
BAHCO
INDUSTRIAL
METALSAWING
BANDSAW BLADES

Welcome to the Bahco Bandsaw Blade Catalog

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

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

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

Table of Contents

GENERAL INFORMATION 3

CARBON

High Hard, Flexback, Friction Cutting 4

BIMETAL

Pallet Dismantler 5
Sandflex® M42 6
3857 Easy Cut® 7
3851 Cobra™ 8-9
3851 Cobra™ PSG (Ground Tooth) 10
3853 TOP Fabricator 11
3854 King Cobra™ PHG MKIII 12
3854 King Cobra™ PHG PQ 13

CARBIDE TIPPED

3860 Multi-Chip Unset Carbide Tipped-TMC 14
3860 Multi-Chip Unset Carbide Tipped-TCZ 15
3868 Carbide Triple Set® TSS (Honed) 16
3868 Carbide Triple Set® "XTRA"™ 17
3881 Carbide Triple Set® THS (Quad Grind-Honed) 18
3881 Carbide Triple Set® THQ (Quad Grind) 19
3869 Carbide Triple Set® 20

Technical Information 21-26
Trouble Shooting Guide 26
Accessories 27

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Precision tools you can rely on:

Quality is our number one priority and we also believe that a key factor in both production cutting and general purpose cutting is product consistency. To achieve this, we operate within Bahco's quality forward system, which uses the ISO 9001-2000 framework. We strive to continually improve our quality management system focusing on customers' needs and satisfaction.



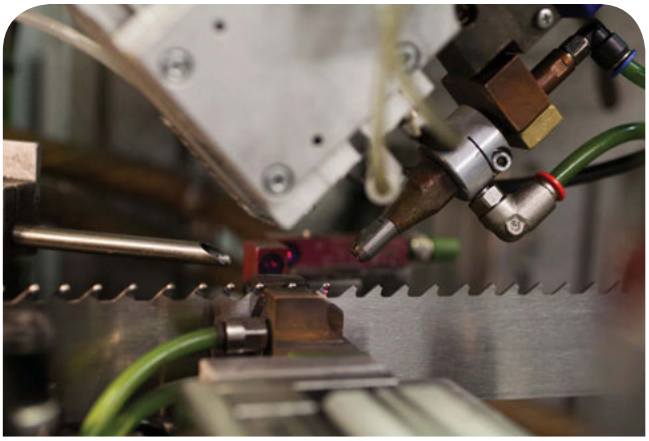
Tooth Forming

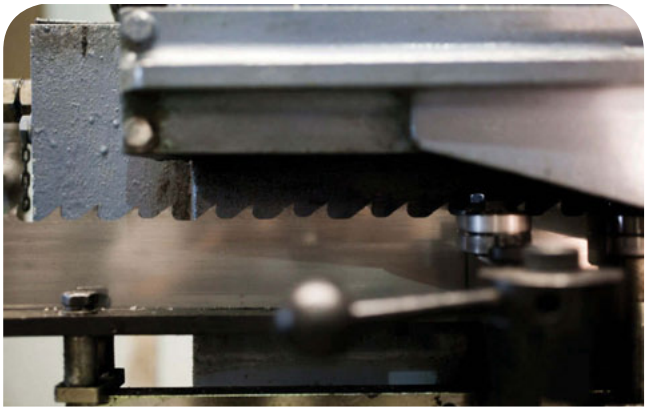
High technology milling and grinding processes are used for precision tooth forming, enabling the production of sharper and stronger teeth.

Carbide Fusion Welding

- High consistancy in carbide tip positioning
- Stong bonding elimnates tooth strippage.

All finished products are deliveried to our highly automated distribution centers.





Setting

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

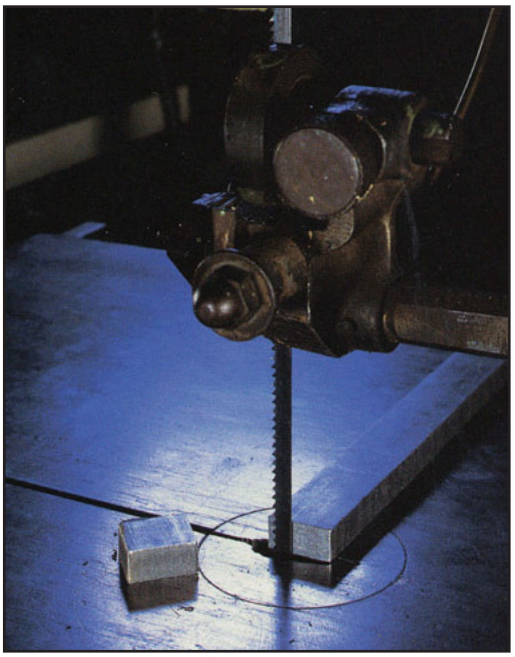
- Measures the set against the permissible tolerance, triggering an automatic shut-off in case of deviation
- Ensures a highly consistent set
- Provides a report card for every coil
- Creates a permanent record in our quality data base

Carbon Steel Blades

For less demanding applications.

