



INDUSTRIAL METALSAWING BANDSAW BLADES

BAHCO®

BAHCO 3859 EasyCut Xtreme



LEARN MORE ABOUT BAHCO
BANDSAW BLADES

PALLET DISMANTLER & CARBON STEEL BLADES

Designed for the pallet recycling & pallet dismantling industry.

M42 PALLET DISMANTLER BANDSAW BLADES			
Inches	mm	Teeth Per Inch	Product Code
1-1/4 X .042	34 X 1.1	5/8	M42-34-1.1-5/8-UB
BULK PACK WELDED LOOPS - 20 EACH			
Length	Product Code		
18'6"	M42-34-1.1-5/8-UB-186		
19'	M42-34-1.1-5/8-UB-190		
20'	M42-34-1.1-5/8-UB-200		
20'6"	M42-34-1.1-5/8-UB-206		
22'	M42-34-1.1-5/8-UB-220		
22'4"	M42-34-1.1-5/8-UB-224		
23'	M42-34-1.1-5/8-UB-230		
23'8"	M42-34-1.1-5/8-UB-238		
24'	M42-34-1.1-5/8-UB-240		
25'4"	M42-34-1.1-5/8-UB-254		

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

3840 PALLET DISMANTLER RECIPROCATING BIMETAL SAW BLADES				
Inches	mm	Teeth Per Inch	Pack Qty	Product Code
7-1/2	190	10/14	100	384019010/14PRRU09CP **
7-1/2	190	10	100	384019010/PRU09100P **
8	210	10	100	384021010/PRU09100P **
8	210	10	500	384021010/PRU09500P
10	269	10	100	384026910/PRU09100P

** Future discontinued, available while supplies last.

- Designed for use by the pallet dismantler business
- The unique design prevents the blade from getting stuck in close by wood beams, when cutting nails in damaged parts of the pallet.
- The tooth design allows for a good material rate removal in wood with nails and high strength to prevent tooth breakage



Carbon steel For less demanding applications.

3849 FLEXBACK CARBON STEEL BLADES			
Inches	mm	Teeth Per Inch Hook Tooth	Product Code
1/4 x .025	6 x 0.6	4	3849-6-0.6-H-4
		6	3849-6-0.6-H-6
3/8 x .025	10 x 0.6	3	3849-10-0.6-H-3
		4	3849-10-0.6-H-4
		6	3849-10-0.6-H-6
1/2 x .025	13 x 0.6	3	3849-13-0.6-H-3
		4	3849-13-0.6-H-4
		6	3849-13-0.6-H-6
3/4 x .032	20 x 0.8	3	3849-20-0.8-H-3
		6	3849-20-0.8-H-6
1 x .035	25 x 0.9	2	3849-25-0.9-H-2
		3	3849-25-0.9-H-3
		4	3849-25-0.9-H-4
		6	3849-25-0.9-H-6

3847 HIGH HARD CARBON STEEL BLADES			
Inches	mm	Teeth Per Inch Regular Tooth	Product Code
1/4 x .025	6 x 0.6	10	3847-6-0.6-R-10
		14	3847-6-0.6-R-14
		18	3847-6-0.6-R-18
		24	3847-6-0.6-R-24
3/8 x .025	10 x 0.6	10	3847-10-0.6-R-10
		14	3847-10-0.6-R-14
		8	3847-10-0.6-R-8
1/2 x .025	13 x 0.6	10	3847-13-0.6-R-10
		14	3847-13-0.6-R-14
		18	3847-13-0.6-R-18
		24	3847-13-0.6-R-24
		6	3847-13-0.6-R-6
3/4 x .032	20 x 0.8	10	3847-20-0.8-R-10
		14	3847-20-0.8-R-14
		18	3847-20-0.8-R-18
		6	3847-20-0.8-R-6
		8	3847-20-0.8-R-8
1 x .035	25 x 0.9	10	3847-25-0.9-R-10
		14	3847-25-0.9-R-14
		6	3847-25-0.9-R-6
		8	3847-25-0.9-R-8



3861 & 3862-WOODCUTTING

Common features for 3861 & 3862 blades:

- Blades can be re-sharpened
 - Fatigue resistant spring steel saw blade backing material made from D6A alloyed steel (Hardness 44-46 HRC)
 - Full "In line" heat treatment process guarantees straightness and the highest quality finish to our product
- Hook Tooth - Traditional tooth design with 10° rake angle, used for non-ferrous metals, wood and plastics.

3861 SANDCUT® BIMETAL

Inches	mm	Teeth Per Inch	Product Code
1 x .035	27 x 0.9	1.33	3861-27-0.9-H-1.33
		2	3861-27-0.9-H-2-BIG
1-1/4 x .035	34 x 0.9	1.15	3861-34-0.9-H-1.15
		1.33	3861-34-0.9-H-1.33
1-1/4 x .042	34 x 1.1	1.15	3861-34-1.1-H-1.15
		1.33	3861-34-1.1-H-1.33
1-1/2 x .042	41 x 1.1	1.15	3861-41-1.1-H-1.15
2 x .042	54 x 1.1	1.15	3861-54-1.1-H-1.15

BAHCO Sandcut Bi-Metal 3861



- High hardness tooth compared to Carbon equivalent by using bi-metal technology – High speed steel tooth using M2 tool steel (Hardness 66-67 HRC)
- The bi-metal technology, one blade covers all the different types of wood (soft, hard, exotic) and they operate successfully both in winter and summer conditions.

3862 SANDCUT® SOLID

Inches	mm	Teeth Per Inch	Product Code
1-1/4 x .042	34 x 1.1	1.15	3862-33-1.1-H-1.15

BAHCO Sandcut Solid 3862



- Hard tooth equivalent to Carbon by using spring steel technology
- This product goes through the same high technology production lines used to produce our market leading metal cutting bandsaw blades.

SANDFLEX® M42 and 3857-EASY-CUT®

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
- Backing material allows for flexibility of the band while holding up against fatigue

Combo Tooth - Traditional shape tooth with varying degree, 8° or 10° rake angle makes M42 suitable for multipurpose cutting of thin-walled tubes and profiles in most materials.

