BAHCO

Precision tools you can rely on

# BANDSAWS & METAL CUTTING TOOLS

# Welcome to the Bahco Metal Cutting Catalogue

We are pleased to present the latest Bahco assortment of industrial bandsaw blades. Constant development and investment in research and development has resulted in innovative and high performance product for both general purpose and production cutting. We offer many patented products from the unique Easy Cut design to take the complex blade selection process out of bandsaw operation through to the latest “set” and “unset” high performance carbide blades for cutting complex materials used in new generation commercial and military aircraft, complex power generation projects and high technology industries.

We include the terminology, tooth pitch selection tables, speed selection data and tooth shape guides for both bi-metal and carbide blades. Also, we offer advice and tips on troubleshooting problems and some of the cutting aids required by customers involved in production cutting including our patented BandCalc™ programme designed to advise on blade selection using our customer's data on machine type, material shapes and sizes.

Quality is our number 1 priority and we also believe that a key factor in both production and general purpose cutting is product consistency. To achieve this, we operate within Bahco's quality forward system, which uses the ISO 9001-2000 framework. We strive to continually improve our quality management system focussing on customer needs and satisfaction. Rapid Continuous Improvement is fundamental to our production processes where we believe in making improvements day by day to continuously improve our products.

Finally, we showcase our entire Bahco metal cutting assortment comprising of holesaws, reciprocating saws, hand hacksaw blades and frames, power hacksaw blades, files and rotary burrs.

## INDEX


### GENERAL INFORMATION

Welcome and index ..... 2
General information ..... 3
Service ..... 4
Terminology ..... 5
Tooth pitch selection tables ..... 6
Speed selection ..... 7
Tooth shape guide ..... 8-9

### PRODUCTS BY APPLICATION

Multi-purpose and contour cutting ..... 10
Production cutting bi-metal ..... 11-12
Production cutting carbide ..... 13-14
Cutting of tubes and profiles ..... 15
Foundry cutting ..... 16

### AIDS

Trouble shooting chart ..... 17
Sawing aids ..... 18

### OTHER METALWORKING TOOLS

Holesaws ..... 19-26
Reciprocating sawblades ..... 27-31
Power hacksaw blades ..... 32-33
Hand hacksaw blades ..... 34
Files ..... 35-38
Rotary burrs ..... 39-43

# General Information

## KEY PRODUCTION PROCESSES

### Tooth Forming

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

### Setting

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

- Measures the set against the permissible tolerance (has an automatic shut-off function)
- Ensures a highly consistent set
- Provides a record card for every coil
- Creates a permanent record in our quality data base

### Heat Treatment

The latest technology heat treatment processes ensure:

- High consistency
- Easier welding alignment
- Reduced handling

All completed product is delivered into our highly automated distribution centres.

## RESEARCH AND DEVELOPMENT

We believe that research and development is fundamental to our goal to be a world leader 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.

To achieve this, we have a state-of-the art R & D centre located in Lidkoping Sweden, capable of testing a wide range of metal cutting products and materials.

The centre is actively involved in research activities including joint metal cutting research projects with a major university to improve and better understand the science of metal cutting.

R & D is at the core of our product development helping customers today with specific needs and developing the technologies for the future.

SERVICE

## Customer Support Service

BandCalc™, our easy-to-use bandsaw cutting data program offers bandsaw machine operators quick access to accurate information on correct blade usage for cutting different types of materials. The program will help select blades for over 2,500 bandsaw machines giving recommendations to include band speed, feed rate and cutting rate. BandCalc™ will suggest a choice of TPI's (Teeth Per Inch) and modify the cutting data accordingly to ensure our customer receives the best advice for every application.

To focus attention on key production end users, we have introduced a bandsaw specialist programme in more and more markets around the world. Our specialists' training is based around reducing the “cost per cut” achieved with the latest high technology ground tooth and carbide products, bringing greater efficiency to our customers cutting operation.

## Storage and Distribution

NDC - New Distribution Concept - is one of our single largest investments in customer service. It comprises three distribution centres in Europe. Modern on-line computer processes ensure prompt and reliable deliveries and minimise stock handling for our customers.

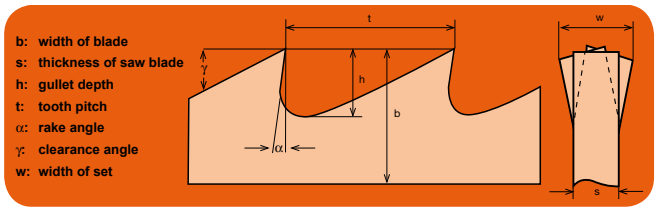
The NDC system provides continuously updated information to our production units. This allows them to produce the right products quickly and maintain high stock security.

## Weld Centres

We have strategically positioned our weld centres globally to offer customers in selected countries a reliable and fast delivery service. Our weld centres feature;

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

## TERMINOLOGY




## Types of Set

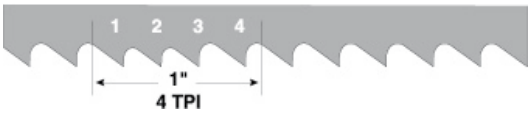
The set is the tilt, or angle, given to the teeth of the saw blade to provide clearance for the blade body and the tooth edges. Below are different types of set:

**Raker Set**

In the raker set, one tooth is set to the left, one tooth is set to the right, and one tooth (raker) is unset. This set type is used on most evenly pitched blades such as regular and hook. It is also used for contour and friction cutting blades on vertical bandsaw machines.

