INDUSTRIAL METALSAWING
BANDSAW BLADES

BAHCO®

LEARN MORE ABOUT BAHCO
BANDSAW BLADES

PALLET DISMANTLER & CARBON STEEL BLADES

Designed for the pallet recycling & pallet dismantling industry.

3850 PALLET DISMANTLER BANDSAW BLADES

Inches	mm	Teeth Per Inch	Product Code
1-1/4 X .042	34 X 1.1	5/8	3850-34-1.1-5/8-KRON-UB
1-1/4 X .042	34 X 1.1	5/8	M42-34-1.1-5/8-UB

- 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 SAW BLADES

Inches	mm	Teeth Per Inch	Product Code
7-1/2	190	10/14	384019010/14PRRU09CP

- Virtually unbreakable Sandflex® bimetal blade.
- 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

For less demanding applications.

3849 FLEXBACK CARBON STEEL BLADES*

Inches	mm	Teeth Per Inch	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
3/8 x .032	10 x 0.8	3	3849-10-0.8-H-3
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

* Hook Tooth Type

3847 HIGH HARD CARBON STEEL BLADES**

Inches	mm	Teeth Per Inch	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

** Regular Tooth Type

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.

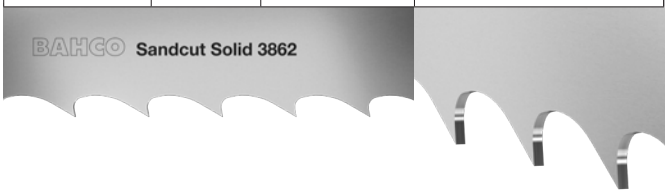
3861 SANDCUT® BIMETAL

Inches	mm	Teeth Per Inch	Product Code
1 x .035	27 x 0.9	1.33	3861-27-0.9-H-1.33
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

- 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



- 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
		6/10	M42-34-1.1-6/10
1-1/2 x .050	41 x 1.3	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
		6/10	M42-41-1.3-6/10
2 x .062	54 x 1.6	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.

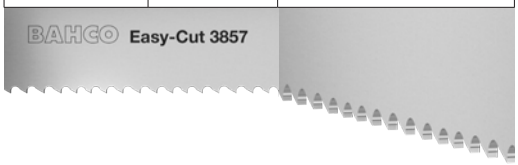
Bahco's perfect "recipe" combines the science of rake angle, unique patented tooth geometry & M42 high speed steel material to produce the tough, resilient and versatile Easy-Cut® blade.

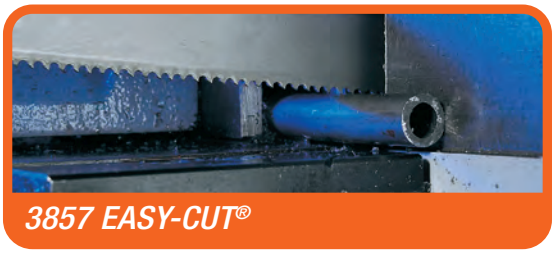
Medium Tooth - This patented design gives a very versatile blade, able to cut all common materials in addition to being very resistant to tooth stripping. Ideal for small workshops cutting different sizes in a wide range of materials.

- 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 .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
1¼ x .042	34 x 1.1	3857-34-1.1-EZ-M



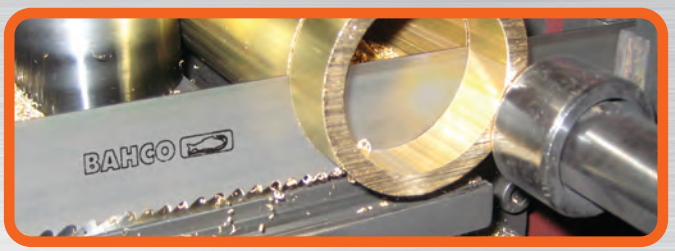


3857 EASY-CUT®

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
		4/6	3851-80-1.6-4/6

BAHCO Sandflex® Cobra™ 3851

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 gives 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 gives 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.

