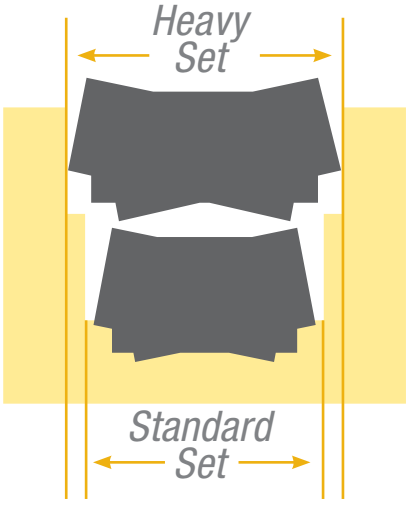
M-4000 M-42 (Heavy Set)

- For large and bundle cutting of structural steel
- Ideal for applications where a larger kerf is needed to prevent blade pinching and stalling from material stresses and movement

M-4000 M-42 (Heavy Set)

WIDTH x GAUGE			VARIABLE PITCH			
INCH	(MM)	COIL LENGTH	Model Number 2/3	Model Number 3/4	Model Number 4/6	Model Number 5/7
1 x .035	(27,0 x 0,90)	250 ft.	AXS927	--	AXS929	AXS930
1-1/4 x .042	(34,0 x 1,10)	250 ft.	--	AXS961	AXS962	AXS989
1-1/2 x .050	(41,0 x 1,27)	150 ft.	--	AXS978	AXS979	AXS9885
2 x .063	(54,0 x 1,60)	150 ft.	AXS981	AXS999	AXS983	--

Positive Rake



- *Ordering by the listed Product Codes, is for coil stock only.*
- *When ordering custom welded lengths use the Model # followed by a "W" and your exact weld length.*

RemGrit® CARBIDE GRIT BANDSAW BLADES

RemGrit® cuts through materials conventional tooth blades can't penetrate! Recommended for use in super alloys, fiberglass, honeycomb, foamed glass, hardened steel, graphite composites, fiber cement board and composite deck material.

GULLETED EDGE

- Features tungsten carbide grit bonded to an alloy steel back
- Carbide particle placement enables band to be run in either direction
- Unequalled life and cutting performance for hard or abrasive material

CONTINUOUS EDGE

- Use continuous edge for material less than 1/4" thick or for hard material with a tendency to fracture, crack, or chip easily
- Carrier wheels should be a minimum of 24" diameter

WIDTH x GAUGE			GULLETED						CONTINUOUS		
INCH	(MM)	COIL LENGTH	Model Number MEDIUM	Model Number MEDIUM COARSE	Model Number COARSE (EXTRA TEMPER) TIRE CUTTING	Model Number COARSE	Model Number COARSE (SHORT TOOTH)	Model Number COARSE (DEEP GULLET)	Model Number MEDIUM	Model Number MEDIUM COARSE	Model Number COARSE
1/4 x .020	(6,00 x 0,51)	250 ft.	308	--	--	--	--	--	310	--	--
3/8 x .025	(10,0 x 0,89)	250 ft.	322	324	--	--	--	--	328	--	--
1/2 x .020	(12,5 x 0,51)	250 ft.	335	--	--	--	--	--	337	338	--
1/2 x .025	(12,5 x 0,64)	250 ft.	330	331	--	--	--	--	333	334	--
3/4 x .032	(19,0 x 0,81)	250 ft.	341	--	--	344	--	--	346	--	349
1 x .035	(25,0 x 0,89)	250 ft.	--	350	381	351	--	352	--	--	357
1-1/4 x .035	(32,0 x 0,89)	250 ft.	--	--	--	--	--	362	--	--	363
1-1/4 x .042	(32,0 x 1,07)	250 ft.	--	--	--	--	--	365	--	--	--
1-1/2 x .042	(38,0 x 1,07)	250 ft.	--	--	--	--	374	--	--	--	--

Tech Tips for Carbide Grit Bandsaw Blades

- Select finer grit for finer finish; use coarser grit for faster cutting.
- When blade appears to be slowing, invert blade to reverse cutting direction to extend blade life up to 25%.