**Combo Set**

In the combo set, used on combo toothed blades, a raker (unset) tooth is followed by teeth in a left, right, left, right sequence. This pattern is repeated with each series of teeth starting and ending with the largest tooth in the pattern.




## 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. A coarse pitch (few TPI) therefore increases productivity and provides a desirable, 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.

## Bandsawing facts

**Machine**

Check frequently:

- The operation of the chip brush
- The wear and alignment of the guides
- The band tension with a tensionmeter (see page 18)
- The band speed with a tachometer (see page 18)
- The coolant concentration with a refractometer (see page 18)

**Coolant / Cutting fluid**

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

- Use appropiate 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

**Running 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.

**Tooth protector**

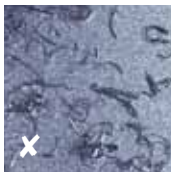
Keep the tooth protector on the blade until it is mounted on the machine to avoid premature chipping of the tooth tips.

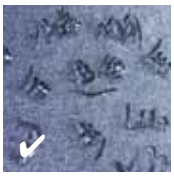
## Feed Rate/Chips

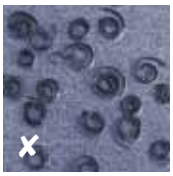
It is important that each tooth of the bandsaw blade cuts a chip with the right thickness. This is determined by the selection of tooth pitch, band speed and feed rate. Start by selecting the right tooth pitch from the diagrams on page 6 then set your band speed according to the diagram on page 7. You can now set the correct feed rate by studying the chips which the bandsaw blade produces when cutting. Use the pictures (below) and adjust your feed rate or band speed accordingly.

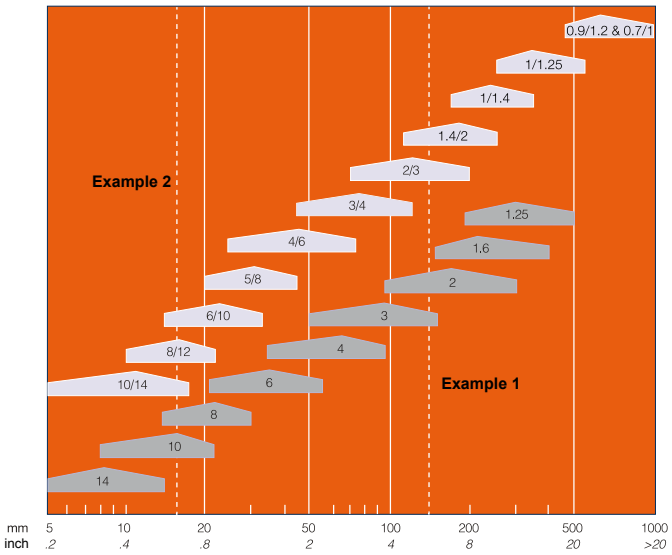
For more information on cutting data contact your local Bahco representative who can help you find the correct cutting data for your specific application.

1. Thin or pulverised chips - increase feed rate or lower band speed
2. Loosely rolled chips - correct cutting data
3. Thick, heavy or blue chips - too high feed, lower feed rate or increase band speed

1. 


2. 


3. 




## Tooth pitch for solid workpieces

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

The ideal choice is at the widest point of each field.

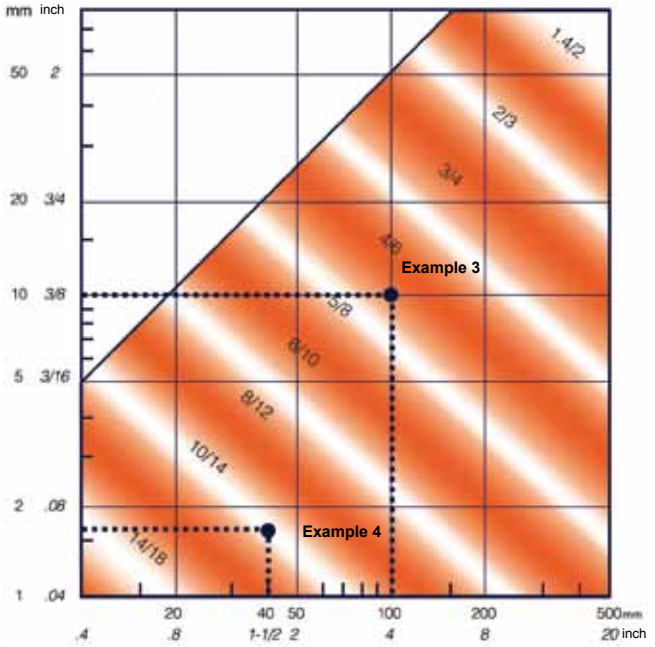
Example 1:

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

Example 2:

If you are sawing in soft materials like plastics, aluminium or wood, choose a pitch two steps coarser than recommended.

