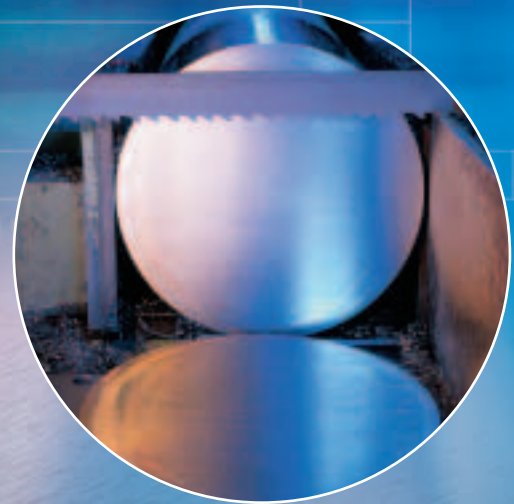
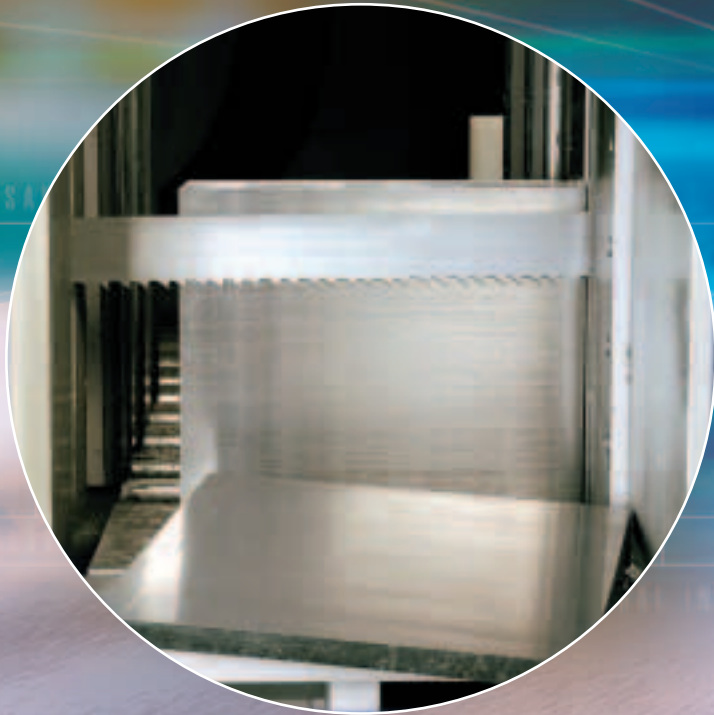


# Industrial Metalsawing

## Bahco Production Cutting Bandsaw Blades



**BAHCO**

**PRODUCTION CUTTING**

# BAHCO GROUND TOOTH TECHNOLOGY

As part of our continuous drive to improve product quality and improve customer efficiency, we have recently invested substantially in the latest ground tooth manufacturing technology. The industry norm has been for many years to mill the teeth, however customer demand and ever-changing applications call for an even better performing production-cutting blade. Ground tooth technology offers benefits not only in tool life, but also in surface finish as the uniform tooth height ensures that the blade slices instead of tears through the material. Ground blades can

also cut a greater range of work piece sizes and shapes than conventional bimetal blades. The advantages don't however stop there; our tests have shown that by using our new ground tooth blades the speed of the cut can also increase dramatically.

The reasons for changing to the new ground tooth are compelling, the right blade choice can result in faster cuts, longer blade life and increased product quality resulting in a much reduced cost per cut and greater cutting efficiency.



## 3854 SANDFLEX® KING COBRA® PHG™

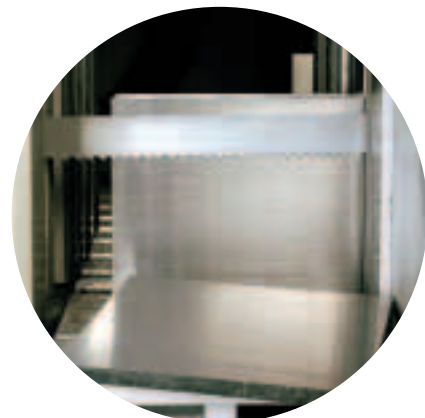
The 3854 PHG blade is ideally suited for high productivity cutting of more difficult-to-cut materials. The patented precision ground tooth design cuts a wide range of hard-to-machine metals, including Inconel 718 and 625, hard Stainless Steels, Tool steels, Mould steels, Zirconium and Titanium. Prolonged tool life is ensured by M42 tooth tips, precise and consistent tooth height and fatigue resistant backing material. The precise set ensures a smooth finish.

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

## 3851 SANDFLEX® COBRA™ PSG™

3851 PSG is the ideal choice for the production cutting of medium to large sections, especially on alloyed and stainless steels. Smooth surface finish is ensured not only by the latest ground tooth technology but also by the precise set. The special combination tooth design and sharp cutting edges allow easy penetration while the HSS M42 tooth tips withstands high heat. The fatigue resistant backing material ensures long tool life. 3851 PSG excels particularly on Stainless Steels (AISI range), Ball Bearing Steels, Alloyed and Tool Steel.