Recommended Band Speeds

BLADE	SFPM	MATERIAL
Coarse	150 - 200	Tool Steel (HrC 42-65)
Med. Coarse	150 - 300	Nitride Case Hardened and Inductive Hardened Steels
Coarse	150 - 400	High-Temp Nickel and Iron Base Super Alloys
Coarse	120 - 300	Hastelloys
Med. Coarse	150 - 500	Aircraft and Sheet Stainless
Coarse	150 - 600	Beryllium
Med. Coarse	125 - 700	Sintered Tungsten, Molybdenum, Iron, and Stainless
Med. Coarse	125 - 300	Welds and Met-Lab Specimens
Coarse	150 - 350	White and High Alloy Cast Iron
Coarse	150 - 300	Grey Cast Iron
Coarse	150 - 400	Titanium
Med. Coarse	1000 - 3000	Foamed Glass
Med. Coarse	300 - 700	Syntactic Foam
Medium	500 - 1500	Low Density Ceramics

BLADE	SFPM	MATERIAL
Medium	200 - 1200	Green Unfired Ceramics
Med. Coarse	800 - 1500	Fiber Reinforced Cement
Med. Coarse	1000 - 3000	Friction Materials
Medium	4000 - 6000	Fiberglass Honeycomb
Medium	1000 - 3000	Fiberglass Reinforced Plastics (polymers, epoxies, melamine, phenolics)
Medium	1500 - 3000	Graphite Composites
Medium	200 - 1000	Aircraft Tooling and Molding Compounds
Coarse	1000 - 4000	Carbon and Graphite
Medium	500 - 1000	Glass
Coarse	1200 - 3000	Wire Reinforced Rubber
Medium	1200 - 3000	Cable and Wire Rope
Coarse	400 - 1600	Compressed Perlite Molding Compounds
Med. Coarse	120 - 500	Cement Lined Steel and Cast Iron Pipe
Coarse	150 - 600	Soapstone, Chalk, Lava, Slate, and Coal

Shading indicates coolant recommended.

• Ordering by the listed Product Codes, is for coil stock only.

• When ordering custom welded lengths use the Model # followed by a "W" and your exact weld length.

Aggressor® CARBON BANDSAW BLADES

Carbon bandsaws are made for general cutting applications.They are ideal for straight and contour cutting. Use to cut carbon tool steels, tubing, solids, structurals, cast iron, and non-ferrous metals.

HARDBACK CARBON

- Solid Carbon Steel
- Tooth hardness 62 HRc - 66 HRc
- Back hardened up to 45 HRc for straight cuts
- Supports heavier feed pressure

Hardback Carbon

WIDTH x GAUGE			CONSTANT PITCH								
INCH	(MM)	COIL LENGTH	Model Number 3 Skip	Model Number 4 Skip	Model Number 6 Skip	Model Number 6 Raker	Model Number 8 Raker	Model Number 10 Raker	Model Number 14 Raker	Model Number 18 Raker	Model Number 24 Raker
1/4 x .025	(6,00 x 0,64)	250 ft.	--	211	213	--	--	214	215	216	217
3/8 x .025	(10,0 x 0,64)	250 ft.	--	223	--	--	--	226	227	228	--
1/2 x .025	(12,5 x 0,64)	250 ft.	--	234	--	236	--	237	239	241	243
3/4 x .032	(19,0 x 0,81)	250 ft.	262	--	--	264	265	267	271	--	--
1 x .035	(25,0 x 0,89)	250 ft.	--	--	--	280	--	282	284	--	--
1 1/4 x .042	(6,0 x 1,07)	250 ft.	--	--	--	295	--	--	--	--	--

WIDTH x GAUGE			CONSTANT PITCH							
INCH	(MM)	COIL LENGTH	Model Number 2 Hook	Model Number 3 Hook	Model Number 4 Hook	Model Number 6 Hook	Model Number 10 Wavy	Model Number 14 Wavy	Model Number 18 Wavy	Model Number 24 Wavy
1/4 x .025	(6,0 x 0,64)	250 ft.	--	--	210	212	--	--	--	--
3/8 x .025	(10,0 x 0,64)	250 ft.	--	220	222	224	--	--	--	--
1/2 x .025	(12,5 x 0,64)	250 ft.	--	231	233	235	238	240	--	242
3/4 x .032	(19,0 x 0,81)	250 ft.	--	261	--	263	268	272	273	--
1 x .035	(25,0 x 0,89)	250 ft.	275	277	--	--	283	--	--	--