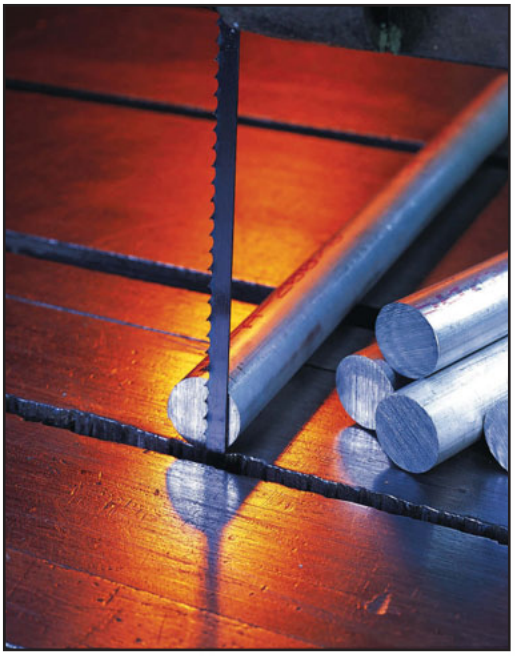
Flexback Carbon Steel Blades - Hook Teeth

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



High Hard Carbon Steel Blades - Regular Teeth

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



Friction Cutting

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

Pallet Dismantler Blade

Designed for the pallet recycling & pallet dismantling industry.

- 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.



Pallet Dismantler			
DIMENSIONS	MM	TEETH	PRODUCT
1-1/4 x .042	34 x 1.1	5/8	3850-34-1.1-5/8-KRON-UB



Pallet Disassembly Saw

WARNING • Wear Safety Goggles (users and bystanders) • Wear hearing protection (users and bystanders) • Avoid prolonged exposure to vibration.

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

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





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

Sandflex® M42

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



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

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

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

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

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

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

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

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

3857-Easy-Cut®

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



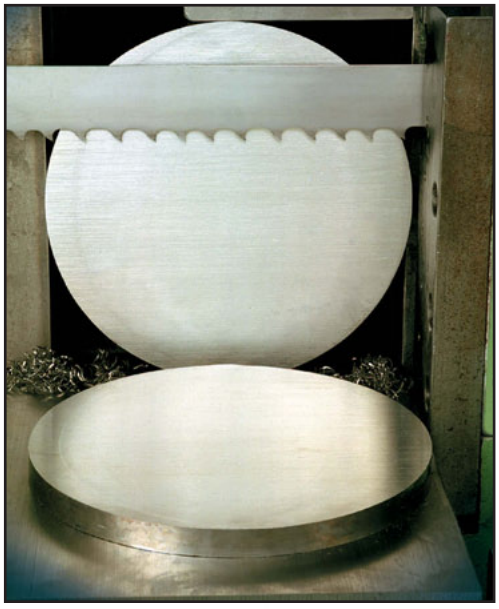
EZ, This patented design gives a very versatile blade, able to cut all common materials in addition to being very resistant to tooth stripping. Ideal for small workshops cutting different sizes in a wide range of materials.

WARNING • Wear Safety Goggles (users and bystanders) • Wear hearing protection (users and bystanders) • Avoid prolonged exposure to vibration.

3851-Cobra™

For high productivity cutting of large or small work pieces and contour cutting.