When cutting 13-20 mm (1/2-3/4 inch) thick pieces of aluminium, use a 5/8 TPI or a 6 TPI blade.




## Cutting pipes and profiles

The diagram on the left will help you find the right tooth pitch for cutting pipes and profiles.

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

Example 3:

When cutting a 100 x 10 mm (4 inch x 0.4 inch) U-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 4:

When cutting a 40 x 1.6 mm (1.5 inch x 0.06 inch) pipe, select a 10/14 TPI blade.

**EASY-CUT - Cutting DATA**

| Order Code | Blade Size Width x Thickness | Material Size (mm) 1 2 3 5 10 20 30 40 50 75 100 150 200 |
|---|---|---|
| 3857-13-0.6-EZ-S | 13 x 0.6 | |
| 3857-13-0.6-EZ-M | 13 x 0.6 | |
| 3857-13-0.6-EZ-L | 13 x 0.6 | |
| 3857-20-0.9-EZ-S | 20 x 0.9 | |
| 3857-20-0.9-EZ-M | 20 x 0.9 | |
| 3857-20-0.9-EZ-L | 20 x 0.9 | |
| 3857-27-0.9-EZ-S | 27 x 0.9 | |
| 3857-27-0.9-EZ-M | 27 x 0.9 | |
| 3857-27-0.9-EZ-L | 27 x 0.9 | |
| 3857-34-1.1-EZ-S | 34 x 1.1 | |
| 3857-34-1.1-EZ-M | 34 x 1.1 | |
| 3857-34-1.1-EZ-L | 34 x 1.1 | |

Within any size range | Small = Good surface finish | Medium = Good band life | Large = Speed of cut

## EASY-CUT

Choose S (Small), M (Medium) or L (Large), depending on the cutting range you need.

# General Information

## SPEED SELECTION

**Bi-metal** — **Meters per minute at Ø mm**

| | Material | 10-65 | 100-300 | 400-800 | >1000 | COOLANT |
|---|---|---|---|---|---|---|
| 1 | Structural steels, machining steel | 100 | 85-95 | 60-75 | 40-60 | 6% |
| 2 | Structural steels, quenched and tempered steels | 80 | 70-80 | 60-68 | 40-50 | 6% |
| 3 | Case hardened-, spring steels, quenched and tempered steels | 75-100 | 60-80 | 45-65 | 30-40 | 8% |
| 4 | Unalloyed tool steel, ball and roller bearing steel | 60-65 | 55-60 | 35-45 | 25-35 | 8% |
| 5 | High speed steel | 45-50 | 40-45 | 30-35 | 20-25 | 8% |
| 6 | Cold work tool steel | 30-35 | 25-30 | 20-25 | 15-20 | DRY |
| 7 | Tool steels, alloyed | 45-65 | 45-60 | 40-60 | 20-40 | 8% |
| 8 | Nitriding steels, high alloyed hot working steels | 40-45 | 35-40 | 25-30 | 20-25 | 8% |
| 9 | Cast iron | 50-60 | 45-50 | 30-40 | 25-30 | DRY |
| 10 | Rust and acid-resistant steels (light) | 40-45 | 40-45 | 35-40 | 30-40 | 10% |
| 11 | Rust and acid-resistant steels (heavy) | 35-40 | 30-35 | 20-30 | 19-22 | 10% |
| 12 | Duplex and heat resistant steels | 25-30 | 20-25 | 15-20 | 14-16 | 10% |
| 13 | Nickel and nickel-cobalt alloys | 15-20 | 13-15 | 10-12 | 10 | 10% |
| 14 | Titanium, titanium alloys; aluminium bronze | 30-35 | 25-30 | 20-25 | 16-18 | 10% |
| 15 | Horizontal machines, aluminium, aluminium alloys | 120 | 120 | 120 | 120 | 25% |
| 16 | Vertical machines, aluminium, aluminium alloys | 3000 | 2100-2500 | 1250-2000 | 500-1200 | 25% |
| 17 | Brass | 120 | 120 | 90-120 | 80-100 | 4% |
| 18 | Copper | 120 | 110 | 80-100 | 60-80 | 15% |

The bigger the size, the lower the speed

**BLADE SELECTION**

| 3857 | 3853 | 3851 | 3851 PSG | 3854 PHG | 3854 PQ |
|---|---|---|---|---|---|
| + | + | ++ | +++ | | |
| + | + | ++ | +++ | | |
| + | + | ++ | +++ | | |
| | | +++ | + | ++ | +++ |
| | | +++ | + | ++ | +++ |
| | | ++ | + | ++ | +++ |
| | | ++ | + | ++ | +++ |
| | | + | + | ++ | +++ |
| | | + | + | ++ | +++ |
| | | + | ++ | +++ | +++ |
| | | + | ++ | +++ | +++ |
| | | + | ++ | +++ | +++ |
| | | + | + | ++ | +++ |
| | | + | + | ++ | +++ |
| | | +++ | + | + | + |
| | | +++ | + | + | + |
| | | +++ | + | ++ | |
| | | +++ | + | ++ | |
| Good + | | Better ++ | | Best +++ | |

