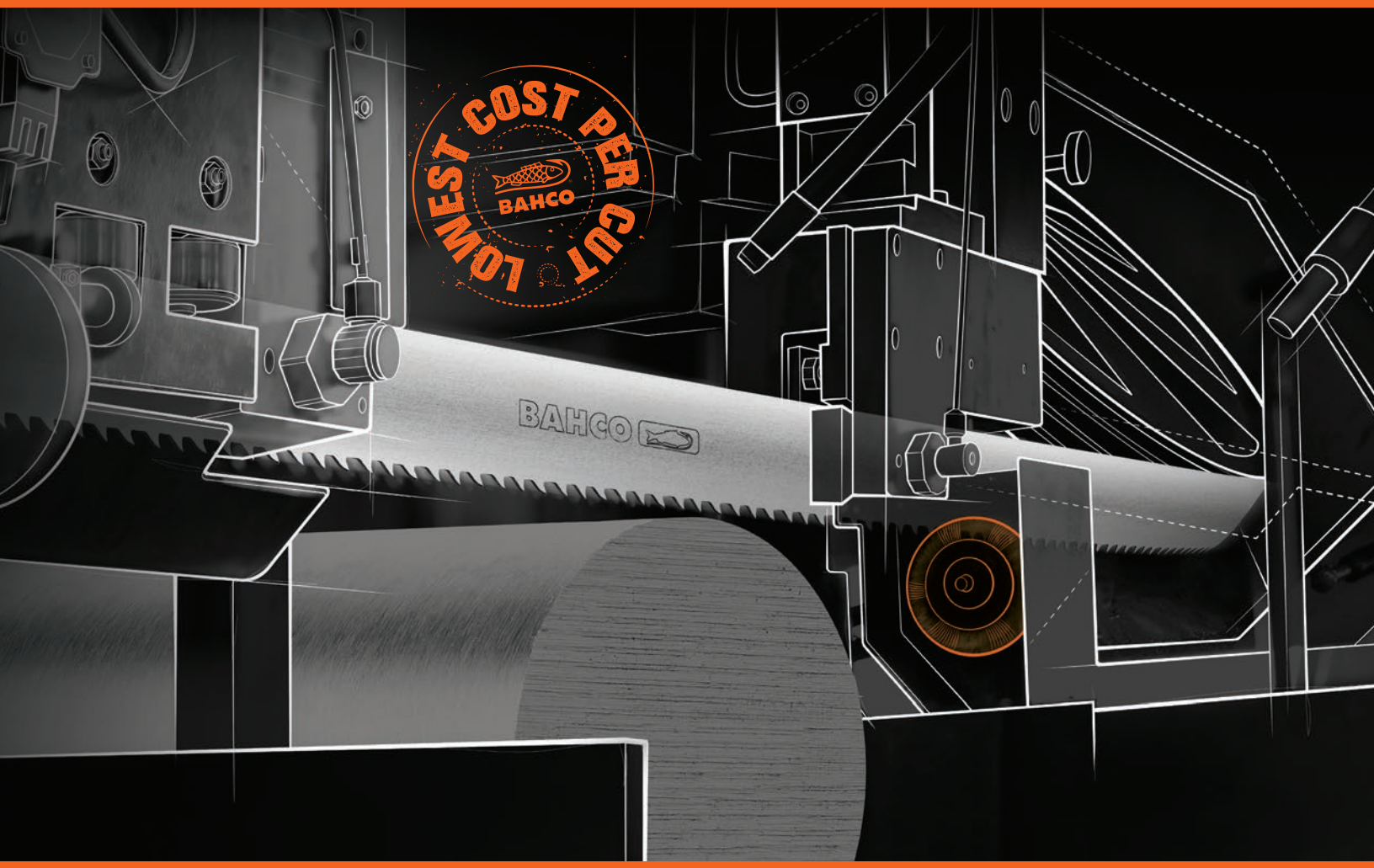
BAHCO®



INDUSTRIAL METALSAWING BANDSAW BLADES

A WIDE RANGE OF CUTTING SOLUTIONS

Bahco Bandsaw Blades For Professionals.

Precison tools you can rely on.

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 3868 TSX. 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 take a Rapid Continuous Improvement (RCI) approach to our production processes, which reflects in the quality and performance of our product.

About Bahco

Over 130 years of leading the way...

In 1886, our iconic brand was born, Today, it is still a symbol of quality.

Bahco, inventor of the original adjustable wrenches and a leader in ergonomic hand tools and cutting tools, has delivered innovative products and solutions since 1886. Bahco products are designed for professionals of various industries, such as aviation, oil & gas, metal cutting, building and construction, automotive, landscaping and vineyards. The vast majority of Bahco products are manufactured in our own factories located throughout Europe.

GÖRAN FREDRIK GÖRANSSON

founded Högbo Stål and Jernwerks AB in Sweden to produce the highest quality steel, pioneering the Bessemer process and unknowingly laying the groundwork for our first saw blade.

Why do Bahco products carry a fish and a hook?

After Bahco's founder, Göran Fredrik Göransson had established his steel mill in 1862, the European steel industry in the eighteen seventies had a long depression with low prices for general steel and crude steel products. The prices for processed steel were much better, which created an interest in processing the steel further. In 1876 the existing steel rolling mill was changed to produce so-called milled steel.

When the production of saw blades commenced in 1886 there was a need for a brand, which could communicate the blades' special properties and quality, and the choice was - quite naturally - the fish and hook.

Everybody understood that steel with a quality for fishing hooks was perfect for saws and other cutting tools as well. It was a great advantage, a brand logo not including letters, language or sophisticated figures making it a symbol easy to recognize. As late as the nineteen fifties, one could still hear boreal forest workers asking for a saw "with the little fish"; as is still the case today in countries with developing literacy rates.

A fishing hook must be hard and strong, but absolutely not brittle. At that time producing the combination "hard but tough" was an inconsistent and thorny metallurgic task, but the "Bessemer steel" from Göransson's steel mill delivered optimal quality.

1886

1916

Today

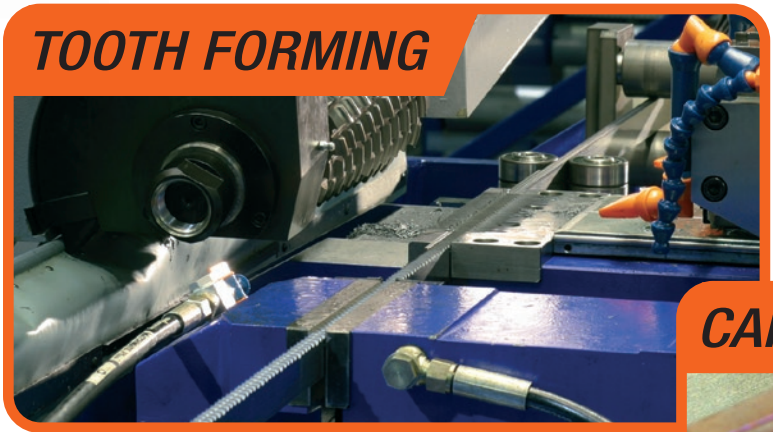
BAHCO

QUALITY IS OUR NUMBER ONE PRIORITY

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. We take a Rapid Continuous Improvement (RCI) approach to our production processes, which reflects in the quality and performance of our product. We strive to continually improve our quality management system focusing on customers' needs and satisfaction.

TOOTH FORMING



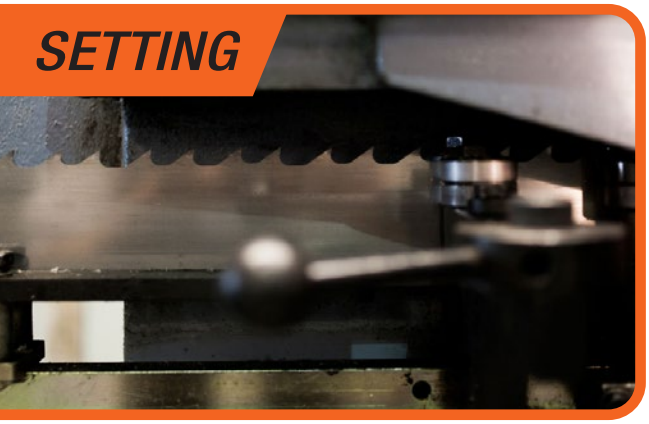
High technology milling and grinding processes are used for precision tooth forming, enabling the production of sharper and stronger teeth.