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





3851-Cobra™

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

3851-Cobra™

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1 x .035	27 x 0.9	5/8	Combo	3851-27-0.9-5/8
1 x .035	27 x 0.9	6/10	Combo	3851-27-0.9-6/10
1 x .035	27 x 0.9	8/12	Combo	3851-27-0.9-8/12
1 x .035	27 x 0.9	10/14	Combo	3851-27-0.9-10/14
1-1/4 x .042	34 x 1.1	2/3	Combo	3851-34-1.1-2/3
1-1/4 x .042	34 x 1.1	3/4	Combo	3851-34-1.1-3/4
1-1/4 x .042	34 x 1.1	4/6	Combo	3851-34-1.1-4/6
1-1/4 x .042	34 x 1.1	5/8	Combo	3851-34-1.1-5/8
1-1/4 x .042	34 x 1.1	6/10	Combo	3851-34-1.1-6/10
1-1/2 x .050	41 X 1.3	2/3	Combo	3851-41-1.3-2/3
1-1/2 x .050	41 X 1.3	3/4	Combo	3851-41-1.3-3/4
1-1/2 x .050	41 X 1.3	4/6	Combo	3851-41-1.3-4/6
1-1/2 x .050	41 X 1.3	5/8	Combo	3851-41-1.3-5/8
1-1/2 x .050	41 X 1.3	1.4/2	Combo PR	3851-41-1.3-1.4/2
2 x .062	54 x 1.6	1.4/2	Combo PR	3851-54-1.6-1.4/2
2 x .062	54 x 1.6	1/1.4	Combo PR	3851-54-1.6-1/1.4
2 x .062	54 x 1.6	2/3	Combo	3851-54-1.6-2/3
2 x .062	54 x 1.6	3/4	Combo	3851-54-1.6-3/4
2-5/8 x .062	67 x 1.6	.7/1	Combo PR	3851-67-1.6-.7/1
3-1/8 x .062	80 x 1.6	.7/1	Combo PR	3851-80-1.6-.7/1
3-1/8 x .062	80 x 1.6	1/1.4	Combo PR	3851-80-1.6-1/1.4
3-1/8 x .062	80 x 1.6	1.4/2	Combo PR	3851-80-1.6-1.4/2



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



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



Combo PR, with a 8-10° rake angle, is mainly used on medium sized to large workpieces when vibration may occur.



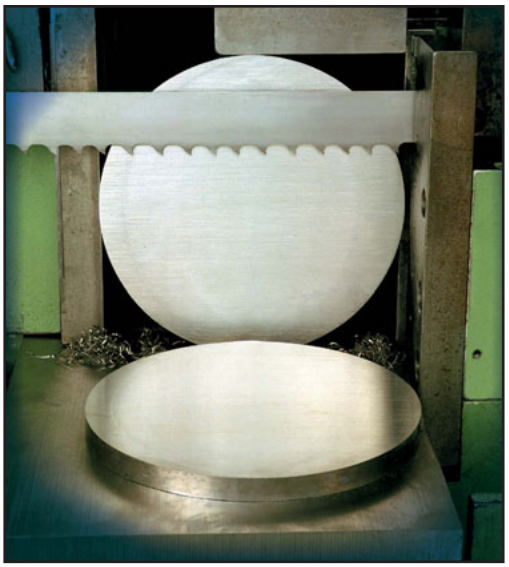
WARNING • Wear Safety Goggles (users and bystanders) • Wear hearing protection (users and bystanders) • Avoid prolonged exposure to vibration.

3851-Cobra™ PSG - Ground Tooth

3851-Cobra™ PSG Ground Tooth Technology

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

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





3851-Cobra™ PSG

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



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

3853-TOP Fabricator

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

*Wide Set–used for heavy structurals to eliminate pinching





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

3853 TOP Fabricator For Tubes Or Profiles

Cuts:

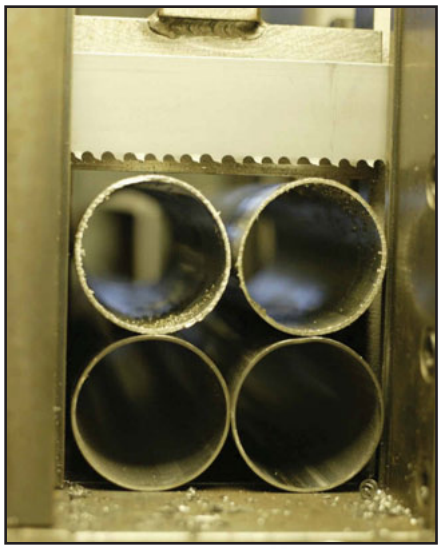
- Channel
- Bundles
- Angle Iron
- I Beam
- H Beam
- Structural Steel
- Square and Round Tubes

Reduces:

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

Features:

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



WARNING • Wear Safety Goggles (users and bystanders) • Wear hearing protection (users and bystanders) • Avoid prolonged exposure to vibration.

3854-KING Cobra™ PHG MKIII

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

- Developed for cutting harder materials.
- Ground tooth for precise and consistent tooth height.
- For high performance cutting of large and difficult to cut work pieces.
- Special design combined with sharp cutting edges for high penetration rate into the work pieces
- Patented set patterns produce a multi chip cutting profile which reduces cutting forces and improves blade life.