**Carbide** — **Meters per minute at Ø mm**

| | Material | 10-65 | 100-300 | 400-800 | >1000 | COOLANT |
|---|---|---|---|---|---|---|
| 1 | Structural steels, machining steel | 200 | 160-190 | 110-150 | 60-90 | 12% |
| 2 | Structural steels, quenched and tempered steels | 140 | 120-140 | 85-115 | 50-70 | 12% |
| 3 | Case hardened-, spring steels, quenched and tempered steels | 120-130 | 110-120 | 75-110 | 40-60 | 10% |
| 4 | Unalloyed tool steel, ball and roller bearing steel | 100-120 | 90-100 | 60-90 | 40-50 | 10% |
| 5 | High speed steel | 100-110 | 80-90 | 60-75 | 50-60 | 10% |
| 6 | Cold work tool steel | 80-100 | 60-90 | 60-75 | 45-65 | DRY |
| 7 | Tool steels, alloyed | 85-95 | 80-90 | 60-70 | 50-60 | 8% |
| 8 | Nitriding steels, high alloyed hot working steels | 75-85 | 70-80 | 60-70 | 45-60 | 8% |
| 9 | Cast iron | 90-105 | 90-95 | 60-75 | 40-55 | 12% |
| 10 | Rust and acid-resistant steels (light) | 80-110 | 80-100 | 70-95 | 65-80 | 12% |
| 11 | Rust and acid-resistant steels (heavy) | 80-90 | 70-80 | 60-70 | 40-50 | 13% |
| 12 | Duplex and heat resistant steels | 100-115 | 80-100 | 65-80 | 50-60 | 12% |
| 13 | Nickel and nickel-cobalt alloys | 30-40 | 25-30 | 20-28 | 15-20 | 12% |
| 14 | Titanium, titanium alloys; aluminium bronze | 50-60 | 40-50 | 35-45 | 16-18 | 12% |
| 15 | Horizontal machines, aluminium, aluminium alloys | 250 | 250 | 250 | 250 | 25% |
| 16 | Vertical machines, aluminium, aluminium alloys | 5000 | 4000-5000 | 3000-4000 | 2000-3000 | 25% |
| 17 | Brass | 250 | 250 | 180-240 | 140-160 | 4% |
| 18 | Copper | 240 | 220 | 130-190 | 100-120 | 15% |

The bigger the size, the lower the speed

**BLADE SELECTION**

| 3868 TSX | 3868 TSS | 3881 THQ | 3881 THS | 3860 TMC | 3869 TS |
|---|---|---|---|---|---|
| + | | | | | |
| + | | | | | |
| + | | | | | |
| + | | | | | |
| + | + | + | + | + | |
| ++ | | ++ | + | + | |
| ++ | ++ | + | + | + | |
| ++ | + | | | | |
| ++ | + | | | | |
| ++ | +++ | +++ | +++ | +++ | ++ |
| ++ | +++ | +++ | +++ | +++ | ++ |
| ++ | +++ | +++ | +++ | +++ | ++ |
| ++ | ++ | +++ | +++ | +++ | ++ |
| ++ | | +++ | | +++ | ++ |
| + | + | + | + | +++ | ++ |
| | | | | +++ | ++ |
| | ++ | | +++ | | |
| | ++ | | +++ | | |
| Good + | | Better ++ | | Best +++ | |

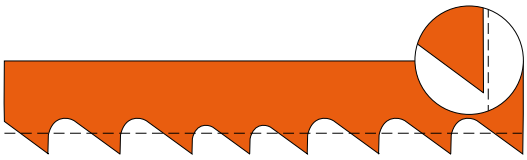
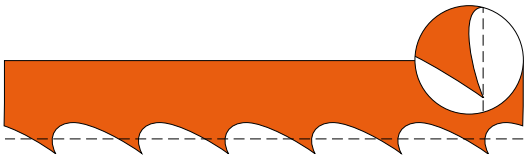
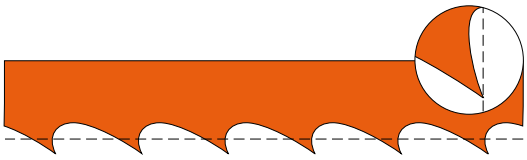
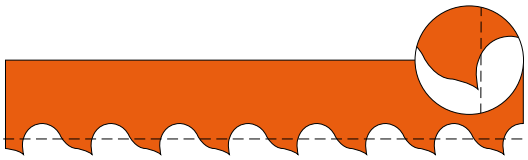
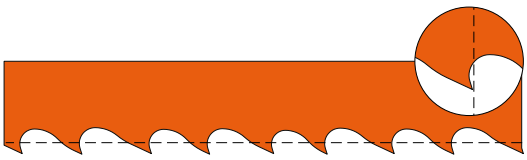
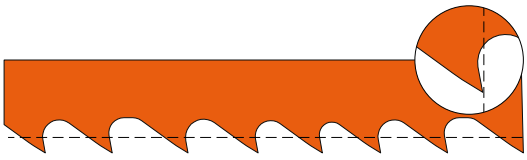
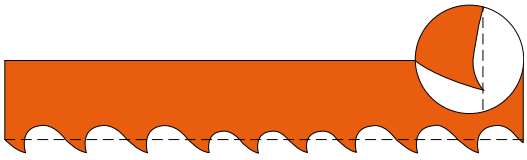
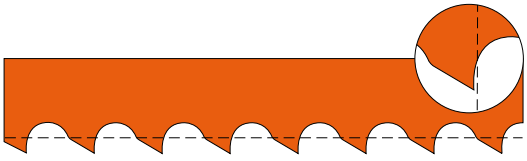
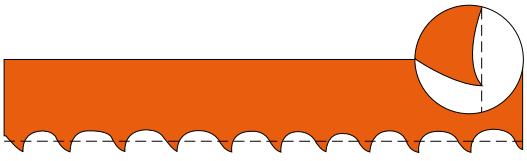
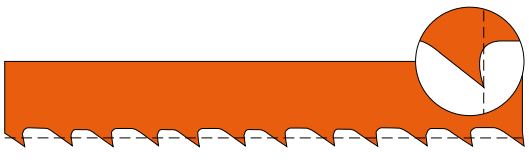
The new Bandsaw Speed & Feed Selector is a good guide to select the correct speed and feed. There is one for Bi-metal- and one for cutting with carbide blades.