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

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

CARBIDE FUSION WELDING

SETTING



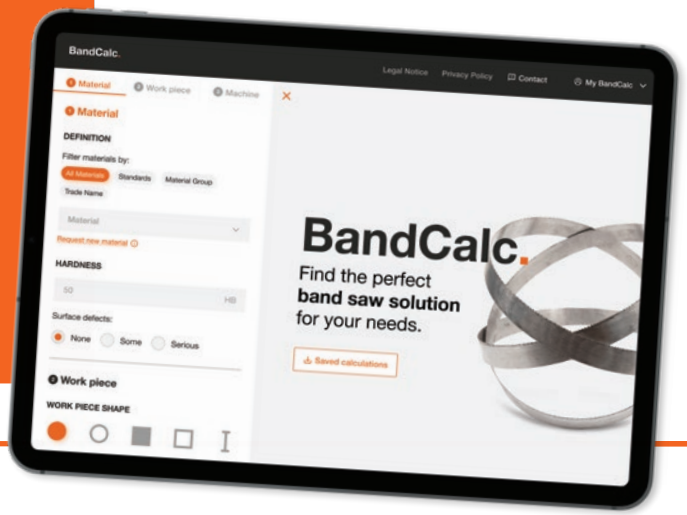
Computer controlled measuring devices and camera monitoring systems check every tooth. This information is collated and displayed on a monitor which:

- 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

COMING IN Q1 OF 2021

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.



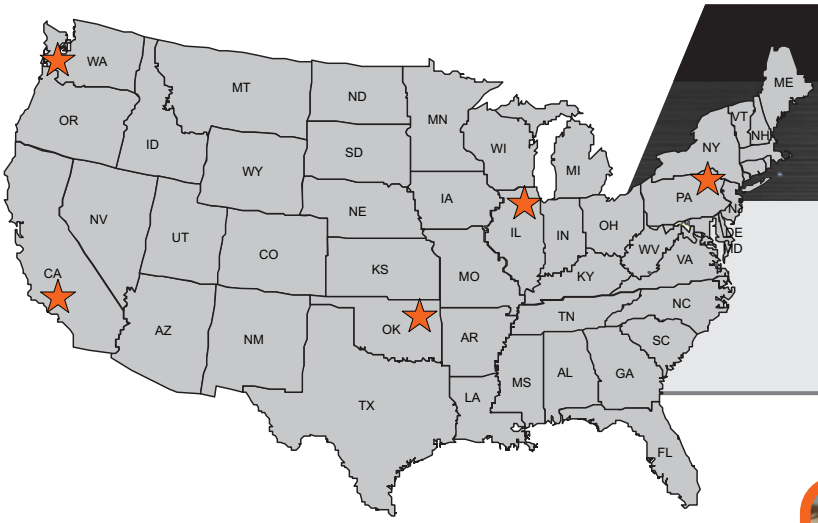
WARNING Wear Safety Goggles (users and bystanders) Wear hearing protection (users and bystanders) Avoid prolonged exposure to vibration.

Bandsaw Technical Representatives

To provide the best support in our markets and accomplish the lowest cost per cut for our all customers we have our specialists across the globe. These specialists are trained in finding the best possible solution for each application in any specific case. They will help you to reach your target and find the right balance between quality performance and cost efficiency.

Quality Products

Continuous improvement and investment in research and development has led to innovative, high-performance products for general-purpose and production cutting applications. We offer many patented products and features, from our unique Easy Cut design which simplifies complex blade selection, to the latest 'set' and 'unset' high performance carbide blades for the most demanding and complex cutting applications – such as commercial and military aerospace, power generation and other high-technology industries.



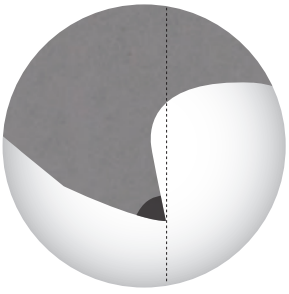
WELD CENTERS

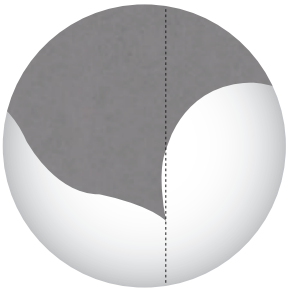
We have strategically positioned our weld centers globally to offer our customers a reliable and fast delivery service.

Our weld centers feature:

- High technology welding machines and annealing control
- Automatic weld grinding equipment
- Quality laboratory

R&D





Carbide Blades

Top Fabricator

We believe that research and development is fundamental to our goal to maintain our leadership position in the development of new bandsaw technology for the increasing demands presented by machine manufacturers, material producers and designers of more and more complex engineering projects.

WBB - WAVY BANDSAW BLADE

Designed and engineered for the toughest cutting applications.

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

- Increase your productivity with Bahco's Patented WBB - Wavy Bandsaw Blade
- Perfect for cutting larger cross sections of heat resistant alloys
- WBB - Wavy Bandsaw Blade will save you money by cutting materials faster and lasting longer
- 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

US Patent No. 9,731,366

CONFIGURE YOUR WBB

To configure your WBB - Wavy Bandsaw Blade, contact your Bahco Technical Representative or call Customer Service at 1-800-446-7404 or email bandsaw@snapon.com

CARBON STEEL BLADES

For less demanding applications.

3849 FLEXBACK CARBON STEEL BLADES				
Inches	**mm**	**Teeth Per Inch**	**Tooth Type**	**Product Code**
1/4 x .025	6 x 0.6	4	Hook	3849-6-0.6-H-4
		6	Hook	3849-6-0.6-H-6
3/8 x .025	10 x 0.6	3	Hook	3849-10-0.6-H-3
		4	Hook	3849-10-0.6-H-4
		6	Hook	3849-10-0.6-H-6
3/8 x .032	10 x 0.8	3	Hook	3849-10-0.8-H-3
1/2 x .025	13 x 0.6	3	Hook	3849-13-0.6-H-3
		4	Hook	3849-13-0.6-H-4
		6	Hook	3849-13-0.6-H-6
3/4 x .032	20 x 0.8	3	Hook	3849-20-0.8-H-3
		6	Hook	3849-20-0.8-H-6
1 x 035	25 x 0.9	2	Hook	3849-25-0.9-H-2
		3	Hook	3849-25-0.9-H-3
3847 HIGH HARD CARBON STEEL BLADES				
1/4 x .025	6 x 0.6	10	Regular	3847-6-0.6-R-10
		14	Regular	3847-6-0.6-R-14
		18	Regular	3847-6-0.6-R-18
		24	Regular	3847-6-0.6-R-24
3/8 x .025	10 x 0.6	10	Regular	3847-10-0.6-R-10
		14	Regular	3847-10-0.6-R-14
		8	Regular	3847-10-0.6-R-8
1/2 x .025	13 x 0.6	10	Regular	3847-13-0.6-R-10
		14	Regular	3847-13-0.6-R-14
		18	Regular	3847-13-0.6-R-18
		24	Regular	3847-13-0.6-R-24
		6	Regular	3847-13-0.6-R-6
3/4 x .032	20 x 0.8	10	Regular	3847-20-0.8-R-10
		14	Regular	3847-20-0.8-R-14
		18	Regular	3847-20-0.8-R-18
		6	Regular	3847-20-0.8-R-6
		8	Regular	3847-20-0.8-R-8
1 x .035	25 x 0.9	10	Regular	3847-25-0.9-R-10
		14	Regular	3847-25-0.9-R-14
		6	Regular	3847-25-0.9-R-6
		8	Regular	3847-25-0.9-R-8
3841 FRICTION				
1 x .035	25 x 0.9	10	Regular	3841-25-0.9-R-10

PALLET DISMANTLER BLADES

Designed for the pallet recycling & pallet dismantling industry.