FLEXBACK CARBON

- Solid Carbon Steel
- Tooth hardness 62 HRc - 66 HRc
- Back hardened up to 38 HRc for contour cutting
- Available in 250 ft. coils or custom-welded to length
- Cuts wood, cast iron, brass, aluminum, zinc, copper, mild steels, non-ferrous metals, fiberglass, plastic, bronze, and lead

Flexback Carbon

WIDTH x GAUGE			CONSTANT PITCH								
INCH	(MM)	COIL LENGTH	Model Number 3 Skip	Model Number 4 Skip	Model Number 6 Skip	Model Number 6 Raker	Model Number 8 Raker	Model Number 10 Raker	Model Number 14 Raker	Model Number 18 Raker	Model Number 24 Raker
1/4 x .025	(6,0 x 0,64)	250 ft.	--	041	043	--	--	044	046	047	048
3/8 x .025	(10,0 x 0,64)	250 ft.	--	063	--	--	065	066	068	069	--
1/2 x .025	(12,5 x 0,64)	250 ft.	--	094	--	097	--	098	100	102	104
3/4 x .032	(19,0 x 0,81)	250 ft.	142	--	--	144	146	148	152	154	--
1 x .035	(25,0 x 0,89)	250 ft.	172	--	--	174	175	176	--	--	--

WIDTH x GAUGE			CONSTANT PITCH						
INCH	(MM)	COIL LENGTH	Model Number 2 Hook	Model Number 3 Hook	Model Number 4 Hook	Model Number 6 Hook	Model Number 10 Wavy	Model Number 14 Wavy	Model Number 24 Wavy
1/4 x .025	(6,0 x 0,64)	250 ft.	--	--	040	042	--	--	--
3/8 x .025	(10,0 x 0,64)	250 ft.	--	060	062	064	--	--	--
1/2 x .025	(12,5 x 0,64)	250 ft.	--	091	093	096	--	101	105
3/4 x .032	(19,0 x 0,81)	250 ft.	--	141	139	143	149	--	--
1 x .035	(25,0 x 0,89)	250 ft.	170	171	--	--	--	--	--

Guidelines for successful bandsaw operation

Blade Width Selection

The dimension from tooth tip to back edge of the blade is the blade width. The greater the width, the greater the resistance to deflection while cutting. For straight cutting applications, use the widest blade the machine can accept. For contour cutting use the widest blade that the contour radius will permit. To cut close tolerance radii the following factors must be considered: blade width, material thickness, machinability, feed force, and location of pivot point.

Teeth Per Inch

The pitch of the blade is defined by the number of teeth per inch (TPI.) Nonferrous materials such as brass, bronze and aluminum require a large chip area. A low TPI, or "coarse pitch," prevents the chips from clogging and binding together in the gullets, which can diminish sawing and damage the blade.

On thin walled pipe, tubing, and sheet goods, many teeth per inch are required to avoid damaging or breaking the teeth. A low TPI blade is the best blade for cutting large cross-sections. The ability of each tooth to cut into the workpiece is increased because the saw's feed pressure is distributed over fewer teeth. A coarse pitch blade increases productivity and provides large chip clearing gullets.

Blade Break-In

Set bandsaw machine at recommended speed for material to be cut. When cutting easily machined metals, cutting rate should be set at 1/3 to 1/2 the recommended rate for the first 50 to 75 square inches.

When cutting difficult to machine metals, such as tool steels or work hardened alloys, set cutting rate at 75% of the recommended rate for the first 25 square inches. Gradually increase the feed until you achieve the recommended cutting rate after 50 to 60 square inches.

Tooth Selection

Tooth selection is based on the principle that there is a tooth pitch best suited for the cutting job. Blade selection should be based on the size, shape accuracy, material and cutting rate expected.