BandCalc™ is an interactive computer software program available on CD that quickly determines the best blade for a specific application, based on the users requirements - material to be cut, machine, workpiece etc. Having selected the blade, information on blade speed and feed rate will be supplied. It is an excellent tool for users who wish to improve efficiency. Also it calculates for you the cost per cut, taking into consideration all factors, including the machine cost. BandCalc™ is available in 10 languages.

# Tooth Shape **Guide**

## BI-METAL

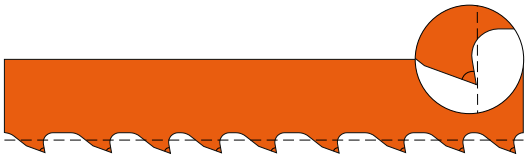
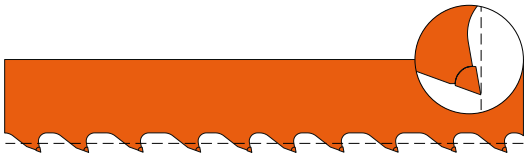
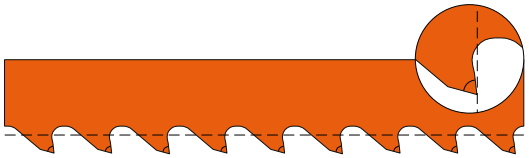
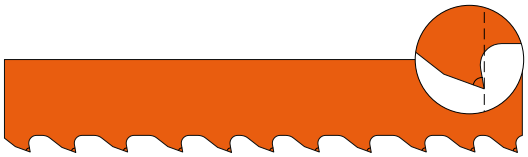
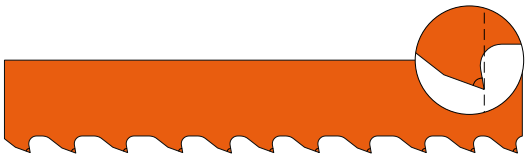
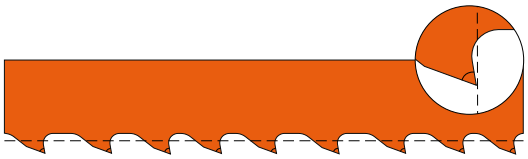
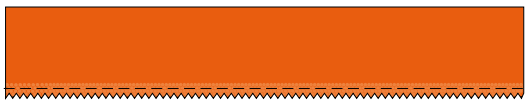
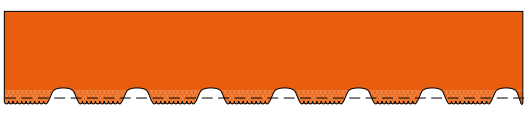
Bahco continuously strive to produce innovative new tooth designs to give maximum band life and efficient cutting.

| | | |
|---|---|---|
| **Combo** | Traditional shape tooth with 0° rake angle. Suitable for multi-purpose cutting of thin-walled tubes and profiles in most materials. |  |
| **Hook** | Traditional tooth design with 10° rake angle, used for non-ferrous metals, wood and plastics. |  |
| **HA** | Development of the traditional Hook design for cutting aluminium in foundry applications. |  |
| **PF** | Specifically designed for cutting bundles of tubes and profiles with excellent capacity and tool life. Very strong tooth with 6 degree positive rake angle. |  |
| **PQ** | Very aggressive 17° positive tooth design intended to give good penetration on difficult to cut material such as stainless steel bearing tube, tool steels and special alloys with work hardening properties. The different set levels produce a multi chip cutting profile which reduces cutting forces and improves blade life. |  |
| **PR** | Innovative "stepped" rake angle giving 10° on 2/3 & 3/4 TPI and 8° on 4/6 and 5/8 TPI. This makes PR a good light production blade cutting small to medium sized workpieces. |  |
| **PS** | High productivity design with a 10-15° rake angle. A high wedge angle and a large gullet space makes it excellent to cut large workpieces. |  |
| **EZ** | This tooth shape is used in the Easy-Cut blades. 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. |  |
| **PSG** | Combo PSG is a ground tooth shape with positive rake angle. It is the ideal toothshape for production cutting medium and large sections of a wide range of materials and especially on alloyed and stainless steels. |  |
| **PHG** | Combo PHG is a patented ground tooth shape with positive rake angle for good penetration of large sections of tough-to-cut alloys and work hardening materials. |  |