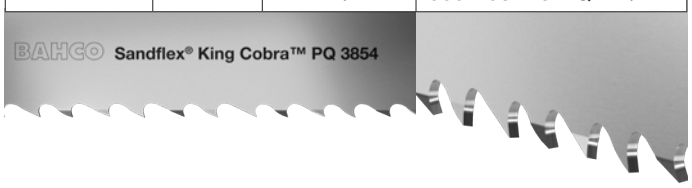
Positive Quad PQ - Very aggressive 17° positive patented tooth design intended to give good penetration on difficult to cut material such as stainless steels, bearing steels, tool steels and special alloys with work hardening properties.

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
1-1/2 x .050	41 X 1.3	2/3	3854-41-1.3-PQ-2/3
		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 x .062	54 x 1.6	2/3	3854-54-1.6-PQ-2/3
		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
2-5/8 x .062	67 x 1.6	2/3	3854-67-1.6-PQ-2/3
		.9/1.2	3854-67-1.6-PQ-.9/1.2
		1.4/2	3854-67-1.6-PQ-1.4/2
3-1/8 x .062	80 x 1.6	3/4	3854-80-1.6-PQ-3/4
		.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

3853 TOP FABRICATOR

ACCESSORIES

Scan the QR Code above to view all Bandsaw Accessories

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:

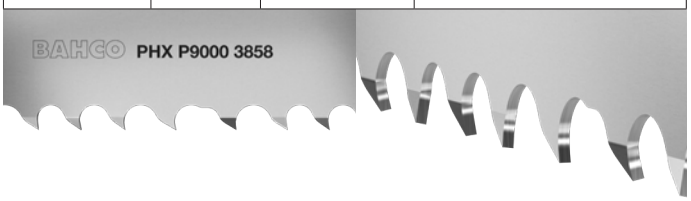
- Tool Steel
- Inconel
- Monel
- Zirconium
- Titanium
- Stainless Steel

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

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	1.4/2	3858-80-1.6-PHX-1.4/2
		.7/1	3858-80-1.6-PHX-.7/1



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

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

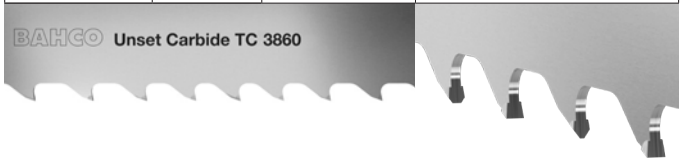
For a bandsaw blade with many of the same features as the 3869 series but providing a smoother finish, consider the 3860 series

- 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 13**

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
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



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
		2/3	3868-54-1.6-TSS-2/3
		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
		2/3	3868-67-1.6-TSS-2/3
3-1/8 x .062	80 x 1.6	.7/1	3868-80-1.6-TSS-.7/1
		1.4/2	3868-80-1.6-TSS-1.4/2
		2/3	3868-80-1.6-TSS-2/3

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	1.6	3868-41-1.3-TSX-1.6
		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
		1.6	3868-54-1.6-TSX-1.6
		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
		.7/1	3868-80-1.6-TSX-.7/1
		1/1.25	3868-80-1.6-TSX-1/1.25
		1.4/2	3868-80-1.6-TSX-1.4/2

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 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
- 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

THS (Triple High Quad - Honed)

The 3881 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 (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.