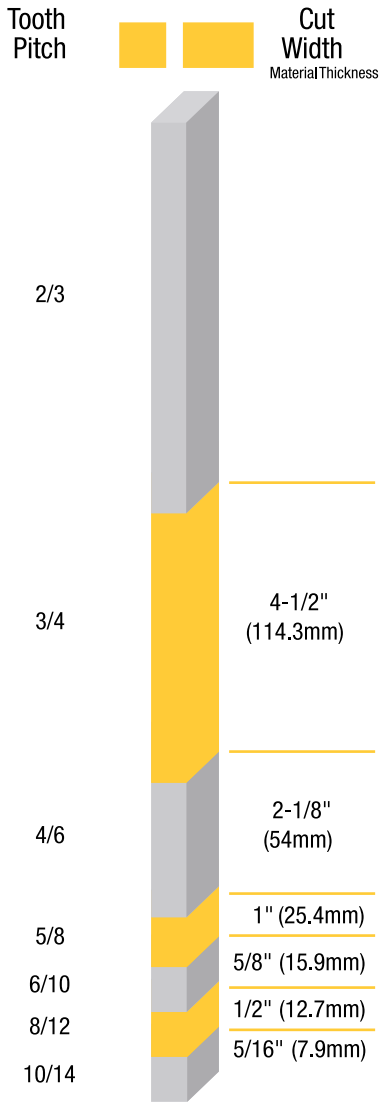
Keep in mind these numbers: 3, 6, 12, and 24. There should be a minimum of three teeth in the work at all times for bi-metal bands and a minimum of six teeth for carbon bands. Ideally, 6 – 12 teeth should be in contact with the work; 24 teeth in the work is too many.

Feed Pressure

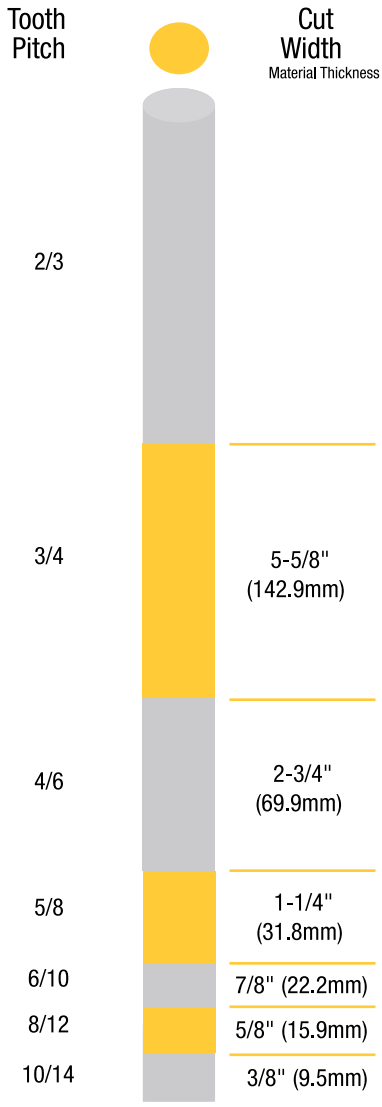
Chips tell you what is happening with your feed pressure and your blade. Powdery or fine chips indicate that not enough feed pressure is being applied. Heavy, thick or blue burned chips mean you're pushing the blade too hard, creating too much heat and load for the teeth. Loosely curled chips tell you everything is going well. Speed should be determined by the class of material (this should remain constant.) Feed would be adjusted until desired chip formation is achieved.