SANDFLEX® M42			
Inches	mm	Teeth Per Inch	Product Code
1/2 x .020	13 x 0.5	10/14	M42-13-0.5-10/14
		14/18	M42-13-0.5-14/18
1/2 x .025	13 x 0.6	6/10	M42-13-0.6-6/10
		8/12	M42-13-0.6-8/12
		10/14	M42-13-0.6-10/14
		14/18	M42-13-0.6-14/18
1/2 x .035	13 x 0.9	6/10	M42-13-0.9-6/10
		10/14	M42-13-0.9-10/14
3/4 x .035	20 x 0.9	4/6	M42-20-0.9-4/6
		5/8	M42-20-0.9-5/8
		6/10	M42-20-0.9-6/10
		8/12	M42-20-0.9-8/12
		10/14	M42-20-0.9-10/14
1 x .035	27 x 0.9	2/3	M42-27-0.9-2/3
		3/4	M42-27-0.9-3/4
		4/6	M42-27-0.9-4/6
		5/8	M42-27-0.9-5/8
		6/10	M42-27-0.9-6/10
		8/12	M42-27-0.9-8/12
		10/14	M42-27-0.9-10/14
1-1/4 x .042	34 x 1.1	2/3	M42-34-1.1-2/3
		3/4	M42-34-1.1-3/4
		4/6	M42-34-1.1-4/6
		5/8	M42-34-1.1-5/8
1-1/2 x .050	41 x 1.3	6/10	M42-34-1.1-6/10
		2/3	M42-41-1.3-2/3
		3/4	M42-41-1.3-3/4
		4/6	M42-41-1.3-4/6
		5/8	M42-41-1.3-5/8
2 x .062	54 x 1.6	6/10	M42-41-1.3-6/10
		1.4/2	M42-54-1.6-1.4/2
		2/3	M42-54-1.6-2/3
		3/4	M42-54-1.6-3/4
		4/6	M42-54-1.6-4/6

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.

Medium Tooth - 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.

- 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

US Patent No. 7,178,441

3857 EASY-CUT®		
Inches	mm	Product Code
1/2 x .020	13 x 0.5	3857-13-0.5-EZ-S
1/2 x .025	13 x 0.6	3857-13-0.6-EZ-M
3/4 x .035	20 x 0.9	3857-20-0.9-EZ-M
1 x .035	27 x 0.9	3857-27-0.9-EZ-M
1 1/4 x .042	34 x 1.1	3857-34-1.1-EZ-M



3857 EASY-CUT®

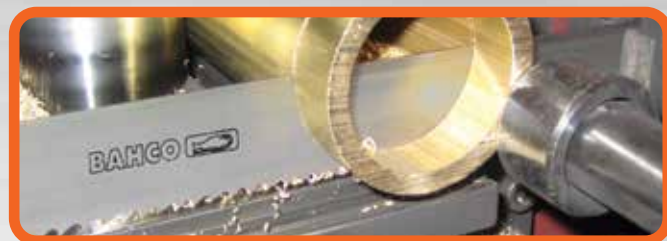


SANDFLEX® M42



The most flexible solution for cutting, from general purpose to production

- POWDERED metal M42 high speed steel tooth edge gives a combination of higher hardness and higher toughness
- Less vibrations, consequently less heat and better wear resistance
- A superior surface finish generates less friction and vibration for improved performance
- General Purpose Applications, solids, bundle, even profiles and castings
- Contour cutting, including aluminum and stainless steel



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

Combo Tooth - New tooth geometry with variable teeth 8-10° rake angle makes the 3851 toothing more robust and increases the performance.

3851 COBRA™ - HOOK TOOTH

Inches	mm	Teeth Per Inch	Product Code
1/4 x .025	6 x 0.6	6	3851-6-0.6-H-6
1/4 x .035	6 x 0.9	6	3851-6-0.9-H-6
3/8 x .025	10 x 0.6	4	3851-10-0.6-H-4
		6	3851-10-0.6-H-6
3/8 x .035	10 x 0.9	4	3851-10-0.9-H-4
		6	3851-10-0.9-H-6
1/2 x .025	13 x 0.6	3	3851-13-0.6-H-3
		4	3851-13-0.6-H-4
		6	3851-13-0.6-H-6
1/2 x .035	13 x 0.9	3	3851-13-0.9-H-3
		4	3851-13-0.9-H-4
		6	3851-13-0.9-H-6
3/4 x .035	20 x 0.9	3	3851-20-0.9-HA-3
1 x .035	27 x 0.9	3	3851-27-0.9-H-3

3851 COBRA™ - COMBO TOOTH

Inches	mm	Teeth Per Inch	Product Code
1/4 x .025	6 x 0.6	10/14	3851-6-0.6-10/14
		14/18	3851-6-0.6-14/18
1/4 x .035	6 x 0.9	10/14	3851-6-0.9-10/14
3/8 x .025	10 x 0.6	10/14	3851-10-0.6-10/14
3/8 x .035	10 x 0.9	10/14	3851-10-0.9-10/14
1/2 x .025	13 x 0.6	5/8	3851-13-0.6-5/8
		6/10	3851-13-0.6-6/10
		8/12	3851-13-0.6-8/12
		10/14	3851-13-0.6-10/14
1/2 x .035	13 x 0.9	6/10	3851-13-0.9-6/10
		10/14	3851-13-0.9-10/14
3/4 x .035	20 x 0.9	4/6	3851-20-0.9-4/6
		5/8	3851-20-0.9-5/8
		6/10	3851-20-0.9-6/10
		8/12	3851-20-0.9-8/12
		10/14	3851-20-0.9-10/14
1 x .035	27 x 0.9	2/3	3851-27-0.9-2/3
		3/4	3851-27-0.9-3/4
		4/6	3851-27-0.9-4/6

BAHCO Sandflex® Cobra™ 3851

3851 COBRA™ - COMBO TOOTH

Inches	mm	Teeth Per Inch	Product Code
1 x .035	27 x 0.9	5/8	3851-27-0.9-5/8
		6/10	3851-27-0.9-6/10
		8/12	3851-27-0.9-8/12
		10/14	3851-27-0.9-10/14
1-1/4 x .042	34 x 1.1	2/3	3851-34-1.1-2/3
		3/4	3851-34-1.1-3/4
		4/6	3851-34-1.1-4/6
		5/8	3851-34-1.1-5/8
		6/10	3851-34-1.1-6/10
1-1/2 x .050	41 x 1.3	2/3	3851-41-1.3-2/3
		3/4	3851-41-1.3-3/4
		4/6	3851-41-1.3-4/6
		5/8	3851-41-1.3-5/8
		1.4/2	3851-41-1.3-1.4/2
2 x .062	54 x 1.6	1.4/2	3851-54-1.6-1.4/2
		1/1.4	3851-54-1.6-1/1.4
		2/3	3851-54-1.6-2/3
		3/4	3851-54-1.6-3/4
		4/6	3851-54-1.6-4/6
2-5/8 x .062	67 x 1.6	.7/1	3851-67-1.6-.7/1
		1.4/2	3851-67-1.6-1.4/2
		1/1.4	3851-67-1.6-1/1.4
		2/3	3851-67-1.6-2/3
		3/4	3851-67-1.6-3/4
3-1/8 x .062	80 x 1.6	.7/1	3851-80-1.6-.7/1
		1/1.4	3851-80-1.6-1/1.4
		1.4/2	3851-80-1.6-1.4/2