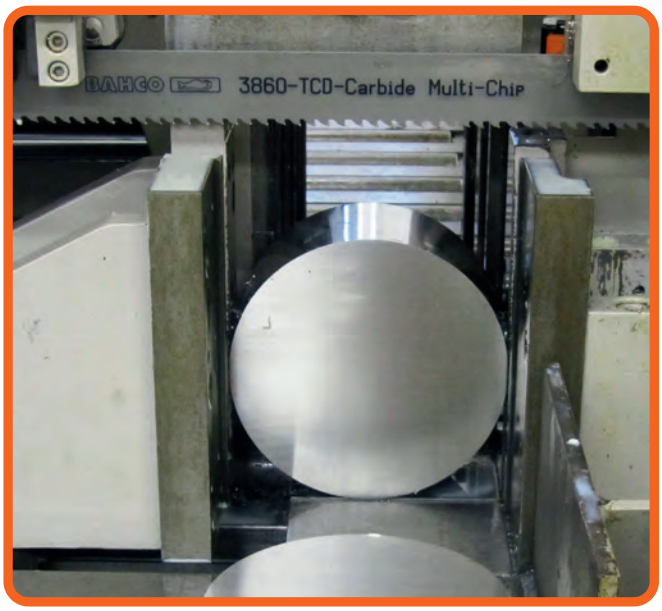
3881 CARBIDE TRIPLE SET® THS

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
		2/3	3881-80-1.6-THS-2/3
		1/1.25	3881-80-1.6-THS-1/1.25

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
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
2-5/8 x .062	67 x 1.6	1/1.25	3860-67-1.6-TCD-1/1.25
		1.4/2	3860-67-1.6-TCD-1.4/2

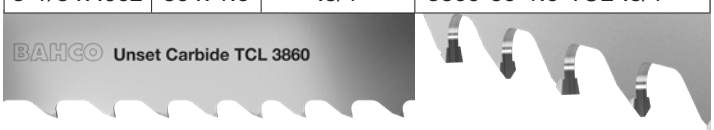
3860 Triple-Chip Unset Carbide Tipped TCL developed specifically for cutting large and high temperature alloys.

- 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 .042	80 X 1.1	1.4/2	3860-80-1.1-TMC-1.4/2
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
		2/3	3860-80-1.6-TMC-2/3
4 X .042	100 X 1.1	1.4/2	3860-100-1.1-TMC-1.4/2

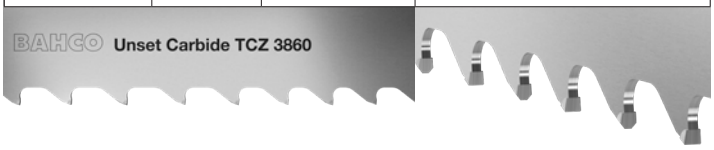
3860 Multi-Chip Unset Carbide Tipped TCZ bandsaw blade for high efficiency cutting of hard Chrome Shaft and case hardened or induction hardened materials.

- 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 x .035	27 x 0.9	3/4	3860-27-0.9-TCZ-3/4
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



Chip Load Per Tooth Formula

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

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/Aluminum	=	.00047"

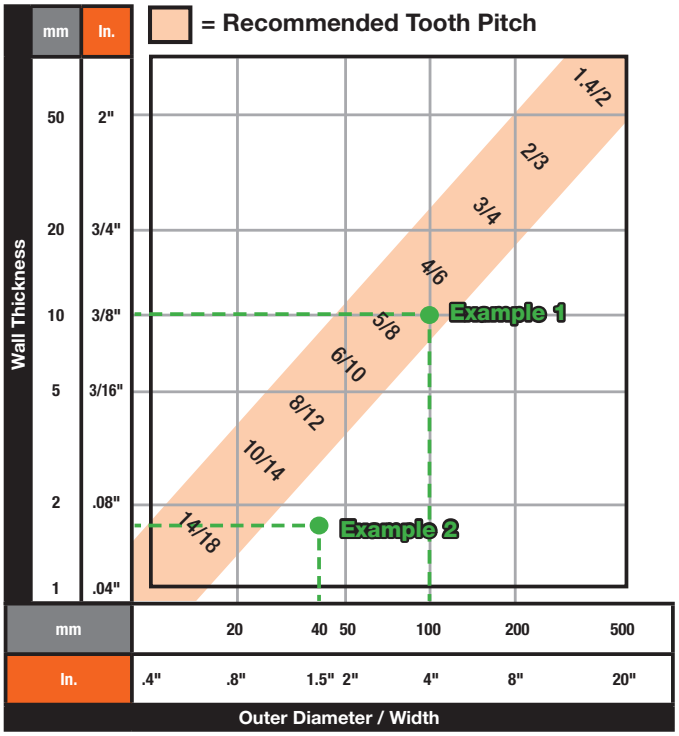
Determine Tooth Pitch Pipes & Profiles

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 with 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