Tooth Pitch Selection

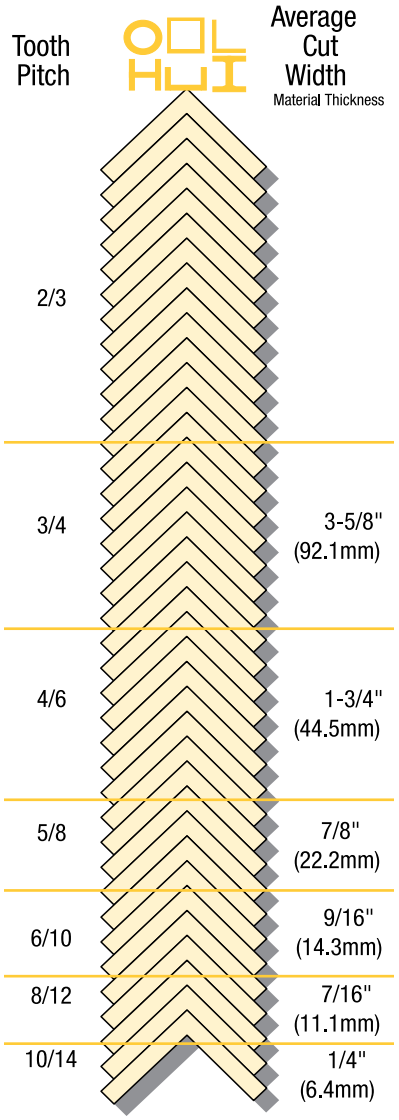
Solid Square & Rectangle



Solid Round

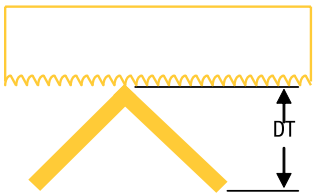


Structurals

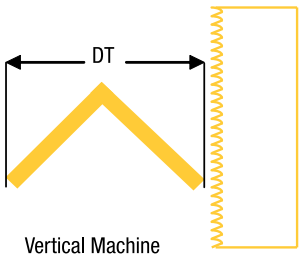


Area = pounds per foot x .294

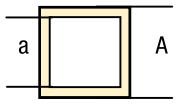
Aluminium Structural Area - pounds per foot x .85



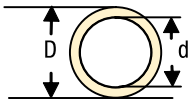
Horizontal Machine



Vertical Machine



A - a = area



$D = .7854 \times D^2$

$d = .7854 \times d^2$

D - d = area

πr^2 = area

$$\frac{\text{area}}{\text{(DT) distance of travel}} = \text{average cut width}$$

For lowest cost per cut, always select the narrowest cross section of the material to be cut for added beam strength, more teeth in cut, longer life, higher band speed, and shortest cut time.

Recommended Bandsaw Operating Speeds (FPM Table)

Carbon Steels	
Material	FPM
1008	320
1015	320
1018	300
1020	320
1021	300
1022	300
1025	320
1026	300
1030	330
1035	310
1040	270
1042	250
1044	220
1045	220
1060	200
1095	180
1117	340
1137	290
1141	280
1144	280
1213	380
1215	380
1513	300
1541	250
A36	270

Alloy Steels	
Material	FPM
150	250
1330	220
1345	210
4130	270
4140	250
4145	210
4340	220
5160	220
6150	210
8616	240
8620	240
8630	220
8640	200
9310	170
52100	160
300M	160
41L40	270
A242	280
e.t.d.	250
HP 9-4-20	100
HP 9-4-25	100
HY-100	160
HY-80	160

Tool & Mold Steels	
Material	FPM
A10	160
A2	180
A6	200
D2	90
H11	190
H12	190
H13	190
L6	190
M1	110
M42	100
O1	200
O6	190
P20	230
S1	200
S5	140
S7	120
T1	100
T15	70
W1	220

Stainless Steels	
Material	FPM
230	150
303	140
304	120
309	90
310	80
316	100
324	100
347	110
410	140
414	110
416	190
420	190
430	150
431	90
450	80
502	140
2205	80
18-8-2	90
22-13-5	60
440C	80
440F	160
M225	90
Nitronic 50	60
Nitronic 60	60
SS-PH	80

Super Alloys	
Material	FPM
A286	90
Astroloy	60
Hastelloy	70
Incoloy 800	90
Incoloy 900	60
Inconel	60
Inconel 625	100
Monel	70
Nickel 200	80
Pyromet X15	120
Titanium	70
Waspalloy	70
WF11	60

BAND SPEEDS
based on 4" material.

INCREASE for smaller sizes 2" +10%;

DECREASE for larger sizes 6" -10%.