BAHCO Sandflex® Cobra™ 3851



BAHCO

3854-KING COBRA™ PHX and PQ

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

- Tooth made from powder metallurgic material withstands high heat levels and is wear resistant and will give a much better blade life.
- For high performance cutting of large and difficult to cut work pieces: tool steel, H-13, D-2, P20
- Special VariEdge, variable rake and clearance angle to optimize each tooth cutting properties
- Three different tooth heights in combination with two set levels will give an improved multichip configuration
- Two set levels for multichip configuration
- Extra deep gullets design to handle bigger chips

Cuts:

- Tool Steel
- H-13, D-2, P-20

PHX - is a patented ground tooth with patented set pattern and a 10° positive rake angle designed for good penetration of large sections of tough-to-cut alloys and work hardening materials.



For difficult to cut materials - multi chip performance

- Powder metallurgic tooth material will give a much better blade life
- The tooth design improves cutting performance in special alloys with work hardening properties
- The wedge angle of 48° gives a strong tooth
- The different set levels produce a multi-chip cutting profile which reduces cutting forces and improves blade life.

Positive Quad PQ - Very aggressive 17° positive patented 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.

3854 KING COBRA™ PHX			
Inches	mm	Teeth Per Inch	Product Code
1 x .035	27 x 0.9	3/4	3854-27-0.9-PHX-3/4
		4/6	3854-27-0.9-PHX-4/6
1-1/4 x .042	34 x 1.1	1.4/2	3854-34-1.1-PHX-1.4/2
		2/3	3854-34-1.1-PHX-2/3
		3/4	3854-34-1.1-PHX-3/4
		4/6	3854-34-1.1-PHX-4/6
1-1/2 x .050	41 X 1.3	2/3	3854-41-1.3-PHX-2/3
		3/4	3854-41-1.3-PHX-3/4
		1.4/2	3854-41-1.3-PHX-1.4/2
2 x .062	54 x 1.6	.7/1	3854-54-1.6-PHX-.7/1
		1.4/2	3854-54-1.6-PHX-1.4/2
		2/3	3854-54-1.6-PHX-2/3
2-5/8 x .062	67 x 1.6	1.4/2	3854-67-1.6-PHX-1.4/2
		.7/1	3854-67-1.6-PHX-.7/1
		1/1.4	3854-67-1.6-PHX-1/1.4
3-1/8 x .062	80 x 1.6	.7/1	3854-80-1.6-PHX-.7/1
		1.4/2	3854-80-1.6-PHX-1.4/2

3854 KING COBRA™ PQ			
Inches	mm	Teeth Per Inch	Product Code
1 x .035	27 X 0.9	3/4	3854-27-0.9-PQ-3/4
		4/6	3854-27-0.9-PQ-4/6
1-1/4 x .042	34 x 1.1	2/3	3854-34-1.1-PQ-2/3
		3/4	3854-34-1.1-PQ-3/4
		4/6	3854-34-1.1-PQ-4/6
		2/3	3854-41-1.3-PQ-2/3
1-1/2 x .050	41 X 1.3	3/4	3854-41-1.3-PQ-3/4
		4/6	3854-41-1.3-PQ-4/6
		1.4/2	3854-41-1.3-PQ-1.4/2
		2/3	3854-54-1.6-PQ-2/3
2 x .062	54 x 1.6	3/4	3854-54-1.6-PQ-3/4
		4/6	3854-54-1.6-PQ-4/6
		.9/1.2	3854-54-1.6-PQ-.9/1.2
		1.4/2	3854-54-1.6-PQ-1.4/2
		2/3	3854-67-1.6-PQ-2/3
2-5/8 x .062	67 x 1.6	.9/1.2	3854-67-1.6-PQ-.9/1.2
		1.4/2	3854-67-1.6-PQ-1.4/2
		3/4	3854-80-1.6-PQ-3/4
3-1/8 x .062	80 x 1.6	.9/1.2	3854-80-1.6-PQ-.9/1.2
		1.4/2	3854-80-1.6-PQ-1.4/2



3853-TOP FABRICATOR

3853 Top Fabricator for tubes or profiles

- New POWDERED metal M42 high speed steel tooth edge gives a combination of higher hardness and higher toughness.
- Double set makes the teeth stronger, more resistant to tooth stripping, and longer lasting.
- M42 bi-metal material offers longer blade life.
- W - EXTRA WIDE SET – used for heavy structurals to eliminate pinching

Cuts:

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

Reduces:

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

Combo PF - Specifically designed for cutting bundles of tubes and profiles with excellent capacity and tool life. Very strong tooth with 9 degree positive rake angle.

3853 TOP FABRICATOR			
Inches	mm	Teeth Per Inch	Product Code
1 x 0.35	27 x 0.9	3/4	3853-27-0.9-3/4
		4/6	3853-27-0.9-4/6
		5/8	3853-27-0.9-5/8
1-1/4 x .042	34 x 1.1	2/3	3853-34-1.1-2/3
		3/4	3853-34-1.1-3/4
		4/6	3853-34-1.1-4/6
		5/8	3853-34-1.1-5/8
1-1/2 x .050	41 X 1.3	2/3	3853-41-1.3-2/3
		3/4	3853-41-1.3-3/4
		3/4	3853-41-1.3-3/4-W
		4/6	3853-41-1.3-4/6
		5/8	3853-41-1.3-5/8
2 x .050	54 x 1.3	3/4	3853-54-1.3-3/4
		3/4	3853-54-1.3-3/4-W
		5/8	3853-54-1.3-5/8
2 x .062	54 X 1.6	2/3	3853-54-1.6-2/3
		2/3	3853-54-1.6-2/3-W
		3/4	3853-54-1.6-3/4
		3/4	3853-54-1.6-3/4-W
		4/6	3853-54-1.6-4/6
2-5/8 x .062	67 x 1.6	2/3	3853-67-1.6-2/3
		2/3	3853-67-1.6-2/3-W
		3/4	3853-67-1.6-3/4
		3/4	3853-67-1.6-3/4-W
		5/8	3853-67-1.6-5/8-W **



** Future discontinued, available while supplies last.



SAWING AIDS



See page 19 or scan the QR Code above to view all Sawing Aids



3858-SANDFLEX® P9000

Specifically designed to cut all difficult materials in medium and large work pieces.