# Tooth Shape **Guide**

## CARBIDE

Bahco produce a comprehensive range of set and unset carbide bandsaw blades to ensure we can meet the demands of our production cutting customers.

| | | |
|---|---|---|
| **THQ** | This Multi-chip tooth is designed for cutting Inconel, Waspaloy and titanium. It is wide set as standard, where pinching is a problem and produces 7 chips to reduce cutting forces and increase life. Applications in medium to large size materials. |  |
| **TMC** | This tooth design is used for our unset carbide blade. It has a 7 chip design and excels in difficult to cut alloys on stable machines. |  |
| **TMC-W** | The same as TMC but with a wider set to avoid pinching particularly Inconels with case hardened surfaces. |  |
| **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. |  |
| **TSX** | This triple chip tooth design has a rake angle of 10° and is ideal for cutting large difficult and abrasive materials. The advantage of a set blade is that it is much more forgiving in less stable machines compared with unset blades. This is a unique and patented tooth design. |  |
| **TSS** | Same design as TSX, but pre "run in" at the factory. Designed to remove the need for running in on the machine allowing full speed / feed operation from the first cut in stainless steel. This is a unique and patented tooth design. |  |
| **THS** | Same design as THQ, but with an extremely low noise level. Not suitable in titanium applications. |  |
| **Multi-Grit C Continuous** | Multi-grit is a range of Tungsten Carbide Grit edge band saw blades that have been developed in direct response to industry applications involving an increasing number of complex and abrasive materials. Will cut ceramics, tyres, graphite, fibreglass, cables composite materials, glass hardened steel, super alloys and cast iron. |  |
| **Multi-Grit G Gulleted** | |  |

# Multi-Purpose and Contour Cutting

## 3857 MULTI-PURPOSE EASY-CUT

The generation of Bandsaw blades to meet the requirements of the multi-purpose customer.
Patented tooth form suitable to cut a variety of sizes and materials with just one blade.
In this application this blade achieves double blade life compared with standard blades.

| | Width | Thickness | TPI |
|---|---|---|---|
| 3857-13-0.6-EZ-L | 13 | 0.6 | Large |
| 3857-13-0.6-EZ-M | | | Medium |
| 3857-13-0.6-EZ-S | | | Small |
| 3857-20-0.9-EZ-L | 20 | 0.9 | Large |
| 3857-20-0.9-EZ-M | | | Medium |
| 3857-20-0.9-EZ-S | | | Small |
| 3857-27-0.9-EZ-L | 27 | 0.9 | Large |
| 3857-27-0.9-EZ-M | | | Medium |
| 3857-27-0.9-EZ-S | | | Small |
| 3857-34-1.1-EZ-L | 34 | 1.1 | Large |
| 3857-34-1.1-EZ-M | | | Medium |
| 3857-34-1.1-EZ-S | | | Small |

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

- 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

## 3851 FOR CONTOUR AND SMALL MACHINES

For cutting various types of materials, from aluminium to stainless steels.
Strong tooth design gives maximum cutting performance.
Tooth styles are related to the different applications.

| | Width | Thickness | TPI | Shape |
|---|---|---|---|---|
| 3851-6-0.6-H-6 | 6 | 0.6 | 6 | Hook |
| 3851-6-0.6-10/14 | | | 10/14 | Combo |
| 3851-6-0.9-H-6 | 6 | 0.9 | 6 | Hook |
| 3851-6-0.9-10/14 | | | 10/14 | Combo |
| 3851-10-0.6-H-4 | 10 | 0.6 | 4 | Hook |
| 3851-10-0.6-H-6 | | | 6 | Hook |
| 3851-10-0.6-10/14 | | | 10/14 | Combo |
| 3851-10-0.9-H-4 | 10 | 0.9 | 4 | Hook |
| 3851-10-0.9-H-6 | | | 6 | Hook |
| 3851-10-0.9-10/14 | | | 10/14 | Combo |
| 3851-13-0.6-H-3 | 13 | 0.6 | 3 | Hook |
| 3851-13-0.6-H-4 | | | 4 | Hook |
| 3851-13-0.6-H-6 | | | 6 | Hook |
| 3851-13-0.6-5/8 | | | 5/8 | PR |
| 3851-13-0.6-6/10 | | | 6/10 | Combo |
| 3851-13-0.6-8/12 | | | 8/12 | Combo |
| 3851-13-0.6-10/14 | | | 10/14 | Combo |
| 3851-13-0.9-H-3 | 13 | 0.9 | 3 | Hook |
| 3851-13-0.9-H-4 | | | 4 | Hook |
| 3851-13-0.9-H-6 | | | 6 | Hook |
| 3851-13-0.9-6/10 | | | 6/10 | Combo |
| 3851-13-0.9-10/14 | | | 10/14 | Combo |
| 3851-20-0.9-4/6 | 20 | 0.9 | 4/6 | PR |
| 3851-20-0.9-5/8 | | | 5/8 | PR |
| 3851-20-0.9-6/10 | | | 6/10 | Combo |
| 3851-20-0.9-8/12 | | | 8/12 | Combo |
| 3851-20-0.9-10/14 | | | 10/14 | Combo |
| 3851-27-0.9-2/3 | 27 | 0.9 | 2/3 | PR |
| 3851-27-0.9-3/4 | | | 3/4 | PR |
| 3851-27-0.9-4/6 | | | 4/6 | PR |
| 3851-27-0.9-5/8 | | | 5/8 | PR |
| 3851-27-0.9-6/10 | | | 6/10 | Combo |
| 3851-27-0.9-8/12 | | | 8/12 | Combo |
| 3851-27-0.9-10/14 | | | 10/14 | Combo |