Feeds

Tooth Pitch	10/14	8/12	6/10	5/8	5/7	4/6	3/4	2/3
Multiplier Rate (MR)	.047	.039	.031	.025	.024	.020	.014	.010
(mm)	(1.19)	(.99)	(.79)	(.64)	(.61)	(.51)	(.36)	(.25)

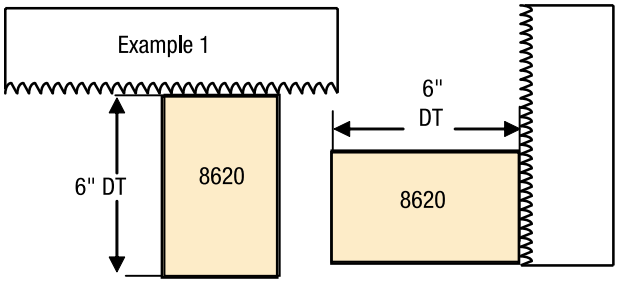
After determining proper tooth pitch and band speed, select the rate MR (multiplier rate) for the tooth pitch being considered and use this formula to determine feedrate:

Band Speed x MR = Linear Inches per Minute Rate

Example 1:

4" X 6" 8620, band speed 240 fpm,
recommended tooth pitch
3/4 cutting the 4" width = MR .014

240 X .014 = 3.36 linear in/min



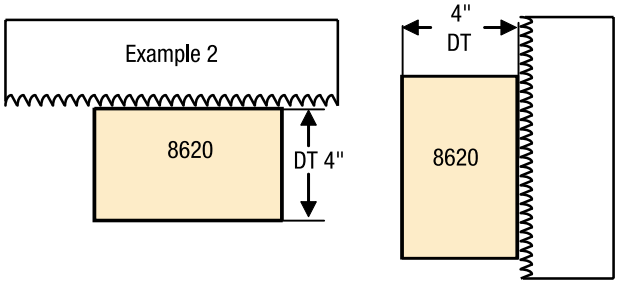
$$\frac{6"}{3.36} = 1.79 \text{ min (CT)} \quad (1 \text{ min. } 47 \text{ sec.})$$

$$\frac{\text{(DT) distance of travel}}{\text{Linear in/min}} = \text{(CT) cut time}$$

Example 2:

4" X 6" 8620, band speed 215 fpm,
recommended tooth pitch
2/3 cutting the 6" width = MR .010

215 X .010 = 2.15 linear in/min

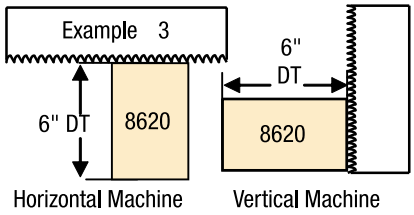


$$\frac{4"}{2.15} = 1.86 \text{ min (CT)} \quad (1 \text{ min. } 52 \text{ sec.})$$

Example 3:

4" X 6" 8620, band speed 240 fpm, recommended tooth pitch 3/4 cutting the 4" width = MR .014

240 X .014 = 3.36 linear in/min

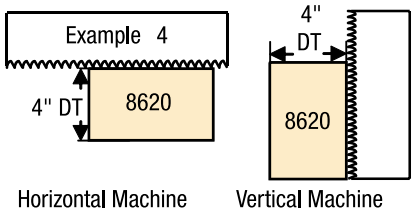


$\frac{6\text{" (DT)}}{3.36\text{ L in/min}}$ = 1.79 min (CT) (1 min. 47 sec.)

Example 4:

4" X 6" 8620, band speed 215 fpm, recommended tooth pitch 2/3 cutting the 6" width = MR .010

215 X .010 = 2.15 linear in/min

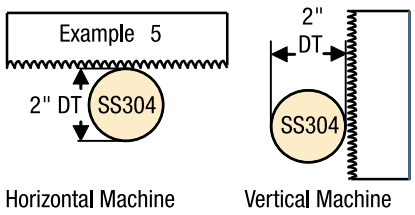


$\frac{4\text{" (DT)}}{2.15\text{ L in/min}}$ = 1.86 min (CT) (1 min. 52 sec.)