- Bahco is using a very high-quality powder metallurgic HSS for the toothing to create an extreme blade life.
- Developed for cutting harder material
- Tooth made from a higher grade powder metallurgic material will gives a much better blade life.
- Ground tooth for precise and consistent tooth height
- For high performance cutting of large and difficult to cut work pieces
- Extreme blade life
- Increased hardness and toughness
- VariEdge, variable rake and clearance angle to optimize each tooth cutting properties
- Three different tooth heights in combination with two set levels will gives an improved multichip configuration.
- Two set levels for multichip configuration
- New tooth design that will give less vibration.
- Extra deep gullets design to handle bigger chips.
- 4% Cr backing material that will increase fatigue life.
- Runs well on plate saws

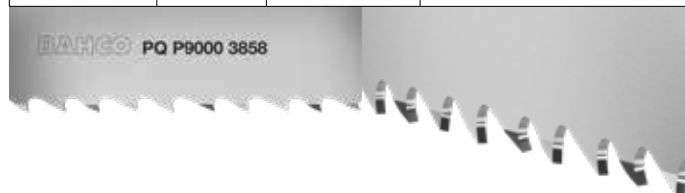
Cuts:

- Tool Steel
- Inconel
- Monel
- Zirconium
- Titanium
- Stainless Steel

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.

PHX - Is a patented tooth design with patented set pattern and a 10° positive rake angle designed for good penetration of large sections of tough-to-cut alloys and work hardening materials.

3858 SANDFLEX® P9000 - PQ			
Inches	mm	Teeth Per Inch	Product Code
1-1/2 x .050	41 x 1.3	1.4/2	3858-41-1.3-PQ-1.4/2
		2/3	3858-41-1.3-PQ-2/3
		3/4	3858-41-1.3-PQ-3/4
2 x .062	54 x 1.6	.9/1.2	3858-54-1.6-PQ-.9/1.2



3858 SANDFLEX® P9000 - PHX			
Inches	mm	Teeth Per Inch	Product Code
2 x .050	54 x 1.3	2/3	3858-54-1.3-PHX-2/3
		3/4	3858-54-1.3-PHX-3/4
2 x .062	54 x 1.6	1/1.4	3858-54-1.6-PHX-1/1.4
		3/4	3858-54-1.6-PHX-3/4
2-5/8 x .062	67 x 1.6	1.4/2	3858-67-1.6-PHX-1.4/2
		.7/1	3858-67-1.6-PHX-.7/1
		1/1.4	3858-67-1.6-PHX-1/1.4
3-1/8 x .062	80 x 1.6	.7/1	3858-80-1.6-PHX-.7/1




3859-EASY-CUT XTREME TRIMETAL

More forgiving than a normal carbide blade,
used in the same way as a Bimetal blade

- More forgiving than a normal carbide blade
- Greatly improved blade life that outperforms regular bimetal in most applications
- Reduce down time with lower number of blade changes
- Reduce blade inventory and carrying costs
- With Easy-Cut Xtreme blade you can cut faster whenever you need to do it
- NO break in – this product comes directly from our factory already honed with a patented edge perpetration; our best multi-application out of the box product yet
- Works on a wide variety of materials including structural and mild steels, stainless steels, cast iron, high temperature alloys, and tool steels.
- Cut "easy to cut" materials and difficult materials with the same blade - no need to change blades

3859- EASY-CUT XTREME TRIMETAL			
Inches	mm	Teeth Per Inch	Product Code
1" x .035	27 x 0.9	3/4	3859-27-0.9-EZX-3/4
		4/6	3859-27-0.9-EZX-4/6
1-1/4" x .042	34 x 1.1	2/3	3859-34-1.1-EZX-2/3
		3/4	3859-34-1.1-EZX-3/4
		4/6	3859-34-1.1-EZX-4/6
1-1/2" x .050	41 x 1.3	1.4/2	3859-41-1.3-EZX-1.4/2
		4/6	3859-41-1.3-EZX-4/6
		2/3	3859-41-1.3-EZX-2/3
		3/4	3859-41-1.3-EZX-3/4
2" x 062	54 x 1.6	1/1.25	3859-54-1.6-EZX-1/1.25
		1.4/2	3859-54-1.6-EZX-1.4/2
		2/3	3859-54-1.6-EZX-2/3
		4/6	3859-54-1.6-EZX-4/6
		3/4	3859-54-1.6-EZX-3/4
2-5/8" x 062	67 x 1.6	.7/1	3859-67-1.6-EZX-.7/1
		1/1.25	3859-67-1.6-EZX-1/1.25
		1.4/2	3859-67-1.6-EZX-1.4/2
		2/3	3859-67-1.6-EZX-2/3
3-1/8" x 062	80 x 1.6	.7/1	3859-80-1.6-EZX-.7/1
		1/1.25	3859-80-1.6-EZX-1/1.25
		1.4/2	3859-80-1.6-EZX-1.4/2

BAHCO Easy-Cut Xtreme TriMetal 3859

EZX - Strong tooth design with a 5° rake angle for cutting easy to cut materials and difficult materials with the same blade - no need to change blades.



3869-CARBIDE TRIPLE SET®

Foundry bandsaw blade for non-ferrous and abrasive materials

Perfect for aluminum, gates and risers, magnesium, zirconium, beryllium, bronze, copper, composites, 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



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.

3869 CARBIDE TRIPLE SET®			
Inches	mm	Teeth Per Inch	Product Code
1/2 x .035	13 x 0.9	3	3869-13-0.9-TS-3
3/4 x .035	20 x 0.9	3	3869-20-0.9-TS-3
		4	3869-20-0.9-TS-4
1 x .035	27 x 0.9	3	3869-27-0.9-TS-3
		4	3869-27-0.9-TS-4
1-1/4 x .042	34 x 1.1	3	3869-34-1.1-TS-3

BALFO Carbide Triple Set® 3869

For a bandsaw blade with many of the same features as the 3869 series but providing a smoother finish, consider the 3860 series

- Multi-Chip Unset tooth design with a rake angle of 10 degrees. Specially designed to cut abrasives and give a smooth finish
- Designed to cut all kinds of materials including Titanium Alloys, Stainless Steel and Aluminum
- Unset teeth provide a superior finish, long life and eliminate additional finishing operations.
- **Additional 3860 sizes available, see page 14**

3860-TC tooth design is a 10° positive rake angle and is used for our unset carbide blade. It excels in difficult to cut alloys on stable machines.