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

3854-King Cobra™ PHG MKIII

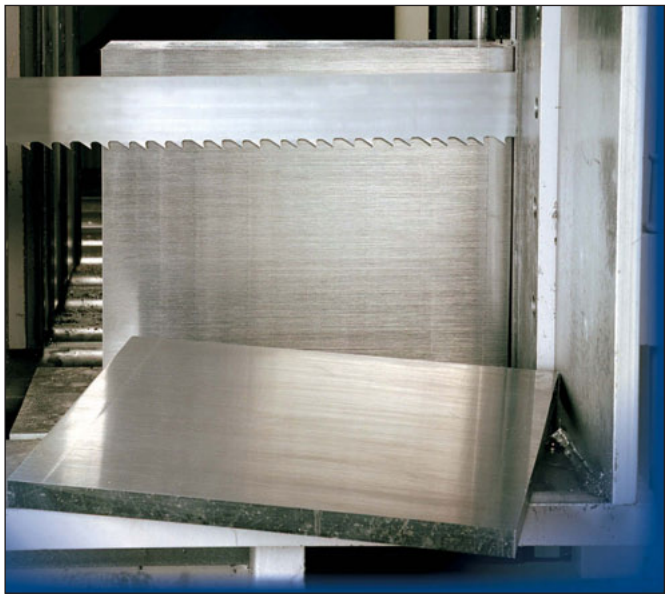
DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1 x .035	27 x 0.9	3/4	PHG	3854-27-0.9-PHG-3/4
1 x .035	27 x 0.9	4/6	PHG	3854-27-0.9-PHG-4/6
1-1/4 x .042	34 x 1.1	1.4/2	PHG	3854-34-1.1-PHG-1.4/2
1-1/4 x .042	34 x 1.1	2/3	PHG	3854-34-1.1-PHG-2/3
1-1/4 x .042	34 x 1.1	3/4	PHG	3854-34-1.1-PHG-3/4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



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

WARNING • Wear Safety Goggles (users and bystanders) • Wear hearing protection (users and bystanders) • Avoid prolonged exposure to vibration.

For difficult to cut materials - multi chip performance



- M42 tooth material provides long life and good resistance to tooth strippage.
- Patented set levels produce a multi chip cutting profile which reduces cutting forces and improves blade life.
  - Inconel
  - Monel
  - Zirconium
  - Titanium
  - Beryllium Copper
  - Stainless Steels
  - Bearing Steels



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

3854-King Cobra™ PQ

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

WARNING • Wear Safety Goggles (users and bystanders) • Wear hearing protection (users and bystanders) • Avoid prolonged exposure to vibration.

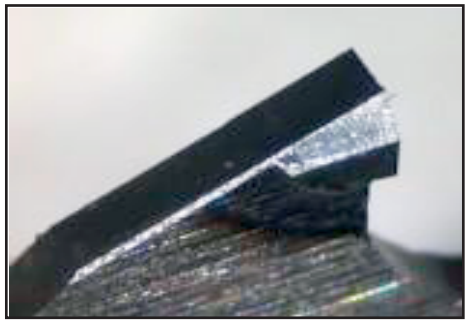
3860 Multi-Chip Unset Carbide Tipped - TMC

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

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

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





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



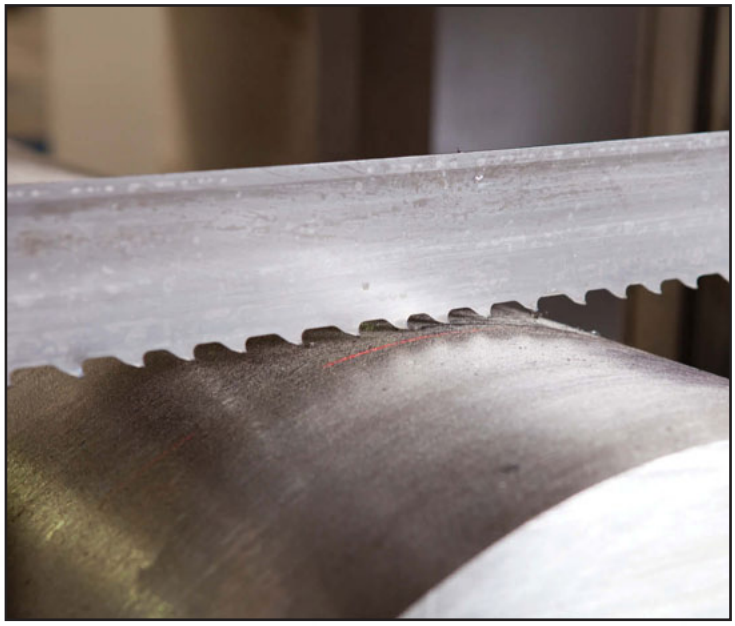
TMC. This tooth design is used for our unset carbide blade. It has a 7 chip design and excels in difficult to cut alloys on stable machines.