DIMENSIONS MM	DIMENSIONS INCHES	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
27 x 0.9	1 x.035	2/3	Combo PSG	3851-27-0.9-PSG-2/3
		3/4	Combo PSG	3851-27-0.9-PSG-3/4
		4/6	Combo PSG	3851-27-0.9-PSG-4/6
34 x 1.1	1-1/4x.042	2/3	Combo PSG	3851-34-1.1-PSG-2/3
		3/4	Combo PSG	3851-34-1.1-PSG-3/4
		4/6	Combo PSG	3851-34-1.1-PSG-4/6
41 x 1.3	1-1/2x.050	1.4/2	Combo PSG	3851-41-1.3-PSG-1.4/2
		2/3	Combo PSG	3851-41-1.3-PSG-2/3
		3/4	Combo PSG	3851-41-1.3-PSG-3/4
		4/6	Combo PSG	3851-41-1.3-PSG-4/6
54 x 1.3	2x.050	1.4/2	Combo PSG	3851-54-1.3-PSG-1.4/2
54 x 1.6	2x.062	1.4/2	Combo PSG	3851-54-1.6-PSG-1.4/2
		2/3	Combo PSG	3851-54-1.6-PSG-2/3
		3/4	Combo PSG	3851-54-1.6-PSG-3/4
67 x 1.6	2-5/8x.062	2/3	Combo PSG	3851-67-1.6-PSG-2/3
		3/4	Combo PSG	3851-67-1.6-PSG-3/4
		4/6	Combo PSG	3851-67-1.6-PSG-4/6



# BAHCO CARBIDE TIPPED BANDSAW BLADES

Carbide tipped band saw blades are ideal for production cutting of stainless steels and difficult to machine steels, abrasive materials and metals with a high alloy content. Carbide tipped blades also produce a high quality finish, as well as ensuring fast cuts and long tool life.

Carbide tipped band saw blades are produced by welding carbide tips into pockets on the fatigue resistant backing material and then grinding to our patented tooth designs; this provides an ultra hard tooth tip with a reduced risk of tooth stripping producing a high performance bandsaw blade.



## 3868 CARBIDE TRIPLE SET® "XTRA"™

The 3868 Carbide Triple Set "Xtra" is particularly suited for medium to large work pieces and difficult to cut abrasive materials such as stainless steel, titanium alloys and abrasive tool steels. The triple set tooth design with good kerf clearance helps to eliminate tooth loss. The strong set pattern provides good swarf clearance and helps prolong tool life.

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

## 3869 CARBIDE TRIPLE SET®

The 3869 Carbide Triple Set is specifically designed for foundries and non-ferrous and abrasive materials. The special triple set configuration provides fast cutting and easy feeding. The 3869 can be used for both straight and radius cutting.

DIMENSIONS MM	DIMENSIONS INCHES	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
13 x 0.8	1/2x.032	4	TS	<b>3869-13-0.8-TS-4</b>
13 x 0.9	1/2x.035	3	TS	<b>3869-13-0.9-TS-3</b>
20 x 0.9	3/4x.035	3	TS	<b>3869-20-0.9-TS-3</b>
		4	TS	<b>3869-20-0.9-TS-4</b>
27 x 0.9	1x.035	3	TS	<b>3869-27-0.9-TS-3</b>
		4	TS	<b>3869-27-0.9-TS-4</b>
29 x 1.1	1-1/8x.042	2	TS	<b>3869-29-1.1-TS-2</b>
34 x 1.1	1-1/4x.042	3	TS	<b>3869-34-1.1-TS-3</b>



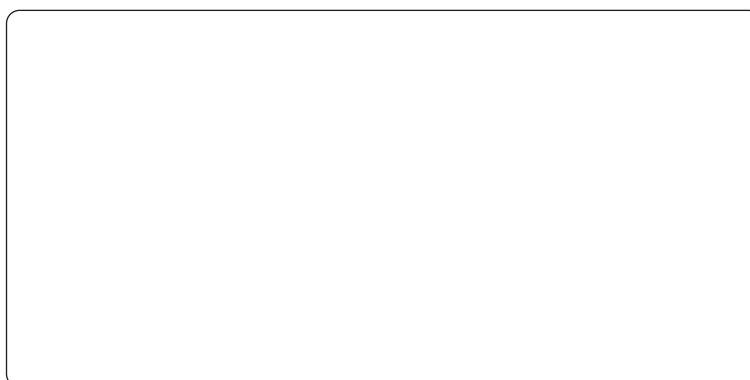
# BandCalc™

BandCalc is a computer software programme that quickly and simply determines the best band saw blade for a specific application. And, having selected the blade, BandCalc will then provide the correct cutting data. It is an excellent tool for users who wish to improve production efficiency.

BandCalc, which is Windows based and available on CD Rom, contains up-to-date information on the entire Bahco band saw assortment, details of over two and a half thousand band saw machines and a database of some 2,700 different materials of international and country standards.

By using these databases and information input by the user, BandCalc will select the best blade and give alternatives for the specific application. It will also supply a cost per cut calculation and accurate cutting data.

BandCalc is available in ten languages: English, Swedish, French, Spanish, German, Dutch, Italian, Finnish, Japanese and Russian.



[www.bahco.com](http://www.bahco.com)

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