3860 MULTI-CHIP UNSET CARBIDE TIPPED - TC			
Inches	mm	Teeth Per Inch	Product Code
1/2 X .035	13 x 0.9	3	3860-13-0.9-TC-3
		4	3860-13-0.9-TC-4
3/4 X .035	20 x 0.9	3	3860-20-0.9-TC-3
		3/4	3860-20-0.9-TC-3/4
1 x .035	27 x 0.9	3	3860-27-0.9-TC-3
		3/4	3860-27-0.9-TC-3/4
1-1/4 x .042	34 x 1.1	3/4	3860-34-1.1-TC-3/4

BALFO Unset Carbide TC 3860



3863 CARBIDE WOOD CUTTING

Unset Carbide Multichip TCW designed to provide a smooth surface

- High speed cutting and unset teeth provide a superior finish and reduce the time for second operations like sanding
- Tooth designed to remove chips and minimize dust on saw boards
- Log sawing use .8/1 to 1.3 tpi
- Hardwood flooring & furniture use 1.3 to 3 tpi
- Ideal for special wood applications such as cutting hardwood flooring, wood siding, paneling and other millwork applications
- The unset carbide blades are suitable for frozen wood applications



3863 - UNSET CARBIDE MULTICHIP - TCW			
Inches	mm	Teeth Per Inch	Product Code
1/2" x .035	13 x 0.9	2	3863-13-0.9-TCW-2
		3	3863-13-0.9-TCW-3
3/4" x .035	20 x 0.9	3	3863-20-0.9-TCW-3
1 x .035	27 x 0.9	1.3	3863-27-0.9-TCW-1.3
		2/3	3863-27-0.9-TCW-2/3
1-1/4" x .042	34 x 1.1	.8/1	3863-34-1.1-TCW-.8/1
		2/3	3863-34-1.1-TCW-2/3
1-1/2" x .042	41 x 1.1	.8/1	3863-41-1.1-TCW-.8/1
		1.3	3863-41-1.1-TCW-1.3
2 x .035	54 x 0.9	.8/1	3863-54-0.9-TCW-.8/1
		1.3	3863-54-0.9-TCW-1.3
		1.3-W	3863-54-0.9-TCW-1.3-W
2 x .042	54 x 1.1	.8/1	3863-54-1.1-TCW-.8/1
		1.3	3863-54-1.1-TCW-1.3

BAHCO Carbide Multichip Wood 3863

Carbide Triple Set TSW for high efficiency cutting of lumber

- Special grade of carbide tooth material provides maximum life and cutting performance
- The TSW carbide blade is the next level after bimetal, designed and used in the same way as bimetal with a superior cutting life
- Ideal for sawing fir and pine logs



3863 - CARBIDE TRIPLE SET - TSW			
Inches	mm	Teeth Per Inch	Product Code
1-1/4" x .042	34 x 1.1	1	3863-34-1.1-TSW-1
2 x .035	54 x 0.9	1	3863-54-0.9-TSW-1

BAHCO Carbide Triple Set Wood 3863

To avoid injury or chipped teeth, always keep the tooth protector on the blade until it is assembled on the saw.

3868-CARBIDE TRIPLE SET[®] TSS and “XTRA”[™] TSX

TSS (Triple Set Stainless - Honed)

- Patented edge preparation (honed) eliminates the need for break in
- Reduces vibration/extremely low noise level
- Patented ground blade design features a triple chip blade with set teeth
- Provides clearance for good chip removal
- Perfect for cutting, high nickel alloys, stainless steel, abrasive tool steel, abrasive, aerospace alloys.

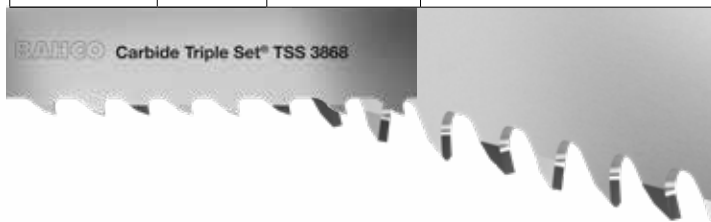
US Patent No. 7,908,954



TSS - This triple chip tooth design has a rake angle of 10° and the patented edge preparation (honed) eliminates the need for break in. Designed to remove the need for running in on the machine allowing full speed, feed operation from the first cut in stainless steel. Not suitable for titanium applications.

3868 CARBIDE TRIPLE SET[®] TSS

Inches	mm	Teeth Per Inch	Product Code
1-1/4 x .042	34 x 1.1	2/3	3868-34-1.1-TSS-2/3
1-1/2 x .050	41 x 1.3	1.4/2	3868-41-1.3-TSS-1.4/2
		2/3	3868-41-1.3-TSS-2/3
2 x .062	54 x 1.6	1.4/2	3868-54-1.6-TSS-1.4/2
		1/1.25	3868-54-1.6-TSS-1/1.25
2-5/8 x .062	67 x 1.6	.7/1	3868-67-1.6-TSS-.7/1
		1.4/2	3868-67-1.6-TSS-1.4/2
		1/1.25	3868-67-1.6-TSS-1/1.25
3-1/8 x .062	80 x 1.6	1.4/2	3868-80-1.6-TSS-1.4/2



TSX (Triple Set Extra)

- Exact same blade as TSS except not honed, perfect for applications where sharp blade is needed.
- Perfect for cutting, titanium alloys, graphite alloy, aluminum with high silicon or matrix alloys.

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.