3850 PALLET DISMANTLER 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.

3940 PALLET RECIPROCATING SAW BLADES				
Inches	**mm**	**Teeth Per Inch**	**Blades Per Pack**	**Product Code**
9 x .035	228 x 0.9	10/14	100	3940-228-10/14-PR09-100P
9 x .035	228 x 0.9	10/14	10	3940-228-10/14-PR09-10P
9 x .050	228 x 1.3	10/14	100	3940-228-10/14-PR13-100P
9 x .050	228 x 1.3	10/14	100	3940-228-8/12-PR13-100P

- Virtually unbreakable Sandflex® bi-metal blade for all materials and type of cut
- This toothing has good material removal rate in wood with nails and high strength to tooth breakage
- The unique front design prevents the blade front to get stuck in close by wood beams, when cutting nails in damaged parts of the pallet
- Designed for use by the pallet repair business

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

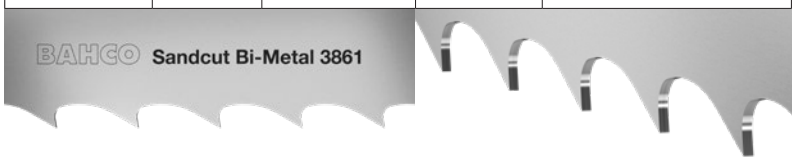
3861 & 3862 - WOODCUTTING

Common features for 3861 & 3862 blades:

- Blades can be re-sharpened
- Fatigue resistant spring steel saw blade backing material made from D6A alloyed steel (Hard-ness 44-46 HRC)
- Full “In line” heat treatment process guarantees straightness and the highest quality finish to our product

3861 SANDCUT® BIMETAL

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



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

- High hardness tooth compared to Carbon equivalent by using bi-metal technology – High speed steel tooth using M2 tool steel (Hardness 66-67 HRC)
- This bi-metal combination offers very high resistance to fatigue from high speed operation in this type of application and the M2 tool steel tooth gives superior extended hardness when compared to a Carbon tooth.
- 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

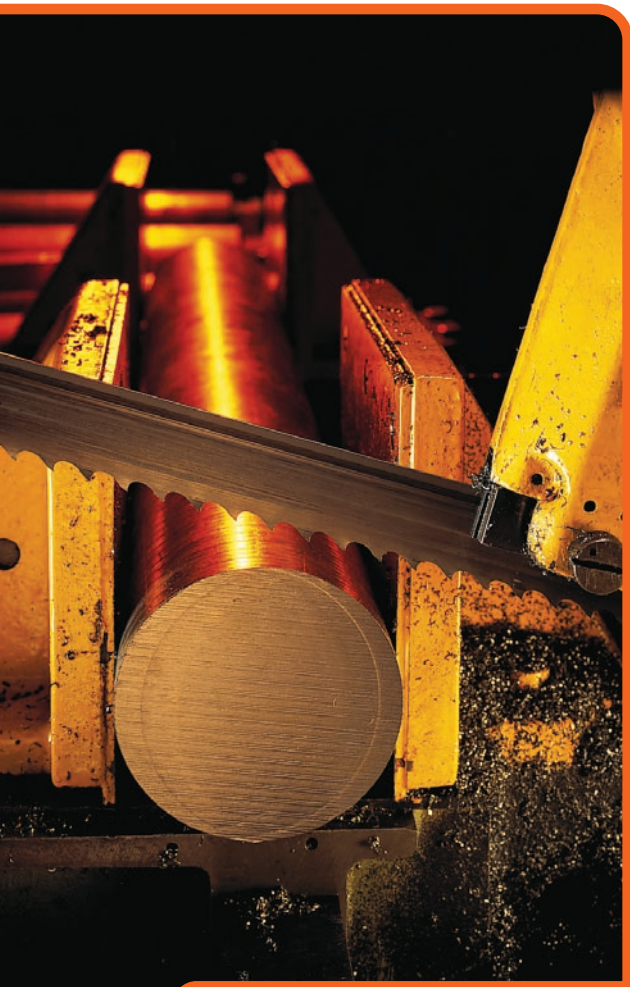
Inches	mm	Teeth Per Inch	Tooth Type	Product Code
1-1/4 x .042	34 x 1.1	1.15	Hook	3862-33-1.1-H-1.15

- 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.
- Total quality control ensures only product produced to our tight quality standards leaves our factories.

SANDFLEX® M42

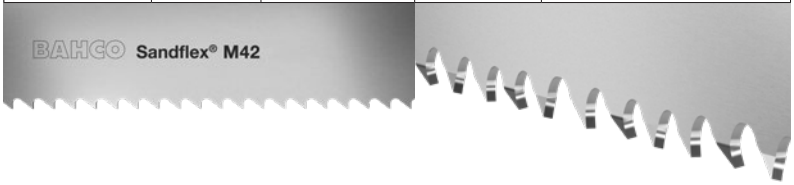
Manufactured from M42 high speed steel for durability and longer tool life.

- 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 - Traditional shape tooth with varing 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	Tooth Type	Product Code
1/2 x .020	13 x 0.5	10/14	Combo	M42-13-0.5-10/14
		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
		8/12	Combo	M42-13-0.6-8/12
		10/14	Combo	M42-13-0.6-10/14
		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
		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
		5/8	Combo	M42-20-0.9-5/8
		6/10	Combo	M42-20-0.9-6/10
		8/12	Combo	M42-20-0.9-8/12
		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
		3/4	Combo	M42-27-0.9-3/4
		4/6	Combo	M42-27-0.9-4/6
		5/8	Combo	M42-27-0.9-5/8
		6/10	Combo	M42-27-0.9-6/10
		8/12	Combo	M42-27-0.9-8/12
		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
		3/4	Combo	M42-34-1.1-3/4
		4/6	Combo	M42-34-1.1-4/6
		5/8	Combo	M42-34-1.1-5/8
		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
		3/4	Combo	M42-41-1.3-3/4
		4/6	Combo	M42-41-1.3-4/6
		5/8	Combo	M42-41-1.3-5/8
		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
		2/3	Combo	M42-54-1.6-2/3
		3/4	Combo	M42-54-1.6-3/4
		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

US Patent No. 7,178,441

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.

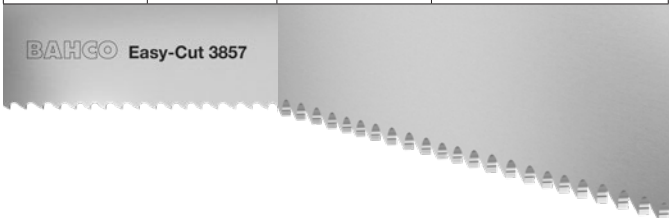
Easy to use – patented anti-tooth-stripping design and M-42 tooth tips combine to create a blade that lasts longer and will not strip teeth like other blades, allowing the operator to spend more time cutting and less time changing saw blades.

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.

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.

3857 EASY-CUT®			
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



3851-COBRA™

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

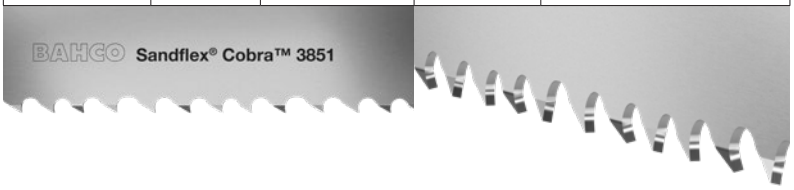
- POWDERED metal M42 high speed steel tooth edge gives a combination of higher hardness and higher toughness
- Less vibrations, consequently less heat and better wear resistance
- New geometry with variable teeth pattern mathematically formulated to maximize cutting performance
- A superior surface finish generates less friciton and vibration for improved perfomance
- Excellent choice for production cutting of the toughest materials
- General Purpose Applications, solids, bundle, even profiles and castings
- Contour cutting, including aluminium and stainless steel

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

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

3851 COBRA™				
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
		10/14	Combo	3851-6-0.6-10/14
		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
		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
		6	Hook	3851-10-0.6-H-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
		6	Hook	3851-10-0.9-H-6
		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
		4	Hook	3851-13-0.6-H-4
		6	Hook	3851-13-0.6-H-6
		5/8	Combo	3851-13-0.6-5/8
		6/10	Combo	3851-13-0.6-6/10
		8/12	Combo	3851-13-0.6-8/12
		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
		4	Hook	3851-13-0.9-H-4
		6	Hook	3851-13-0.9-H-6
		6/10	Combo	3851-13-0.9-6/10
		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
		4/6	Combo	3851-20-0.9-4/6
		5/8	Combo	3851-20-0.9-5/8
		6/10	Combo	3851-20-0.9-6/10
		8/12	Combo	3851-20-0.9-8/12
		10/14	Combo	3851-20-0.9-10/14
1 x .035	27 x 0.9	3	Hook	3851-27-0.9-H-3
		2/3	Combo	3851-27-0.9-2/3
		3/4	Combo	3851-27-0.9-3/4
		4/6	Combo	3851-27-0.9-4/6