3860 - Multi-Chip Unset Carbide Tipped - TMC

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

3860 Multi-Chip Unset Carbide Tipped - TCZ

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



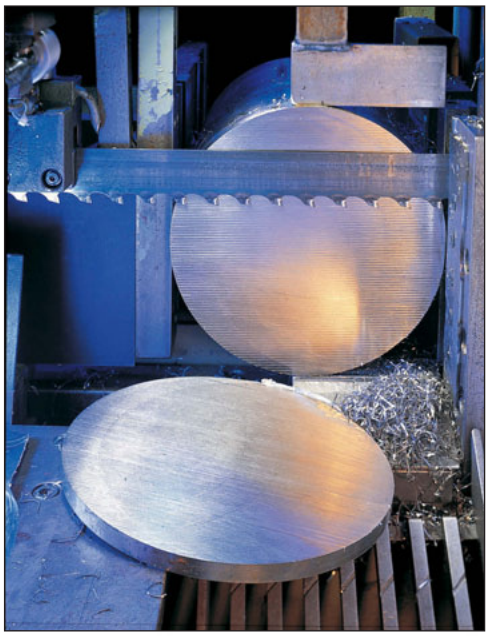
- Special tooth geometry designed for hard chrome bars
- The blade has a 0° rake angle
- Unset teeth provide a superior surface finish, long life and eliminate secondary operations
- Special grade of carbide tooth material provides maximum life and cutting performance
- High heat resistance allows high speed cutting even in large solids

3860 - Multi-Chip Unset Carbide Tipped - TCZ

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1-1/4 x .042	34 x 1.1	2/3	TCZ	3860-34-1.1-TCZ-2/3
1-1/4 x .042	34 x 1.1	3/4	TCZ	3860-34-1.1-TCZ-3/4
1-1/2 x .050	41 x 1.3	2/3	TCZ	3860-41-1.3-TCZ-2/3
1-1/2 x .050	41 x 1.3	3/4	TCZ	3860-41-1.3-TCZ-3/4



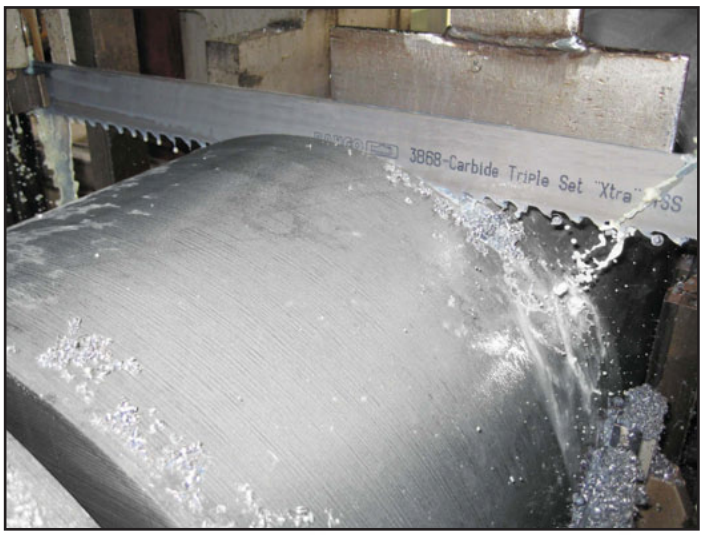
TCZ. This tooth design is used for our unset carbide blade. It has a 7 chip design and excels in difficult to cut alloys on stable machines.



WARNING • Wear Safety Goggles (users and bystanders) • Wear hearing protection (users and bystanders) • Avoid prolonged exposure to vibration.

TSS (Triple Set Stainless - Honed)

- Patented edge preparation (honed) eliminates the need for break in
- Reduces vibration/extremely low noise level
- Designed specifically for production cutting of stainless steels
- The teeth of the 3868 are tipped with a special grade of carbide to cut the most difficult materials.
- Carbide is very tough so the edges can withstand the high impact forces of bandsawing without breaking or chipping.
- Carbide is superior to bimetal blades with higher cutting rates, lower cost per cut and extended tool life.
- Carbide will save you money by cutting material faster and lasting longer than any other bi-metal blade- that is how Bahco reduces your cost per cut.
- Patented ground blade design features a triple chip blade with set teeth.
- Provides clearance for good chip removal
- Perfect for cutting, high nickel alloys, stainless steel, abrasive tool steel, abrasive, aerospace alloys.