3868 CARBIDE TRIPLE SET[®] “XTRA”[™] TSX

Inches	mm	Teeth Per Inch	Product Code
1 x 0.35	27 x 0.9	3/4	3868-27-0.9-TSX-3/4
1-1/4 x .042	34 x 1.1	2	3868-34-1.1-TSX-2
		2/3	3868-34-1.1-TSX-2/3
		3/4	3868-34-1.1-TSX-3/4
1-1/2 x .050	41 X 1.3	2	3868-41-1.3-TSX-2 **
		1.4/2	3868-41-1.3-TSX-1.4/2
		2/3	3868-41-1.3-TSX-2/3
		3/4	3868-41-1.3-TSX-3/4
2 x .050	54 x 1.3	1.4/2	3868-54-1.3-TSX-1.4/2
2 x .062	54 x 1.6	1.4/2	3868-54-1.6-TSX-1.4/2
		2	3868-54-1.6-TSX-2
		1/1.25	3868-54-1.6-TSX-1/1.25
		2/3	3868-54-1.6-TSX-2/3
		3/4	3868-54-1.6-TSX-3/4
2-5/8 X .062	67 X 1.6	2/3	3868-67-1.6-TSX-2/3
		1.4/2	3868-67-1.6-TSX-1.4/2
		1/1.25	3868-67-1.6-TSX-1/1.25
		.7/1	3868-67-1.6-TSX-.7/1
3-1/8 x .042	80 x 1.1	3/4	3868-80-1.1-TSX-3/4
3-1/8 x .062	80 x 1.6	3/4	3868-80-1.6-TSX-3/4
		1.4/2	3868-80-1.6-TSX-1.4/2



** Future discontinued, available while supplies last.



3881-CARBIDE TRIPLE SET THQ and THS

THQ (Triple High Quad)

The 3881 Quad grind and set pattern enables cutting of scaled surfaces, improves chip removal and extends blade life.

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
- Tooth chamfers improves the chip removal and extends blade life.
- Reduces tooth strippage on breakthrough
- Tooth chamfers improves chip removal and extends blade life especially in materials with
- Set tooth design eliminates vibration and noise especially on unstable machines

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 smaller chips to reduce cutting forces and increase life. Applications in medium to large size materials with scale.



3881 CARBIDE TRIPLE SET® THQ

Inches	mm	Teeth Per Inch	Product Code
1-1/4 X.042	34 x 1.1	2/3	3881-34-1.1-THQ-2/3
1-1/2 X.050	41 X 1.3	1.4/2	3881-41-1.3-THQ-1.4/2
		2/3	3881-41-1.3-THQ-2/3
2 X.062	54 X 1.6	1.4/2	3881-54-1.6-THQ-1.4/2
		2/3	3881-54-1.6-THQ-2/3
		1/1.25	3881-54-1.6-THQ-1/1.25
2-5/8 x .062	67 x 1.6	1.4/2	3881-67-1.6-THQ-1.4/2
		2/3	3881-67-1.6-THQ-2/3
		1/1.25	3881-67-1.6-THQ-1/1.25
3-1/8 x .062	80 x 1.6	1.4/2	3881-80-1.6-THQ-1.4/2
		2/3	3881-80-1.6-THQ-2/3
		1/1.25	3881-80-1.6-THQ-1/1.25
		.7/1	3881-80-1.6-THQ-.7/1

BAHCO Carbide Multi Set THQ 3881

THS (Triple High Quad - Honed)

The 3881 Quad grind and set pattern enables cutting of scaled surfaces, improves chip removal and extends blade life.

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

- Patented edge preparation (honed) eliminates the need for break in
- Same design as THQ, but with an extremely low noise level.

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



3881 CARBIDE TRIPLE SET® THS

Inches	mm	Teeth Per Inch	Product Code
1-1/4 X.042	34 X 1.1	2/3	3881-34-1.1-THS-2/3
1-1/2 X.050	41 X 1.3	2/3	3881-41-1.3-THS-2/3
		1.4/2	3881-41-1.3-THS-1.4/2
2 X .062	54 X 1.6	2/3	3881-54-1.6-THS-2/3
		1/1.25	3881-54-1.6-THS-1/1.25
		1.4/2	3881-54-1.6-THS-1.4/2
2-5/8 x .062	67 x 1.6	1/1.25	3881-67-1.6-THS-1/1.25
		2/3	3881-67-1.6-THS-2/3
		1.4/2	3881-67-1.6-THS-1.4/2
3-1/8 x .062	80 x 1.6	.7/1	3881-80-1.6-THS-.7/1
		1.4/2	3881-80-1.6-THS-1.4/2
		1/1.25	3881-80-1.6-THS-1/1.25

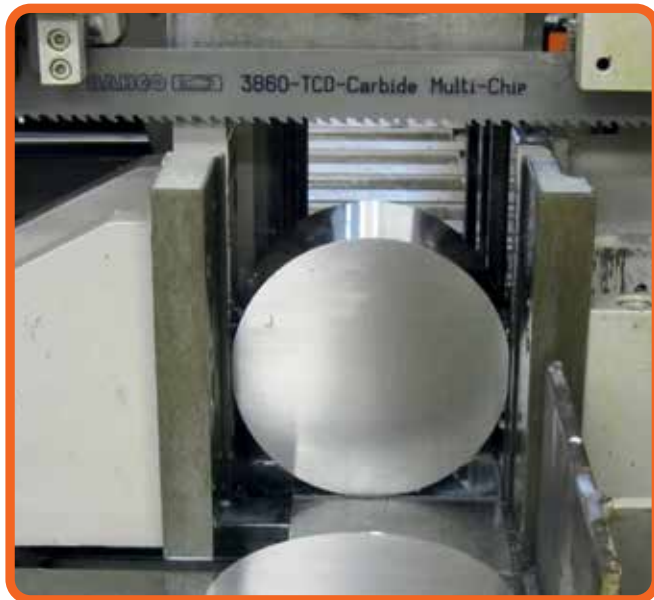
BAHCO Carbide Multi Set THS 3881



3860-MULTI-CHIP UNSET CARBIDE TIPPED TCD and TCL

3860 Multi-Chip Unset Carbide Tipped TCD bandsaw blade for economical high efficiency cutting of difficult and abrasive materials.

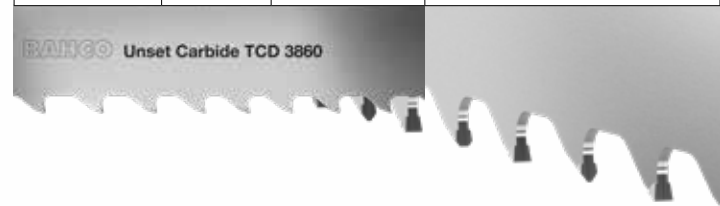
- Multi-Chip Unset tooth design with a rake angle of 10 degrees. Specially designed to cut abrasives and give a smooth finish
- Designed to cut all kinds of materials including Titanium Alloys, Stainless Steel and Aluminum
- Unset teeth provide a superior finish, long life and eliminate additional finishing operations.



3860-TCD - tooth design is a 10° positive rake angle and is used for our unset carbide blade. It excels in difficult to cut alloys on stable machines.