* To order a blade: Product code + length of the blade.
Explanation TOOTHSHAPES on pages 8-9.

# Production Cutting Bi-Metal

## 3851 SANDFLEX® COBRA™

For cutting various types of materials, from aluminium to stainless steels.
Strong tooth design gives maximum cutting performance.
Tooth styles are related to the different applications.

| | Width | Thickness | TPI | Shape |
|---|---|---|---|---|
| 3851-27-0.9-P-3 | 27 | 0.9 | 3 | PS |
| 3851-27-0.9-P-4 | | | 4 | PS |
| 3851-27-0.9-2/3 | | | 2/3 | PR |
| 3851-27-0.9-3/4 | | | 3/4 | PR |
| 3851-27-0.9-4/6 | | | 4/6 | PR |
| 3851-27-0.9-5/8 | | | 5/8 | PR |
| 3851-27-0.9-6/10 | | | 6/10 | Combo |
| 3851-27-0.9-8/12 | | | 8/12 | Combo |
| 3851-27-0.9-10/14 | | | 10/14 | Combo |
| 3851-34-1.1-P-2 | 34 | 1.1 | 2 | PS |
| 3851-34-1.1-P-3 | | | 3 | PS |
| 3851-34-1.1-2/3 | | | 2/3 | PR |
| 3851-34-1.1-3/4 | | | 3/4 | PR |
| 3851-34-1.1-4/6 | | | 4/6 | PR |
| 3851-34-1.1-5/8 | | | 5/8 | PR |
| 3851-34-1.1-6/10 | | | 6/10 | Combo |
| 3851-41-1.3-P-2 | 41 | 1.3 | 2 | PS |
| 3851-41-1.3-2/3 | | | 2/3 | PR |
| 3851-41-1.3-3/4 | | | 3/4 | PR |
| 3851-41-1.3-4/6 | | | 4/6 | PR |
| 3851-41-1.3-5/8 | | | 5/8 | PR |
| 3851-41-1.3-1.4/2 | | | 1.4/2 | PR |
| 3851-54-1.3-2/3 | 54 | 1.3 | 2/3 | PR |
| 3851-54-1.3-3/4 | | | 3/4 | PR |
| 3851-54-1.3-4/6 | | | 4/6 | PR |
| 3851-54-1.6-2/3 | 54 | 1.6 | 2/3 | PR |
| 3851-54-1.6-3/4 | | | 3/4 | PR |
| 3851-54-1.6-1.4/2 | | | 1.4/2 | PR |
| 3851-54-1.6-P-1.25 | | | 1.25 | PS |
| 3851-54-1.6-1/1.4 | | | 1/1.4 | PR |
| 3851-67-1.6-1/1.4 | 67 | 1.6 | 1/1.4 | PS |
| 3851-67-1.6-.7/1 | | | 0.7/1 | PR |
| 3851-80-1.6-1/1.4 | 80 | 1.6 | 1/1.4 | PS |
| 3851-80-1.6-.7/1 | | | 0.7/1 | PS |

## 3851 SANDFLEX® COBRA™ PSG

For production cutting on various types of materials, especially alloyed and stainless steels.
Ground tooth for precise and consistent tooth height.
Precise tooth set for smooth surface finish

| | Width | Thickness | TPI | Shape |
|---|---|---|---|---|
| 3851-27-0.9-PSG-2/3 | 27 | 0.9 | 2/3 | PSG |
| 3851-27-0.9-PSG-3/4 | | | 3/4 | PSG |
| 3851-27-0.9-PSG-4/6 | | | 4/6 | PSG |
| 3851-34-1.1-PSG-2/3 | 34 | 1.1 | 2/3 | PSG |
| 3851-34-1.1-PSG-3/4 | | | 3/4 | PSG |
| 3851-34-1.1-PSG-4/6 | | | 4/6 | PSG |
| 3851-41-1.3-PSG-1.4/2 | 41 | 1.3 | 1.4/2 | PSG |
| 3851-41-1.3-PSG-2/3 | | | 2/3 | PSG |
| 3851-41-1.3-PSG-3/4 | | | 3/4 | PSG |
| 3851-41-1.3-PSG-4/6 | | | 4/6 | PSG |
| 3851-54-1.6-PSG-1.4/2 | 54 | 1.6 | 1.4/2 | PSG |
| 3851-54-1.6-PSG-2/3 | | | 2/3 | PSG |
| 3851-54-1.6-PSG-3/4 | | | 3/4 | PSG |

* To order a blade: Product code + length of the blade.
Explanation TOOTHSHAPES on pages 8-9.