Example 5:

2" dia. SS304, band speed 132 fpm, recommended tooth pitch 4/6 cutting the 2" width = MR .020

132 X .020 = 2.64 linear in/min

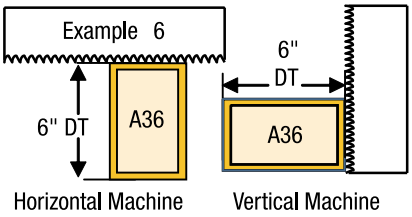


$\frac{2\text{" (DT)}}{2.64\text{ L in/min}}$ = .75 min (CT) (45 sec.)

Example 6:

4" X 6", 1/4" wall A36, band speed 270 fpm, recommended tooth pitch 5/8 cutting the .79" avg. cut width = MR . 025

270 X .025 = 6.75 linear in/min

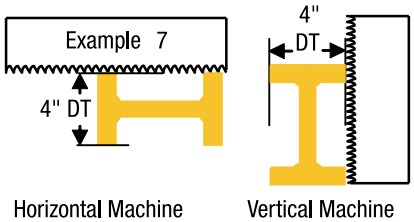


$\frac{6\text{" (DT)}}{6.75\text{ L in/min}}$ = .88 min (CT) (53 sec.)

Example 7:

"I" beam, 37.41 lbs/ft A36, band speed 240 fpm, recommended tooth pitch 3/4 cutting the 1.83" avg. cut width = MR .014

240 X .014 = 3.36 linear in/min

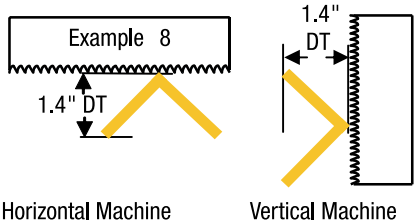


$\frac{4\text{" (DT)}}{3.36\text{ L in/min}}$ = 1.19 min (CT) (1 min. 11 sec.)

Example 8:

2" angle 1/4" wall A36, band speed 300 fpm, recommended tooth pitch 5/8 cutting the .7" avg. cut width = MR .025

300 X .025 = 7.5 linear in/min



$\frac{1.4\text{" (DT)}}{7.5\text{ L in/min}}$ = .19 min (CT) (11 sec.)

For the lowest cost per cut, always select/position the material to obtain the narrowest cross section to be cut for added beam strength, more teeth in cut, longer tool life, higher band speed, and quickest cut time.

When stacking material, multiply the area of each piece by the number of pieces, then divide by the DT (distance of travel) to obtain average cut width for selection of proper tooth pitch.

When using a smaller tooth pitch than normal, use the MR (multiplier rate) listed for the proper selection to minimize over-filling the gullets of the smaller teeth.

For increased production, after determining the beam strength, material clamping, coolant, tooth pitch, and machine condition are all appropriate, the MR (multiplier rate) can be increased up to 25%.

Blade Break-in

It is important to run all new bandsaw blades at a reduced rate to break them in. This helps to remove any uneven edges that are imparted on cutting tools during the manufacturing processes, and can double the life of the blade. To break in a blade:

1) Set machine to the recommended band speed for the material being cut.

2) Multiply the recommended cut time by:
   a. 2 – for band speeds 250 fpm and higher
   b. 1.75 – for band speeds 175 to 250 fpm
   c. 1.5 – for band speeds 120 to 175 fpm
   d. 1.25 – for band speeds 80 to 120 fpm
   e. Band speeds less than 80 fpm require minimal break-in

3) Gradually increase cutting rate to proper cut time over the next:
   a. 80 to 100 sq. in.
   b. 60 to 80 sq. in.
   c. 40 to 60 sq. in.
   d. 20 to 40 sq. in.
   e. 20 or less sq. in.

BANDSAW BLADES

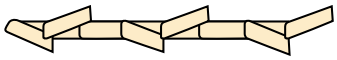
Bandsaw Terms

Tooth Form

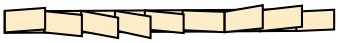
Positive rake. A positive rake tooth angles forward in the direction of the cutting action. Higher positive rake angles give the most aggressive tooth penetration for easier chip formation. This tooth form is recommended for cutting difficult-to-machine materials, solids, and solid cross sections.