3860 MULTI-CHIP UNSET CARBIDE TIPPED - TCD

Inches	mm	Teeth Per Inch	Product Code
1/2 X .035	13 x 0.9	3	3860-13-0.9-TC-3
		4	3860-13-0.9-TC-4
3/4 X .035	20 x 0.9	3	3860-20-0.9-TC-3
		3/4	3860-20-0.9-TC-3/4
1 x .035	27 x 0.9	3	3860-27-0.9-TC-3
		3/4	3860-27-0.9-TC-3/4
1-1/4 x .042	34 x 1.1	2/3	3860-34-1.1-TCD-2/3
		3/4	3860-34-1.1-TC-3/4
1-1/2 x .050	41 x 1.3	1.9/2.1	3860-41-1.3-TCD-1.9/2.1
		1.4/2	3860-41-1.3-TCD-1.4/2
		2/3	3860-41-1.3-TCD-2/3
		3/4	3860-41-1.3-TCD-3/4
2 x .062	54 x 1.6	1.9/2.1	3860-54-1.6-TCD-1.9/2.1
		1.4/2	3860-54-1.6-TCD-1.4/2
		2/3	3860-54-1.6-TCD-2/3
		3/4	3860-54-1.6-TCD-3/4



3860 Triple-Chip Unset Carbide Tipped TCL developed specifically for cutting large and high temperature alloys.

- High heat resistance allows high speed cutting even in large solids



3860-TCL - tooth design is a 10° positive rake angle and is used for our unset carbide blade. It excels in difficult to cut alloys on stable machines.

3860 TRIPLE-CHIP UNSET CARBIDE TIPPED - TLC

Inches	mm	Teeth Per Inch	Product Code
1-1/2 x .050	41 x 1.3	1.4/2	3860-41-1.3-TCL-1.4/2
		2/3	3860-41-1.3-TCL-2/3
2 x .063	54 x 1.6	1.4/2	3860-54-1.6-TCL-1.4/2
		2/3	3860-54-1.6-TCL-2/3
2-5/8 x .062	67 x 1.6	1.4/2	3860-67-1.6-TCL-1.4/2
		2/3	3860-67-1.6-TCL-2/3
3-1/8 x .062	80 x 1.6	.8/1	3860-80-1.6-TCL-.8/1



3860-MULTI-CHIP UNSET CARBIDE TIPPED TMC and TCZ

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

Performs extremely well cutting Titanium solids and blocks, 718 and other high temperature Alloys and aluminum.

- Special tooth geometry designed for Titanium applications
- Unset teeth provide a superior surface finish, long life and eliminate secondary operations

3860-TMC - tooth design is a 10° positive rake angle and is used for our unset carbide blade. It excels in difficult to cut alloys on stable machines.



3860 MULTI-CHIP UNSET CARBIDE TIPPED - TMC

Inches	mm	Teeth Per Inch	Product Code
1-1/2 x .050	41 x 1.3	1.4/2	3860-41-1.3-TMC-1.4/2
		2/3	3860-41-1.3-TMC-2/3
2 X .062	54 X 1.6	1/1.25	3860-54-1.6-TMC-1/1.25
		1/4.2	3860-54-1.6-TMC-1.4/2
		2/3	3860-54-1.6-TMC-2/3
2-5/8 X .062	67 X 1.6	1/1.25	3860-67-1.6-TMC-1/1.25
		1.4/2	3860-67-1.6-TMC-1.4/2
		2/3	3860-67-1.6-TMC-2/3
3-1/8 X .062	80 X 1.6	.7/1	3860-80-1.6-TMC-.7/1
		1/1.25	3860-80-1.6-TMC-1/1.25
		1.4/2	3860-80-1.6-TMC-1.4/2
4 X .042	100 X 1.1	1.4/2	3860-100-1.1-TMC-1.4/2



3860 Multi-Chip Unset Carbide Tipped TCZ bandsaw blade for high efficiency cutting of hard Chrome Shaft and case hardened or induction hardened materials.

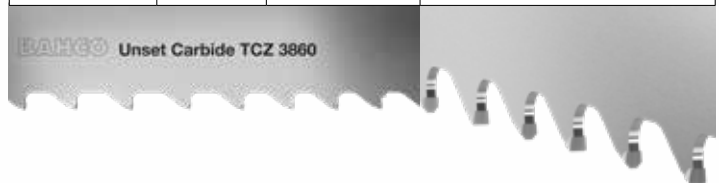
- Special tooth geometry designed for hard chrome bars
- Unset teeth provide a superior surface finish, long life and eliminate secondary operations

3860-TCZ - tooth design is a negative 6° rake angle and is used for our unset carbide blade. It excels in difficult to cut alloys on stable machines.



3860 - MULTI-CHIP UNSET CARBIDE TIPPED - TCZ

Inches	mm	Teeth Per Inch	Product Code
1-1/4 x .042	34 x 1.1	2/3	3860-34-1.1-TCZ-2/3
		3/4	3860-34-1.1-TCZ-3/4
1-1/2 x .050	41 x 1.3	2/3	3860-41-1.3-TCZ-2/3
		3/4	3860-41-1.3-TCZ-3/4



TECHNICAL INFORMATION

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:

• Titanium	=	.00019"
• Inconel	=	.000098"
• Tool Steels	=	.00013"
• Stainless steels	=	.00019"
• Low Alloys/Alloy steel	=	.00031"
• Bronze/Copper/Aluminum	=	.00047"

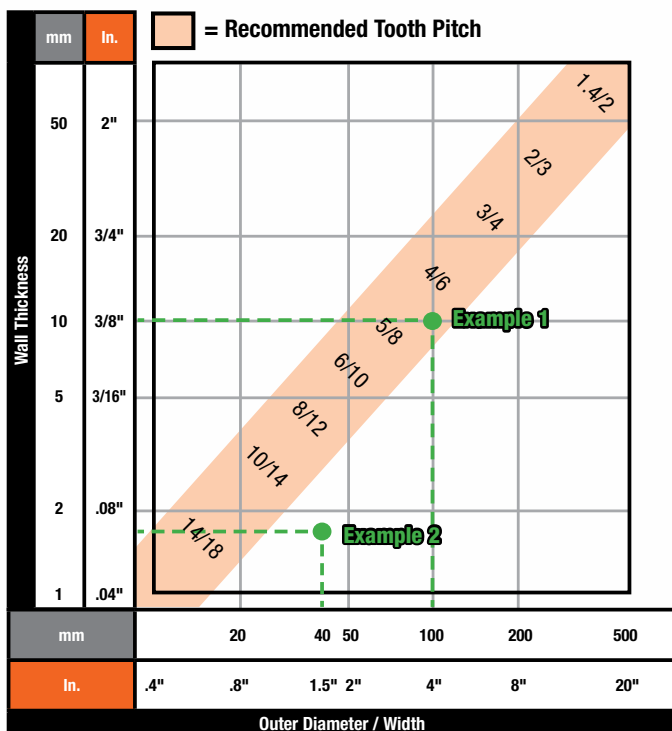
Determine Tooth Pitch Pipes & Profiles

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 1: 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.