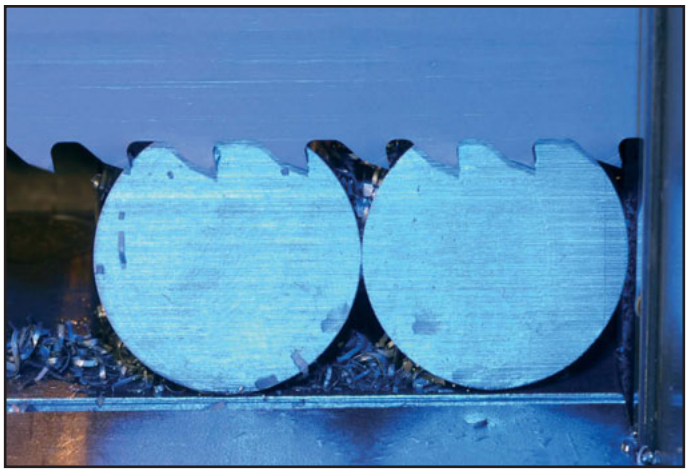
TSS. Same design as TSX, but pre "run in" at the factory. Designed to remove the need for running in on the machine allowing full speed, feed operation from the first cut in stainless steel. This is a unique and patented tooth design. Not suitable for titanium applications.

3868-Carbide Triple Set® TSS

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

TSX (Triple Set Extra)

- For high efficiency cutting of difficult and abrasive materials.
- Triple set tooth design and good kerf clearance help eliminate tooth loss.
- Proven to increase productivity dramatically
- Greatly improved blade life
- 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.



3868-Carbide Triple Set® "Xtra"™ TSX

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1-1/4 x .042	34 x 1.1	2	TSX	3868-34-1.1-TSX-2
1-1/4 x .042	34 x 1.1	2/3	TSX	3868-34-1.1-TSX-2/3
1-1/4 x .042	34 x 1.1	3/4	TSX	3868-34-1.1-TSX-3/4
1-1/2 x .050	41 X 1.3	1.6	TSX	3868-41-1.3-TSX-1.6
1-1/2 x .050	41 X 1.3	2	TSX	3868-41-1.3-TSX-2
1-1/2 x .050	41 X 1.3	1.4/2	TSX	3868-41-1.3-TSX-1.4/2
1-1/2 x .050	41 X 1.3	2/3	TSX	3868-41-1.3-TSX-2/3
1-1/2 x .050	41 X 1.3	3/4	TSX	3868-41-1.3-TSX-3/4
2 x .050	54 x 1.3	1.4/2	TSX	3868-54-1.3-TSX-1.4/2
2 x .062	54 x 1.6	1.4/2	TSX	3868-54-1.6-TSX-1.4/2
2 x .062	54 x 1.6	2	TSX	3868-54-1,6-TSX-2
2 x .062	54 x 1.6	1.6	TSX	3868-54-1.6-TSX-1.6
2 x .062	54 x 1.6	1/1.25	TSX	3868-54-1.6-TSX-1/1.25
2 x .062	54 x 1.6	2/3	TSX	3868-54-1.6-TSX-2/3
2 x .062	54 x 1.6	3/4	TSX	3868-54-1.6-TSX-3/4
2-5/8 x .062	67 x 1.6	2/3	TSX	3868-67-1.6-TSX-2/3
2-5/8 x .062	67 x 1.6	1.4/2	TSX	3868-67-1.6-TSX-1.4/2
2-5/8 x .062	67 x 1.6	1/1.25	TSX	3868-67-1.6-TSX-1/1.25
2-5/8 X .062	67 X 1.6	.7/1	TSX	3868-67-1.6-TSX-.7/1
3-1/8 x .062	80 x 1.6	.7/1	TSX	3868-80-1.6-TSX-.7/1



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

WARNING • Wear Safety Goggles (users and bystanders) • Wear hearing protection (users and bystanders) • Avoid prolonged exposure to vibration.

THS (Triple High Quad - Honed)

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

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

- Patented edge preparation
- Eliminates breaking in
- Reduces tooth strippage on breakthrough
- Same design as THQ, but with an extremely low noise level.
- Not suitable for titanium applications, use 3881 Carbide Triple Set THQ for cutting Titanium. (see page 19)



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





3881-Carbide Triple Set® THS

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

THQ (Triple High Quad)

The 3881 patented Quad grind and set pattern enables cutting of scaled surfaces, improves chip removal and extents 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
- Patented tooth chamfers improves the chip removal and extends blade life.
- Reduces tooth strippage on breakthrough