3851 COBRA™				
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
		6/10	Combo	3851-27-0.9-6/10
		8/12	Combo	3851-27-0.9-8/12
		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
		3/4	Combo	3851-34-1.1-3/4
		4/6	Combo	3851-34-1.1-4/6
		5/8	Combo	3851-34-1.1-5/8
		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
		3/4	Combo	3851-41-1.3-3/4
		4/6	Combo	3851-41-1.3-4/6
		5/8	Combo	3851-41-1.3-5/8
		1.4/2	Combo	3851-41-1.3-1.4/2
2 x .062	54 x 1.6	1.4/2	Combo	3851-54-1.6-1.4/2
		1/1.4	Combo	3851-54-1.6-1/1.4
		2/3	Combo	3851-54-1.6-2/3
		3/4	Combo	3851-54-1.6-3/4
		4/6	Combo	3851-54-1.6-4/6
2-5/8 x .062	67 x 1.6	.7/1	Combo	3851-67-1.6-.7/1
		1.4/2	Combo	3851-67-1.6-1.4/2
		1/1.4	Combo	3851-67-1.6-1/1.4
		2/3	Combo	3851-67-1.6-2/3
		3/4	Combo	3851-67-1.6-3/4
3-1/8 x .062	80 x 1.6	.7/1	Combo	3851-80-1.6-.7/1
		1/1.4	Combo	3851-80-1.6-1/1.4
		1.4/2	Combo	3851-80-1.6-1.4/2
		4/6	Combo	3851-80-1.6-4/6



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

POWDERED METAL
BAHCO
COBRA
3851 | BANDSAW BLADE
TECHNOLOGY

3854-KING COBRA™ PHX

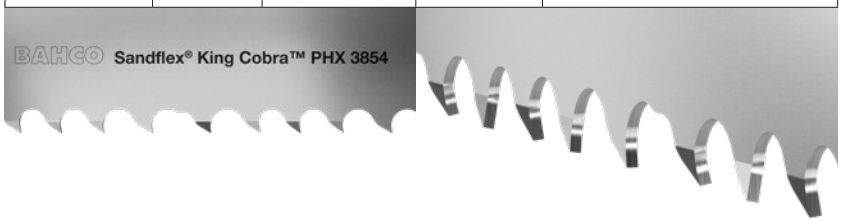
For high performance cutting of large and difficult to cut work pieces

- Tooth made from powder metallurgic material withstands high heat levels and is wear resistant and will gives a much better blade life.
- Developed for cutting harder material
- For high performance cutting of large and difficult to cut work pieces
- 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
- New tooth design that will give less vibration.
- Extra deep gullets design to handle bigger chips

Cuts:

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

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



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.

3854-KING COBRA™ PQ

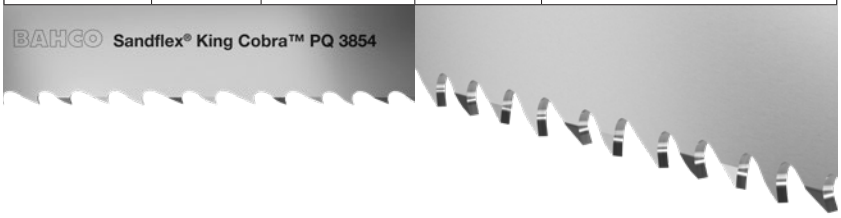
For difficult to cut materials - multi chip performance

- Powder metallurgic tooth material will give a much better blade life
- Patented tooth design with a very positive rake angle of 17° allows good penetration into difficult to cut materials.
- 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.

Cuts:

- Inconel
- Monel
- Zirconium
- Titanium
- Beryllium Copper
- Stainless Steels
- Bearing Steels

3854 KING COBRA™ PQ				
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
		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
		3/4	PQ	3854-34-1.1-PQ-3/4
		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
		3/4	PQ	3854-41-1.3-PQ-3/4
		4/6	PQ	3854-41-1.3-PQ-4/6
		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
		3/4	PQ	3854-54-1.6-PQ-3/4
		4/6	PQ	3854-54-1.6-PQ-4/6
		.9/1.2	PQ	3854-54-1.6-PQ-.9/1.2
		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
		3/4	PQ	3854-67-1.6-PQ-3/4
		.9/1.2	PQ	3854-67-1.6-PQ-.9/1.2
		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
		3/4	PQ	3854-80-1.6-PQ-3/4
		.9/1.2	PQ	3854-80-1.6-PQ-.9/1.2
		1.4/2	PQ	3854-80-1.6-PQ-1.4/2



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.

3853-TOP FABRICATOR

3853 Top Fabricator for tubes or profiles

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

Features:
- 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

3853 TOP FABRICATOR				
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
		4/6	Combo PF	3853-27-0.9-4/6
		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
		3/4	Combo PF	3853-34-1.1-3/4
		4/6	Combo PF	3853-34-1.1-4/6
		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
		3/4	Combo PF	3853-41-1.3-3/4
		3/4	Combo PF	3853-41-1.3-3/4-W
		4/6	Combo PF	3853-41-1.3-4/6
		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
		3/4	Combo PF	3853-54-1.3-3/4-W
		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
		2/3	Combo PF	3853-54-1.6-2/3-W
		3/4	Combo PF	3853-54-1.6-3/4
		3/4	Combo PF	3853-54-1.6-3/4-W
		4/6	Combo PF	3853-54-1.6-4/6
2–5/8 x .062	67 x 1.6	2/3	Combo PF	3853-67-1.6-2/3
		2/3	Combo PF	3853-67-1.6-2/3-W
		3/4	Combo PF	3853-67-1.6-3/4
		3/4	Combo PF	3853-67-1.6-3/4-W
		5/8	Combo PF	3853-67-1.6-5/8-W

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.

POWDERED METAL TECHNOLOGY
BAHCO
TOP FABRICATOR
3853 | BANDSAW BLADE
EXTRA WIDE SET

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

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

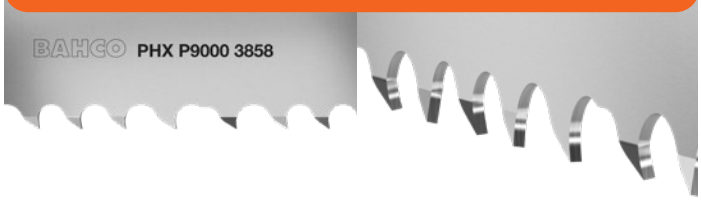
Cuts:

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

3858 SANDFLEX® P9000				
Inches	**mm**	**Teeth Per Inch**	**Tooth Type**	**Product Code**
1-1/2 x .050	41 x 1.3	1.4/2	PQ	3858-41-1.3-PQ-1.4/2
		2/3	PQ	3858-41-1.3-PQ-2/3
		3/4	PQ	3858-41-1.3-PQ-3/4
2 x .050	54 x 1.3	2/3	PHX	3858-54-1.3-PHX-2/3
		3/4	PHX	3858-54-1.3-PHX-3/4
2 x .062	54 x 1.6	1/1.4	PHX	3858-54-1.6-PHX-1/1.4
		3/4	PHX	3858-54-1.6-PHX-3/4
2-5/8 x .062	67 x 1.6	1.4/2	PHX	3858-67-1.6-PHX-1.4/2
		.7/1	PHX	3858-67-1.6-PHX-.7/1
		1/1.4	PHX	3858-67-1.6-PHX-1/1.4
3-1/8 x .062	80 x 1.6	1.4/2	PHX	3858-80-1.6-PHX-1.4/2
		.7/1	PHX	3858-80-1.6-PHX-.7/1

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.