Straight tooth. A straight tooth has a 0° cutting face, and is recommended for cutting easy-to-cut, low alloy materials as well as interrupted cuts.

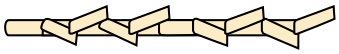
Tooth Set



Raker set. These are individually set teeth – first right then left – followed by an unset tooth. The unset tooth (raker tooth) allows for fast chip removal and a straight cutting action. This tooth set is recommended for general purpose cutting applications.



Wavy set. Wavy set teeth are set in groups, right and left, in varying degrees. Wavy set teeth are recommended for cutting light metal sections, such as sheet, tubing and small solid shapes.



Modified raker set. Variable set teeth are set in alternating groups with a single unset tooth (raker tooth). When these are combined with the varying set angles of the teeth, a faster, smoother, and quieter cutting action is achieved. Variable tooth blades perform extremely well on most applications and provide fast cutting on solids, shapes, structurals and piping.

Tooth Type

Regular. This is a conventional tooth with a 0° rake angle, ideal for a wide range of general purpose cutting applications.

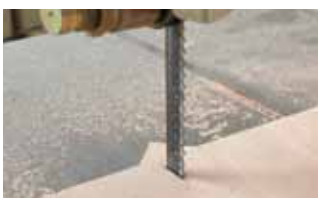
Hook. This tooth type has a 10° positive rake angle for fast cutting with less feed pressure. The rounded gullets allow for fast chip removal and are generally used for cutting nonmetallics and nonferrous metals.

Skip. This tooth type has a 0° rake angle with shallow gullets and evenly spaced teeth for efficient chip removal. It is used for cutting large sections of soft, nonferrous metal and nonmetal material, such as wood, composition materials, cork and plastic.

Variable. A traditional tooth form that offers a 0° rake angle, varying gullet depths and tooth sizes. Designed to reduce harmonic vibration, this blade efficiently removes chips, extending blade life in solids and structurals.

Variable Positive. Variable positive tooth form offers varying gullet depth, tooth sizes and a positive rake angle for maximum cutting speeds and better tooth penetration in harder to machine materials.

Duplex. Duplex blades offer deep, chip clearing gullets, increased tooth strength, and a high positive rake angle. This results in faster sawing rates and improved finishes. Duplex blades are recommended for production cutting work hardened metals, tool steels, and exotic alloys.



Machine Checklist

- The blade tension with a tension meter
- The performance of the chip brush
- The wear and alignment of the blade guides
- The band speed with a tachometer
- The cutting fluid concentration with a refractometer

Cutting Fluid

The cutting fluid keeps the blade teeth cool, it prevents the chips from welding to the tooth, and also lubricates the chips, allowing them to move through the cut.

- Use a high quality cutting fluid
- Make sure the cutting fluid is distributed throughout the cut

One-Year Limited Warranty Policy

1. Definitions

"Product" or "Products" means any product(s) manufactured for or by Disston Company (hereinafter "Disston"). "Date of Original Retail Purchase" is the date the customer first bought the Product.

2. Scope of Warranty

DISSTON WARRANTS that its Products are free from defective materials and workmanship for a period of ONE (1) YEAR from the Date of Original Retail Purchase. This warranty does not extend to Products that have been damaged by accident, abuse, misuse, or misapplication; or to Products that have been modified or altered.

3. Warranty Procedures

Disston will, at its option, repair, replace or credit an amount equal to the purchase price of the Product in addition to any shipping paid by the customer, provided that the customer first contacts Disston's customer service department for return authorization and instructions. Upon return authorization, the Product should be returned to Disston with shipping prepaid for review and evaluation. The contact information for Disston's customer service department is as follows:

Disston Company
5 Industrial Drive West
South Deerfield, MA 01373
Phone: 800/272-4436, 800/446-8890 International Phone: (1) 413/665-1262
Fax: 800/654-1972, 888/729-3004 International Fax: (1) 413/665-8064
Email: customer.service@disstontools.com

Disston reserves the right to require reimbursement for shipping costs if the Product received by Disston is not covered by this warranty and the customer requests that the product be returned.

4. Limitations on Warranty

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