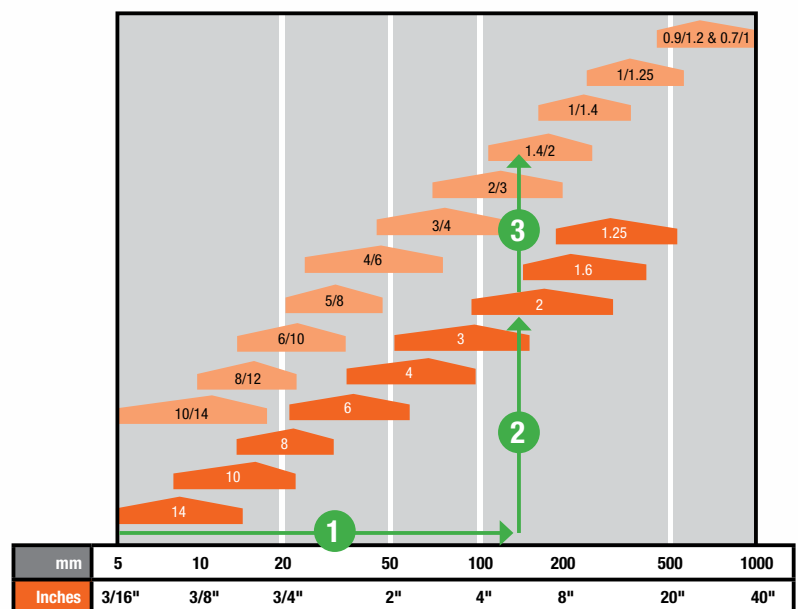


Determine TPI in Solid Work Piece

Example:

You have a work piece 6"

1. Follow the horizontal scale to 150mm
2. Move vertical until you reach the dark orange spots. The **dark orange** gives the TPI for **constant tooth pitch**. You will hit both 3 and 2 TPI, but since the line is passing through the "2 TPI" spot in the wider part, this is our recommendation.
3. If you prefer a blade with **variable tooth pitch** keep moving vertical to meet the **light orange** rectangles. In this case both 2/3 or 1.4/2 can work.



TECHNICAL INFORMATION

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.



TECHNICAL INFORMATION

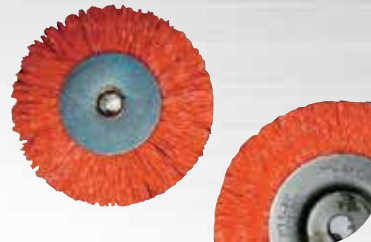
Important Facts		Band breakage	Crooked sawing	Tooth breakage	Rough surface	Rapid tooth wear	Vibration	Band slips on wheel
Machine	Guides and Guidearms You have to check and adjust guides regularly. Check if worn out and replace if necessary. Position guidearms as close to work piece as possible	Guides 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	



Chip Brushes

Used to clean the gullet of the bandsaw blade and are vital for optimum performance.

Product Code	Diameter Width	Bore
CN3	3 - 1/2	1/2 x 3/8
CN4	4 - 1/2	1/2 x 3/8
CN6	6 - 1/2	1/2 x 1/2
3870-BRUSH-60-6	2	1/4
3870-BRUSH-60-6-CHN	2	1/4
3870-BRUSH-80-6	3-1/8	1/4
3870-BRUSH-80-6-CHN	3-1/8	1/4
3870-BRUSH-80-10-CHN	3-1/8	3/8
3870-BRUSH-80-8-CHN	3-1/8	5/16
3870-BRUSH-100-12CHN	4	1/2
3870-BRUSH-100-13CHN	4	1/2
3870-BRUSH-100-10CHN	4	3/8
3870-BRUSH10010HEXCH	4	3/8 EX



3870-Tachometer2

This tool is designed to measure RPM, surface speed and distance, and scale can be changed between metrical to imperial settings.



3870-Tensionmeter

Bahco's tensionmeter is designed for easy, accurate measurement of the blade tension of all bandsaws.



3870-Refractometer

Proper coolant concentration is as important as band speed or feed. It is easily checked with the refractometer.



3870-Wedge-3

A steel wedge, 75 mm (3") long, to help prevent the bandsaw blade from pinching when it is cutting materials that have high stress and tend to close the kerf while cutting.



SINEWAVE®

BAHCO® **SINEWAVE**® provides an aggressive broaching action in the cut that enhances the cutting ability, reduces cut time and increases blade life. It incorporates a series of ramps on the back edge of bandsaw blades, which allows bandsaw machines to exert more force into a cut without increasing machine pressure.

SINEWAVE® rocking motion ensures less tooth contact within the work piece, which increases penetration for faster cutting.

SINEWAVE® ramp depth and length can be engineered to a customer's specific cutting applications, operating parameters and production requirements to optimize performance across a wide variety of materials.

SINEWAVE® can be applied to any Bahco Bimetal or Carbide bandsaw blade. Supplied only in welded-to length bands.



Ideal for cutting work hardening materials:

- High Nickel Alloys
- Rene Type Materials
- Super Alloys
- High Temperature Alloys

BandCalc™

With our patented **Bahco BandCalc**™ that has been exclusively developed by Bahco, you can easily identify the most suitable Bahco bandsaw blade and the best machine parameters to optimize your cutting operation.

BandCalc™ gives you a recommendation by taking into consideration your machine model, the condition of your machine, your requirements and the material as well as the dimension and shape of the work piece to be cut.



GET STARTED!

GO TO: [BANDCALC.BAHCO.COM](https://bandcalc.bahco.com)



**LEARN MORE ABOUT BAHCO
BANDSAW BLADES**

Atlantic Weld Center
19 Bert Collins Drive
Throop, PA 18512

Sales Headquarters
2801 80th Street, Kenosha, WI 53143

USA Customer Service
Toll Free: USA 800-446-7404
Fax: 800-877-5687
Email: bandsaw@snapon.com

Canada Customer Service
195 A Harry Walker Parkway North
Newmarket, ON, L3Y 7B3
Toll Free: 800-296-4787
Fax: 888-447-8665
Email: canadaindustrialbrands@snapon.com