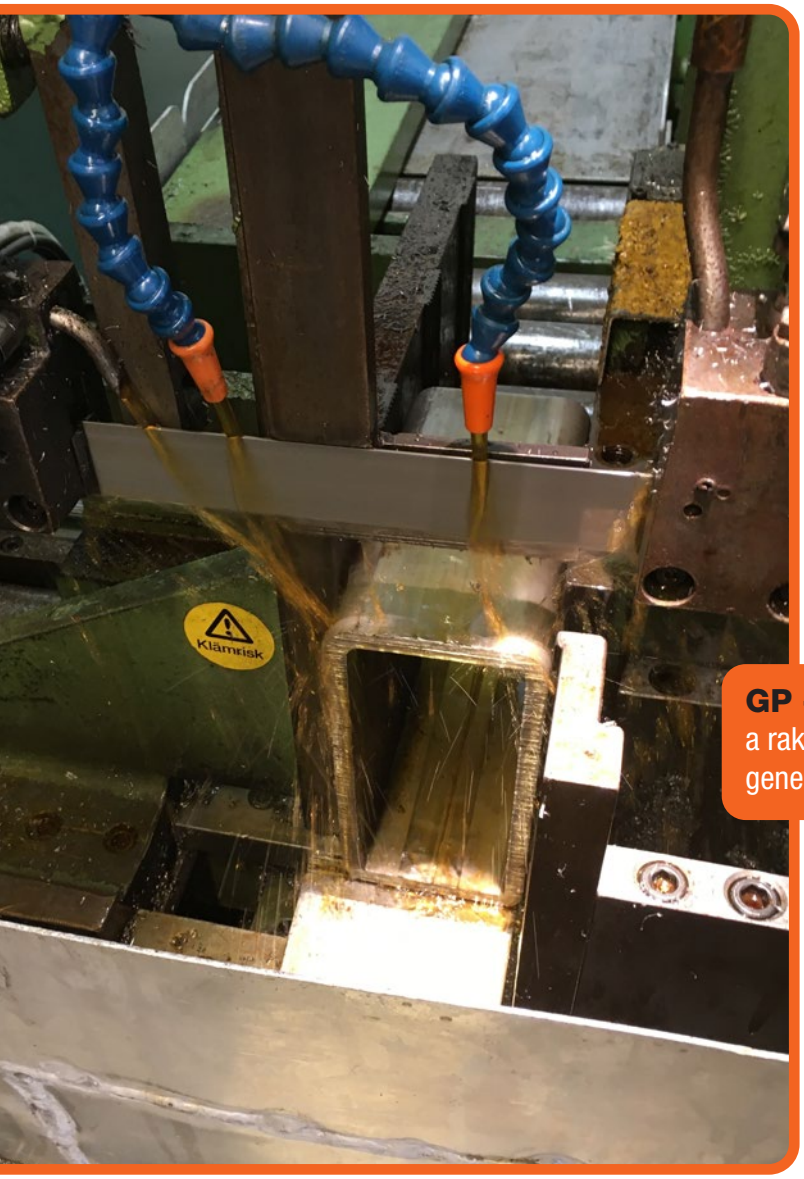


3867-GENERAL PURPOSE CARBIDE

General Purpose Carbide for cutting

- More universal/versatile (general purpose) due to stronger tooth design.
- Can cut all materials* and shapes due to new tooth and gullet shape
- Needs no running in as same Patented edge preparation (honed) as on our TSS product
- New set pattern gives bigger span in cutting width

*Not titanium



Coming Soon!

Available Spring 2021

3867 GENERAL PURPOSE CARBIDE			
Inches	mm	Teeth Per Inch	Product Code
1 x .035	27 x 0.9	3/4	3867-27-0.9-3/4
1-1/4 x .042	34 x 1.1	2/3	3867-34-1.1-2/3
		3/4	3867-34-1.1-3/4
1-1/2 x .050	41 x 1.3	2/3	3867-41-1.3-2/3
		3/4	3867-41-1.3-3/4

BAHCO GP Carbide 3867

GP - This triple chip tooth design has a rake angle of 5° and is designed for general purpose use.

3869-CARBIDE TRIPLE SET®

Foundry bandsaw blade for non-ferrous and abrasive materials

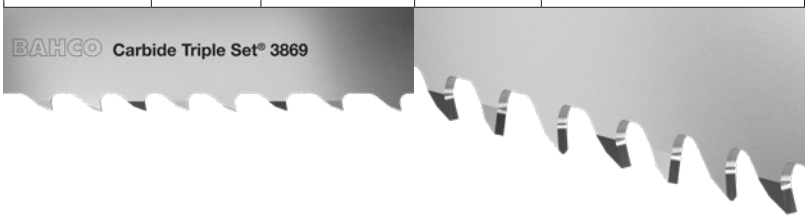
Perfect for aluminum, gates and risers, magnesium, zirconium, beryllium, bronze, copper, composites, abrasive materials and plastics.

- 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®

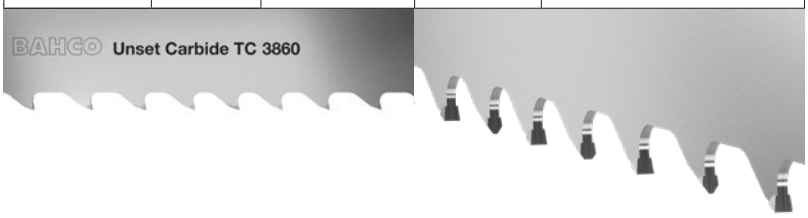
Inches	mm	Teeth Per Inch	Tooth Type	Product Code
1/2 x .035	13 x 0.9	3	TS	3869-13-0.9-TS-3
3/4 x .035	20 x 0.9	3	TS	3869-20-0.9-TS-3
		4	TS	3869-20-0.9-TS-4
1 x .035	27 x 0.9	3	TS	3869-27-0.9-TS-3
		4	TS	3869-27-0.9-TS-4
1-1/4 x .042	34 x 1.1	3	TS	3869-34-1.1-TS-3



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

3860 MULTI-CHIP UNSET CARBIDE TIPPED - TC

Inches	mm	Teeth Per Inch	Tooth Type	Product Code
1/2 X .025	13 x 0.6	3	TC	3860-13-0.6-TC-3
		4	TC	3860-13-0.6-TC-4
3/4 X .035	20 x 0.9	3	TC	3860-20-0.9-TC-3
		3/4	TC	3860-20-0.9-TC-3/4
1 x .035	27 x 0.9	3	TC	3860-27-0.9-TC-3
		3/4	TC	3860-27-0.9-TC-3/4
1-1/4 x .042	34 x 1.1	3/4	TC	3860-34-1.1-TC-3/4



- 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 24**

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.

3868-CARBIDE TRIPLE SET® TSS

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.
- Positive 10 degree rake angle tooth for faster cutting rates and increased productivity .
- Set tooth design eliminates vibration and noise especially on unstable machines.

US Patent No. 7,908,954

3868 CARBIDE TRIPLE SET® TSS				
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
		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
		2/3	TSS	3868-54-1.6-TSS-2/3
		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
		1.4/2	TSS	3868-67-1.6-TSS-1.4/2
		1/1.25	TSS	3868-67-1.6-TSS-1/1.25
		2/3	TSS	3868-67-1.6-TSS-2/3
3-1/8 x .062	80 x 1.6	.7/1	TSS	3868-80-1.6-TSS-.7/1
		1.4/2	TSS	3868-80-1.6-TSS-1.4/2
		2/3	TSS	3868-80-1.6-TSS-2/3

ENGINEERED PRODUCTIVITY
BAHCO
CARBIDE TIPPED
BANDSAW BLADE
SOLUTIONS

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. This is a unique and patented tooth design. Not suitable for titanium applications.

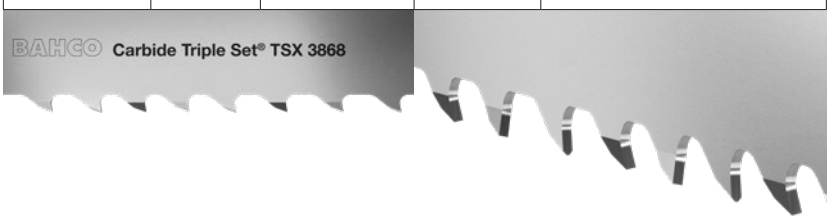
WARNING Wear Safety Goggles (users and bystanders) Wear hearing protection (users and bystanders) Avoid prolonged exposure to vibration.