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

3881-Carbide Triple Set® THQ

DIMENSIONS INCHES	MM	TEETH PER INCH	TOOTH TYPE	PRODUCT CODE
1-1/4 X.042	34 x 1.1	2/3	THQ	3881-34-1.1-THQ-2/3
1-1/2 X.050	41 X 1.3	1.4/2	THQ	3881-41-1.3-THQ-1.4/2
1-1/2 X.050	41 X 1.3	2/3	THQ	3881-41-1.3-THQ-2/3
2 X.062	54 X 1.6	1.4/2	THQ	3881-54-1.6-THQ-1.4/2
2 X.062	54 X 1.6	2/3	THQ	3881-54-1.6-THQ-2/3
2-5/8 x .062	67 x 1.6	1.4/2	THQ	3881-67-1.6-THQ-1.4/2
2-5/8 x .062	67 x 1.6	2/3	THQ	3881-67-1.6-THQ-2/3
3-1/8 x .062	80 x 1.6	1.4/2	THQ	3881-80-1.6-THQ-1.4/2
3-1/8 x .062	80 x 1.6	2/3	THQ	3881-80-1.6-THQ-2/3
3-1/8 x .062	80 x 1.6	1/1.25	THQ	3881-80-1.6-THQ-1/1.25

WARNING • Wear Safety Goggles (users and bystanders) • Wear hearing protection (users and bystanders) • Avoid prolonged exposure to vibration.

3869 Carbide Triple Set®

Foundry bandsaw blade for non-ferrous and abrasive materials

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

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



3869-Carbide Triple Set®

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



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



3870-Bandcalc is an interactive computer software program, available on CD, that quickly determines the best blade for a specific applicaiton, based on the user's requirements, the material to be cut, the machine, workpiece etc.

Simply select the blade, and information on blade speed and fee-rate will be supplied. It is a an excellent tool for anyone looking to improve efficiency. It also calculates the cost per cut for you, taking into consideration all factors, including the machine cost.

Feed Rate/Chips

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

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

1: Start by selecting the correct tooth pitch from the selection charts.

2: Then set your band speed and feed rate according to BANDCALC.

3: Once cutting, you can adjust the feed rate by studying the chips that the saw is producing.

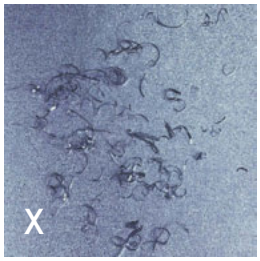
4. Compare them to the diagrams below.

   a. Thin or pulverized chips – increase feed or decrease band speed

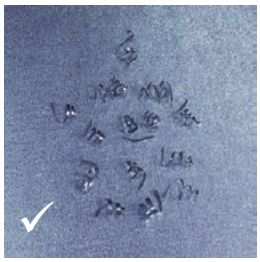
   b. Loosely rolled chips – correct

   c. Thick, heavy, or blue chips – decrease feed rate or increase band speed

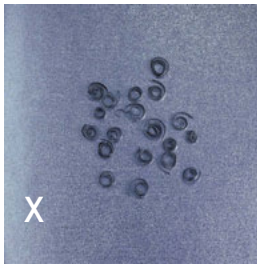
a.



b.



c.



Chip Load Per Tooth Formula

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

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 X 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/Aluminium	=	.00047”



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 %
Veritcal machines, aluminium, aluminium alloys	16405	13124-16405	9843-13124	6562-9843	10 %
Brass	820	820	591-787	459-525	4 %
Copper	787	722	427-623	328-33	15 %

The bigger the size, the lower the speed.

WARNING • Wear Safety Goggles (users and bystanders) • Wear hearing protection (users and bystanders) • Avoid prolonged exposure to vibration.