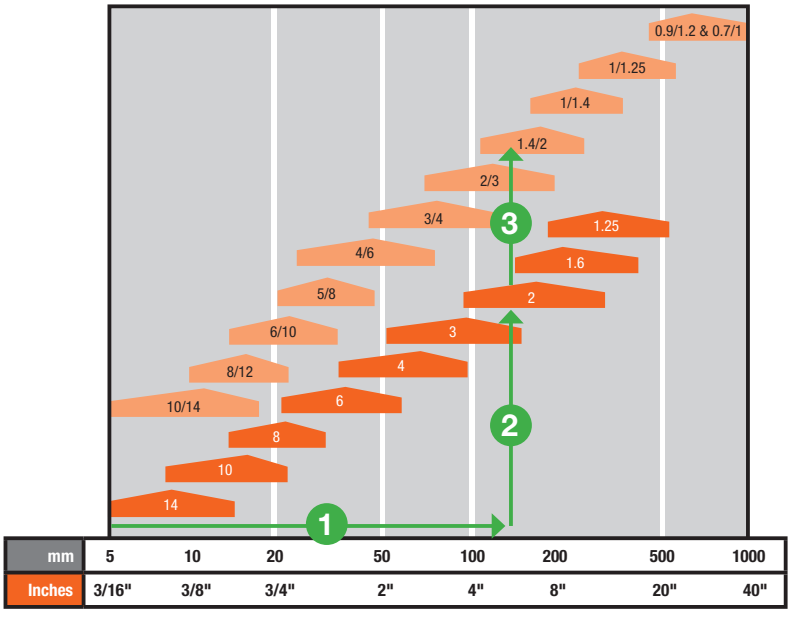
Example:

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.



WBB-WAVY BANDSAW BLADE

Designed and engineered for the toughest cutting applications.

- Perfect for cutting larger cross sections of heat resistant alloys
- The WBB - Wavy Bandsaw Blade is a customized blade specific for your cutting applications
- The WBB - Wavy Bandsaw Blade concept can be applied to any Bahco Bimetal or Carbide Bandsaw Blade
- Faster cutting rate
- Longer blade life
- Straighter more accurate cutting
- Reduces the risk of permature blade failure due to heat build up
- Ideal for cutting work hardening materials
  - High Nickel Alloys
  - Rene Type Materials
  - Super Alloys

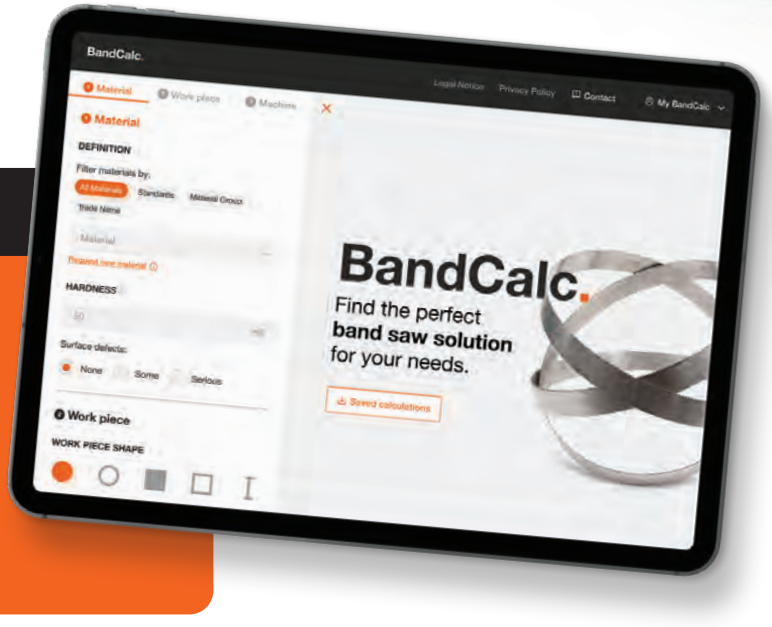
Bahco's Bandsaw Technical Representatives will work to ensure that the WBB - Wavy Bandsaw Blade will meet or exceed the most complex cutting.

US Patent No. 9,731,366

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.



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