3868-CARBIDE TRIPLE SET® "XTRA"™ TSX

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.
- Positive 10 degree rake angle tooth for faster cutting rates and increased productivity
- Set tooth design eliminates vibration and noise especially on unstable machines

3868 CARBIDE TRIPLE SET® "XTRA"™ TSX				
Inches	**mm**	**Teeth Per Inch**	**Tooth Type**	**Product Code**
1 x 0.35	27 x 0.9	3/4	TSX	3868-27-0.9-TSX-3/4
1-1/4 x .042	34 x 1.1	2	TSX	3868-34-1.1-TSX-2
		2/3	TSX	3868-34-1.1-TSX-2/3
		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
		2	TSX	3868-41-1.3-TSX-2
		1.4/2	TSX	3868-41-1.3-TSX-1.4/2
		2/3	TSX	3868-41-1.3-TSX-2/3
		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	TSX	3868-54-1.6-TSX-2
		1.6	TSX	3868-54-1.6-TSX-1.6
		1/1.25	TSX	3868-54-1.6-TSX-1/1.25
		2/3	TSX	3868-54-1.6-TSX-2/3
		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
		1.4/2	TSX	3868-67-1.6-TSX-1.4/2
		1/1.25	TSX	3868-67-1.6-TSX-1/1.25
		.7/1	TSX	3868-67-1.6-TSX-.7/1
3-1/8 x .042	80 x 1.1	3/4	TSX	3868-80-1.1-TSX-3/4
3-1/8 x .062	80 x 1.6	3/4	TSX	3868-80-1.6-TSX-3/4
		.7/1	TSX	3868-80-1.6-TSX-.7/1
		1/1.25	TSX	3868-80-1.6-TSX-1/1.25
		1.4/2	TSX	3868-80-1.6-TSX-1.4/2



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 tooth design.

3881-CARBIDE TRIPLE SET THQ

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

3881 CARBIDE TRIPLE SET® THQ				
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
		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
		2/3	THQ	3881-54-1.6-THQ-2/3
		1/1.25	THQ	3881-54-1.6-THQ-1/1.25
2-5/8 x .062	67 x 1.6	1.4/2	THQ	3881-67-1.6-THQ-1.4/2
		2/3	THQ	3881-67-1.6-THQ-2/3
		1/1.25	THQ	3881-67-1.6-THQ-1/1.25
3-1/8 x .062	80 x 1.6	1.4/2	THQ	3881-80-1.6-THQ-1.4/2
		2/3	THQ	3881-80-1.6-THQ-2/3
		1/1.25	THQ	3881-80-1.6-THQ-1/1.25
		.7/1	THQ	3881-80-1.6-THQ-.7/1

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.

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

3881-CARBIDE TRIPLE SET THS

THS (Triple High Quad - Honed)

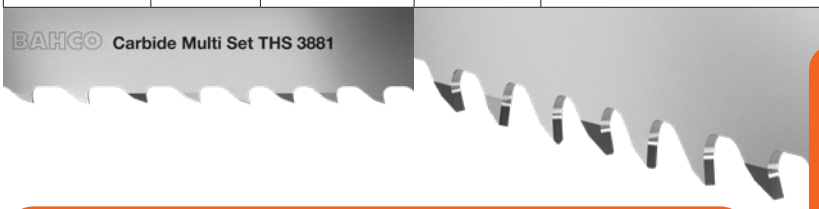
The 3881 Quad grind and set pattern enables cutting of scaled surfaces, improves chip removal and extents blade life.

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

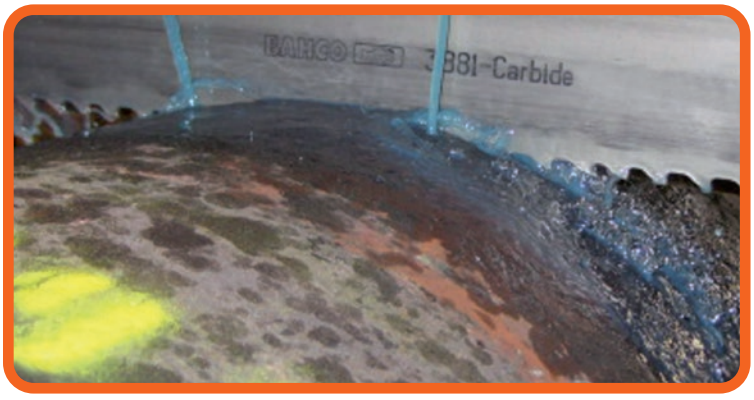
- Patented edge preparation (honed) eliminates the need for break in
- Reduces tooth strippage on breakthrough
- Same design as THQ, but with an extremely low noise level.
- Patented tooth chamfers improves chip removal and extends blade life especially in materials with scale and rough surface finish
- Set tooth design eliminates vibration and noise especially on unstable machines

3881 CARBIDE TRIPLE SET® THS

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



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.



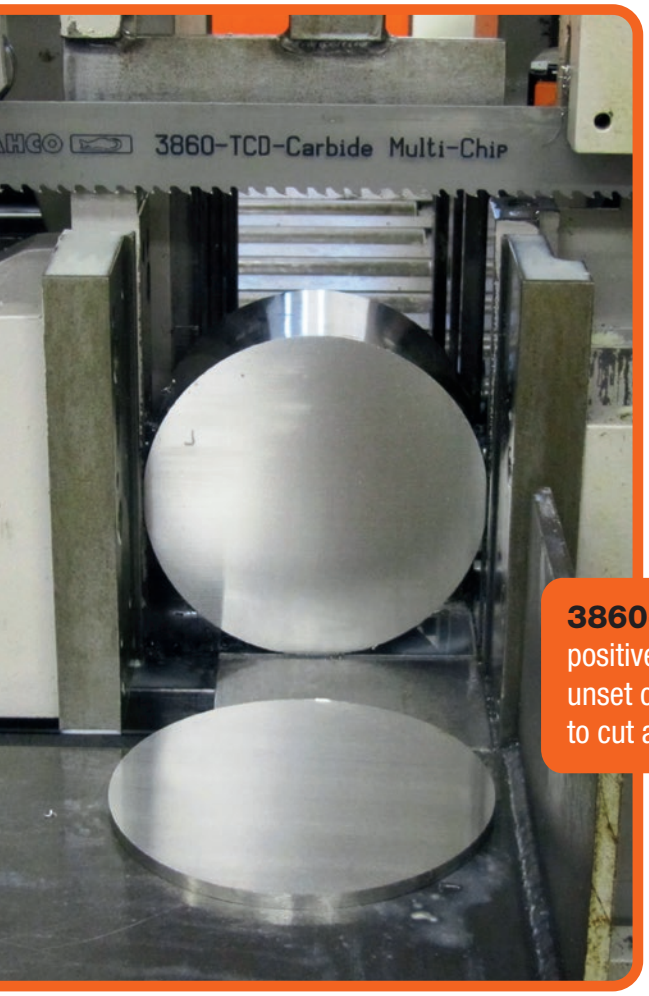
3860-MULTI-CHIP UNSET CARBIDE TIPPED TCD

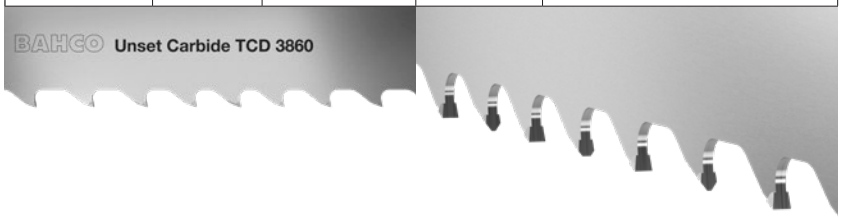
3860 Multi-Chip Unset Carbide Tipped TCD bandsaw blade for economical high efficiency cutting of difficult and abrasive materials.

- 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 MULTI-CHIP UNSET CARBIDE TIPPED - TCD

Inches	mm	Teeth Per Inch	Tooth Type	Product Code
1/2 X .025	13 x 0.6	3	TC	3860-13-0.6-TC-3
		4	TC	3860-13-0.6-TC-4
3/4 X .035	20 x 0.9	3	TC	3860-20-0.9-TC-3
		3/4	TC	3860-20-0.9-TC-3/4
1 x .035	27 x 0.9	3	TC	3860-27-0.9-TC-3
		3/4	TC	3860-27-0.9-TC-3/4
1-1/4 x .042	34 x 1.1	2/3	TCD	3860-34-1.1-TCD-2/3
		3/4	TC	3860-34-1.1-TC-3/4
1-1/2 x .050	41 x 1.3	1.9/2.1	TCD	3860-41-1.3-TCD-1.9/2.1
		1.4/2	TCD	3860-41-1.3-TCD-1.4/2
		2/3	TCD	3860-41-1.3-TCD-2/3
		3/4	TCD	3860-41-1.3-TCD-3/4
2 x .062	54 x 1.6	1.9/2.1	TCD	3860-54-1.6-TCD-1.9/2.1
		1.4/2	TCD	3860-54-1.6-TCD-1.4/2
		2/3	TCD	3860-54-1.6-TCD-2/3
		3/4	TCD	3860-54-1.6-TCD-3/4
2-5/8 x .062	67 x 1.6	1/1.25	TCD	3860-67-1.6-TCD-1/1.25
		1.4/2	TCD	3860-67-1.6-TCD-1.4/2





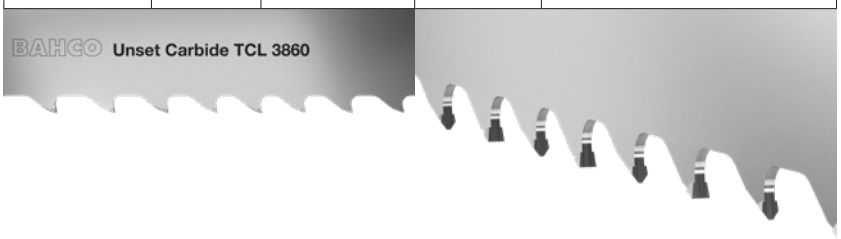
3860-TCD - tooth design is a 10° positive rake angle and is used for our unset carbide blade. It excels in difficult to cut alloys on stable machines.