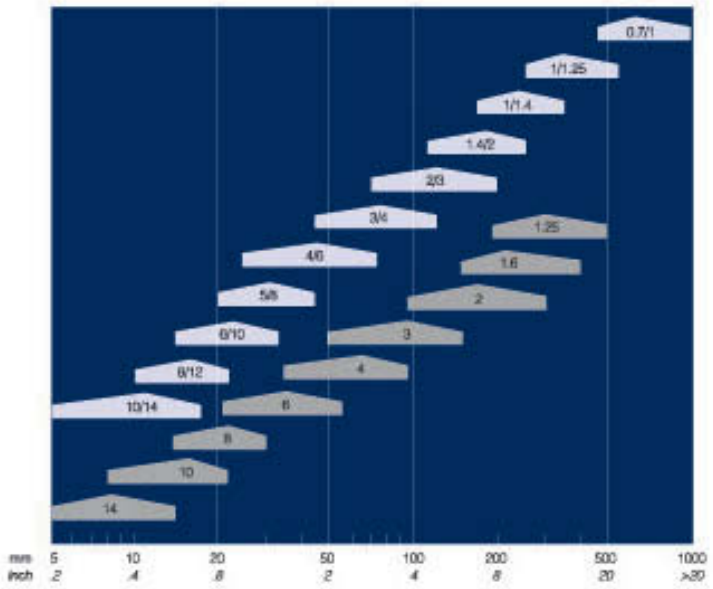
Tooth Pitch Selection Charts

Solid workpieces

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

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

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



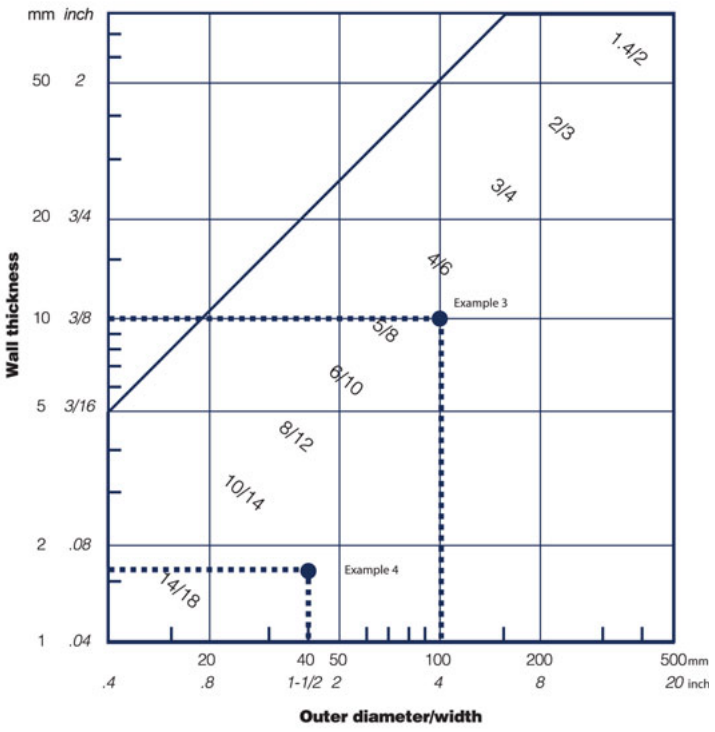
Cutting Pipes and Profiles

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

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

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

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

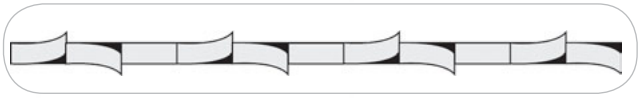


Bandsaw Blade Width

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

Bandsaw Blade Tooth Set

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



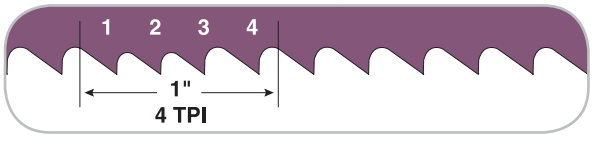
Teeth Per Inch (TPI)

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

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

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

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



Blade Break In - Bimetal

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

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

Blade Break In - Carbide

When breaking in Carbide blades start at normal Bimetal speeds and feeds and work up to nominal chip load. (Refer to page 22).

Do not break-in 3881 THS (see page 18) or 3868 TSS (see page 16), these products are run-in at the factory.

Bandsaw Machine Tips

Check frequently:

- The operation of the chip brush.
- The wear and alignment of the guides.
- The band tension with a tensionmeter (see page 27).
- The band speed with a tachometer (see page 27).
- The coolant concentration with a refractometer (see page 27).

Coolant / Cutting fluid

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

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

Workpiece

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

WARNING • Wear Safety Goggles (users and bystanders) • Wear hearing protection (users and bystanders) • Avoid prolonged exposure to vibration.

Trouble Shooting Guide

	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

Chip brushes are used to clean the gullet of the bandsaw blade and are vital for optimum performance. Made out of strong nylon and available in 6 sizes. Code gives outer and bore diameter in mm.



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	60 mm	6 mm
3870-BRUSH-80-6	80 mm	6 mm
3870-BRUSH-80-8	80 mm	8 mm
3870-BRUSH-80-10	80 mm	10 mm
3870-BRUSH-100-10	100 mm	10 mm
3870-BRUSH-100-12	100 mm	12 mm

Safety Glasses



3870-SG-11



3870-SG-32



3870-SG-22

3870-WEDGES

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.

3870-Tachometer

This computerized bandsaw blade tachometer instantly presents the actual band speed in ft/min, m/min on a LED display.



3870-Tensionmeter

Proper tension is necessary to provide straight cuts and long blade life, thereby reducing the cost per cut.
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.



Gloves

A thin PU material gives user better touch and feel.



Product Code	Size
GL008-10	Medium
GL008-8	Large

Anti-vibration pads on fingers and palms.



Product Code	Size
GL010-10	Medium
GL010-8	Large





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