3860-TRIPLE CHIP UNSET CARBIDE TIPPED TCL

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 TRIPLE-CHIP UNSET CARBIDE TIPPED - TLC				
Inches	mm	Teeth Per Inch	Tooth Type	Product Code
1-1/2 x .050	41 x 1.3	1.4/2	TCL	3860-41-1.3-TCL-1.4/2
		2/3	TCL	3860-41-1.3-TCL-2/3
2 x .063	54 x 1.6	1.4/2	TCL	3860-54-1.6-TCL-1.4/2
		2/3	TCL	3860-54-1.6-TCL-2/3
2-5/8 x .062	67 x 1.6	1.4/2	TCL	3860-67-1.6-TCL-1.4/2
		2/3	TCL	3860-67-1.6-TCL-2/3
3-1/8 x .062	80 x 1.6	.8/1	TCL	3860-80-1.6-TCL-.8/1



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.

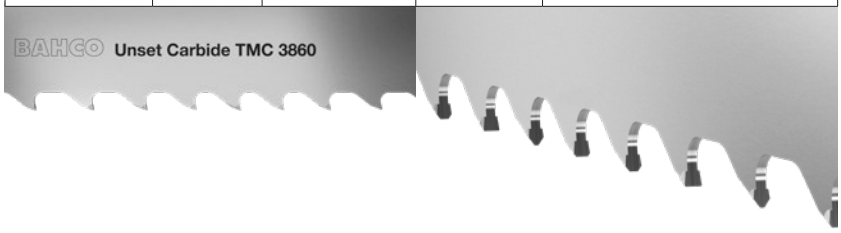
3860-MULTI-CHIP UNSET CARBIDE TIPPED TMC

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

Performs extremely well cutting Titanium solids and blocks, 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
- 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

3860 MULTI-CHIP UNSET CARBIDE TIPPED - TMC				
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
		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
		1/4.2	TMC	3860-54-1.6-TMC-1.4/2
		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
		1.4/2	TMC	3860-67-1.6-TMC-1.4/2
		2/3	TMC	3860-67-1.6-TMC-2/3
3-1/8 X .042	80 X 1.1	1.4/2	TMC	3860-80-1.1-TMC-1.4/2
3-1/8 X .062	80 X 1.6	.7/1	TMC	3860-80-1.6-TMC-.7/1
		1/1.25	TMC	3860-80-1.6-TMC-1/1.25
		1.4/2	TMC	3860-80-1.6-TMC-1.4/2
		2/3	TMC	3860-80-1.6-TMC-2/3
4 X .042	100 X 1.1	1.4/2	TMC	3860-100-1.1-TMC-1.4/2



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.

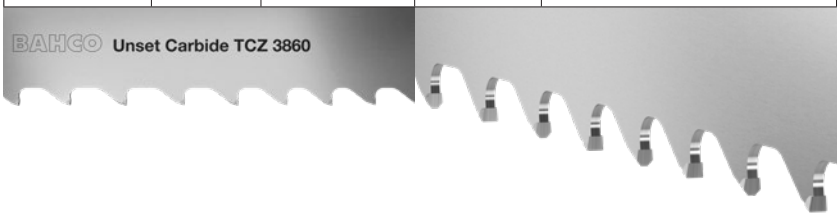
3860-MULTI-CHIP UNSET CARBIDE TIPPED TCZ

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
- 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

Inches	mm	Teeth Per Inch	Tooth Type	Product Code
1 x .035	27 x 0.9	3/4	TCZ	3860-27-0.9-TCZ-3/4
1-1/4 x .042	34 x 1.1	2/3	TCZ	3860-34-1.1-TCZ-2/3
		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
		3/4	TCZ	3860-41-1.3-TCZ-3/4



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.

BI-METAL PORTABANDS

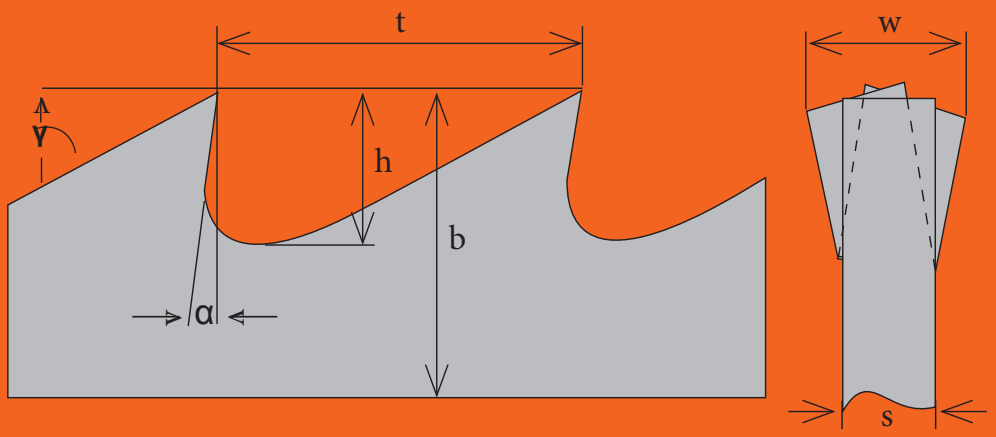
Fast cutting for hand-held machines

- A unique design for multipurpose and jobshop use that provides hand-held machines with fast cutting, easy feeding, exceptional control, and precision cutting on a variety of materials.
- Perfect for cutting stainless steel, angle iron, bronze, copper, galvanized pipe, mild steel, aluminum, brass, chrome

BI-METAL PORTABANDS - 5 PACKS					
Inches	**mm**	**Blade Length**	**Teeth Per Inch**	**Tooth Type**	**Product Code**
1/2 x .020	13 x 0.5	44-7/8"	10	Regular	PAB105P
		44-7/8"	14		PAB145P
		44-7/8"	18		PAB185P
		44-7/8"	24		PAB245P
		44-7/8"	10/14		PAB10145P
		44-7/8"	14/18		PAB14185P

Bandsaw Blade Terminology

b: width of blade
s: thickness of blade
h: gullet depth
t: tooth pitch
a: rake angle
y: clearance angle
w: width of set



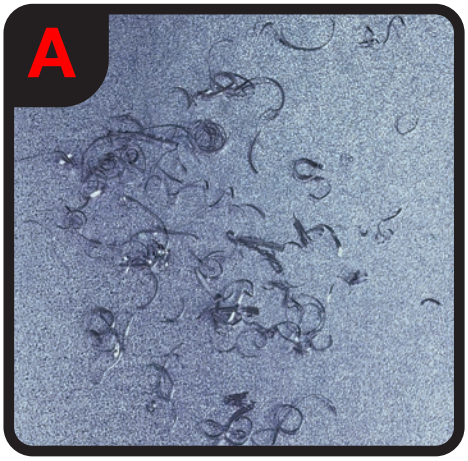
Feed Rate/Chips

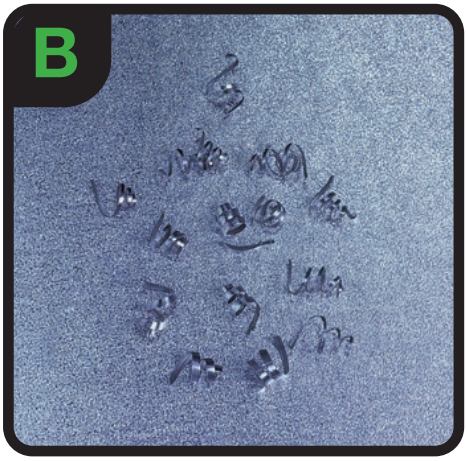
It is important that each tooth of the bandsaw blade cuts a chip with the right thickness.

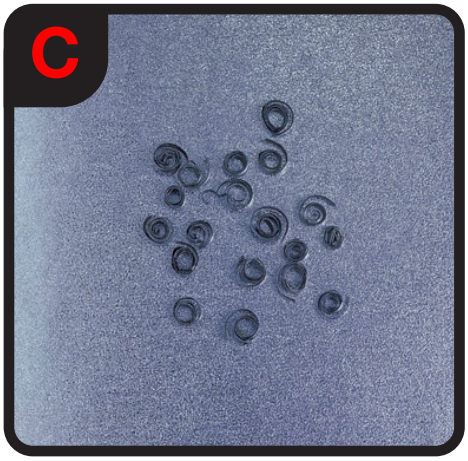
This is determined by the selection of tooth pitch, band speed and feed rate.

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







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/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 %
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 %

TECHNICAL INFORMATION

Determine TPI in Solid Work Piece

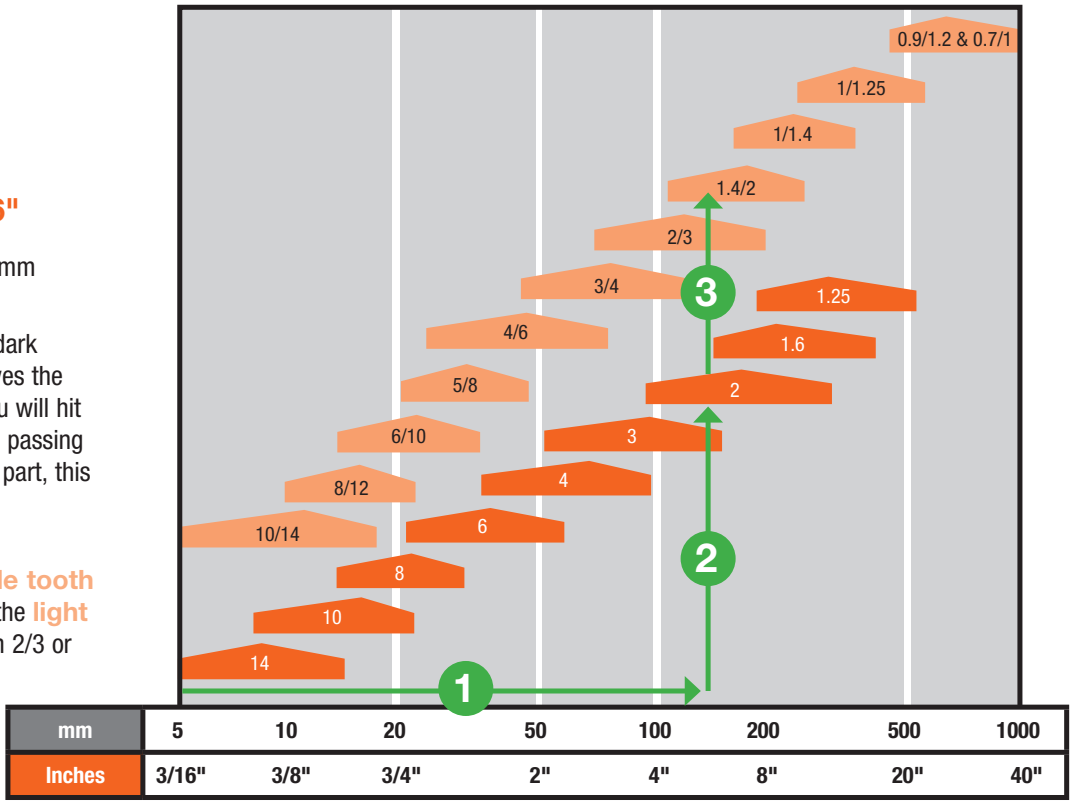
Example:

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.



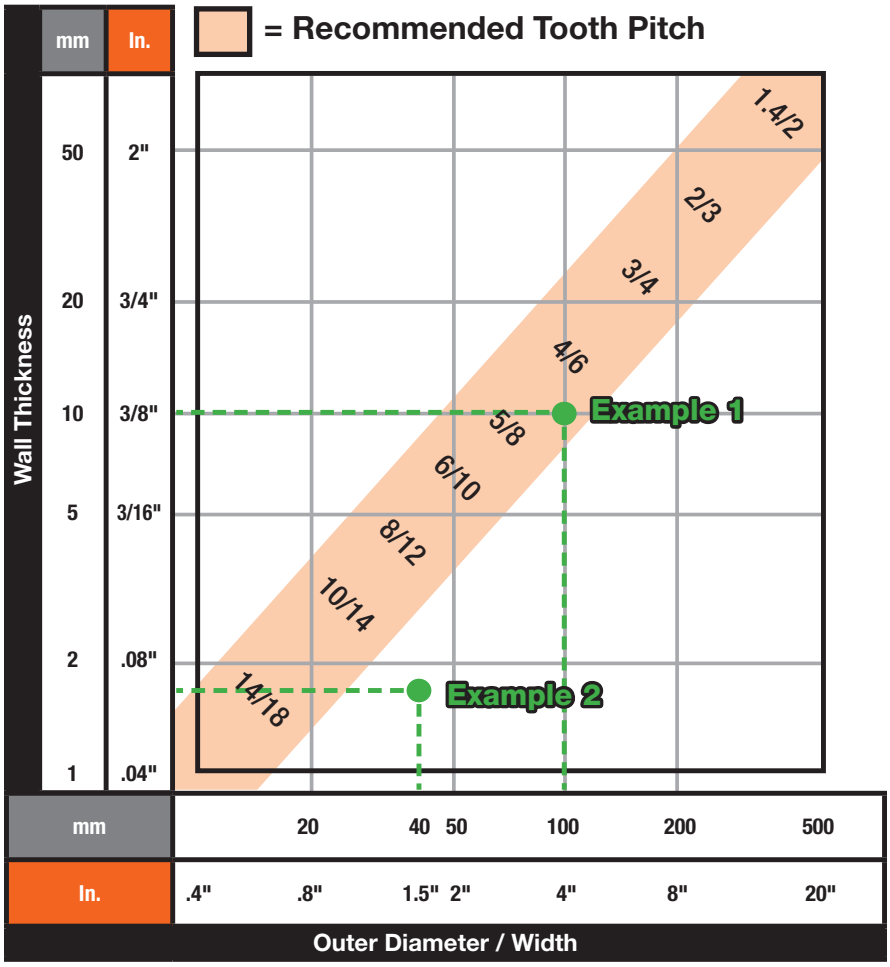
Determine Tooth Pitch Pipes & Profiles

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 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.

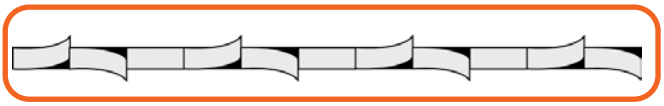


Bandsaw Blade Width

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.



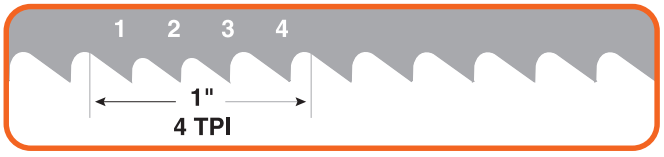
Teeth Per Inch (TPI)

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

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.

Patented edge preparation (honed) eliminates the need for break in for 3881 Carbide Triple Set THS (see page 23) or 3868 Carbide Triple Set TSS (see page 20).

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 35).
- The band speed with a tachometer (see page 35).
- The coolant concentration with a refractometer (see page 35).

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

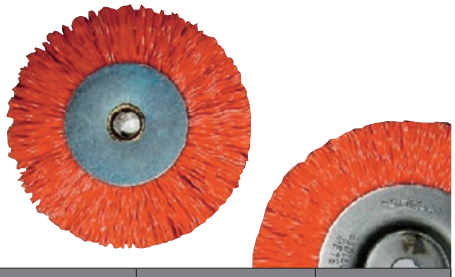
- Make sure that the workpiece is firmly clamped so that it cannot vibrate or rotate.
- Do not use bent or damaged workpieces.

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

BAH3870-SG11

Gloves

GL008-10US Size - Large

A thin PU material gives user better touch and feel.

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.

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

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