# Production Cutting Bi-Metal

## 3854 SANDFLEX® KING COBRA™PHG™

Developed for cutting harder material. Ground tooth for precise and consistent tooth height.
For high performance cutting of large and difficult to cut work pieces.
Special design in combination with sharp cutting edges for high rate of penetration into the work piece.
HSS tooth edge withstands high heat levels and is wear resistant.

"Be Sharp,
Use Bahco Bandsaws"

| | Width | Thickness | TPI | Shape |
|---|---|---|---|---|
| 3854-27-0.9-PHG-3/4 | 27 | 0.9 | 3/4 | PHG |
| 3854-27-0.9-PHG-4/6 | | | 4/6 | PHG |
| 3854-34-1.1-PHG-2/3 | 34 | 1.1 | 2/3 | PHG |
| 3854-34-1.1-PHG-3/4 | | | 3/4 | PHG |
| 3854-34-1.1-PHG-4/6 | | | 4/6 | PHG |
| 3854-41-1.3-PHG-1.4/2 | 41 | 1.3 | 1.4/2 | PHG |
| 3854-41-1.3-PHG-2/3 | | | 2/3 | PHG |
| 3854-41-1.3-PHG-3/4 | | | 3/4 | PHG |
| 3854-54-1.6-PHG-.7/1 | 54 | 1.6 | 0.7/1 | PHG |
| 3854-54-1.6-PHG-1.4/2 | | | 1.4/2 | PHG |
| 3854-54-1.6-PHG-2/3 | | | 2/3 | PHG |
| 3854-67-1.6-PHG-.7/1 | 67 | 1.6 | 0.7/1 | PHG |
| 3854-67-1.6-PHG-1.4/2 | | | 1.4/2 | PHG |
| 3854-67-1.6-PHG-1/1.4 | | | 1/1.4 | PHG |

## 3854 SANDFLEX® KING COBRA™ PQ

Very positive rake angle allows good penetration into difficult to cut materials.
The wedge angle of 48° gives a strong tooth.
The tooth design improves cutting performance in special alloys with work hardening properties.
The different set levels produce a multi chip cutting profile which reduces cutting forces and improves blade life.

| | Width | Thickness | TPI | Shape |
|---|---|---|---|---|
| 3854-27-0.9-PQ-3/4 | 27 | 0.9 | 3/4 | PQ |
| 3854-34-1.1-PQ-2/3 | 34 | 1.1 | 2/3 | PQ |
| 3854-34-1.1-PQ-3/4 | | | 3/4 | PQ |
| 3854-41-1.3-PQ-1.4/2 | 41 | 1.3 | 1.4/2 | PQ |
| 3854-41-1.3-PQ-2/3 | | | 2/3 | PQ |
| 3854-41-1.3-PQ-3/4 | | | 3/4 | PQ |
| 3854-54-1.6-PQ-.9/1.2 | 54 | 1.6 | 0.9/1.2 | PQ |
| 3854-54-1.6-PQ-1.4/2 | | | 1.4/2 | PQ |
| 3854-54-1.6-PQ-2/3 | | | 2/3 | PQ |
| 3854-54-1.6-PQ-3/4 | | | 3/4 | PQ |
| 3854-67-1.6-PQ-.9/1.2 | 67 | 1.6 | 0.9/1.2 | PQ |
| 3854-67-1.6-PQ-1.4/2 | | | 1.4/2 | PQ |
| 3854-67-1.6-PQ-2/3 | | | 2/3 | PQ |

* To order a blade: Product code + length of the blade.
Explanation TOOTHSHAPES on pages 8-9.

## 3868 CARBIDE TRIPLE SET® "XTRA"™ TSX

For high efficiency cutting of difficult and abrasive materials.
Particularly well suited for materials such as stainless steels, titanium alloys and abrasive tool steels.
The triple set tooth design and good kerf clearance help eliminate tooth loss.

| | Width | Thickness | TPI | Shape |
|---|---|---|---|---|
| 3868-34-1.1-TSX-2 | 34 | 1.1 | 2 | TSX |
| 3868-34-1.1-TSX-2/3 | | | 2/3 | TSX |
| 3868-34-1.1-TSX-3/4 | | | 3/4 | TSX |
| 3868-41-1.3-TSX-1.6 | 41 | 1.3 | 1.6 | TSX |
| 3868-41-1.3-TSX-1.4/2 | | | 1.4/2 | TSX |
| 3868-41-1.3-TSX-2 | | | 2 | TSX |
| 3868-41-1.3-TSX-2/3 | | | 2/3 | TSX |
| 3868-41-1.3-TSX-3/4 | | | 3/4 | TSX |
| 3868-54-1.3-TSX-1.4/2 | 54 | 1.3 | 1.4/2 | TSX |
| 3868-54-1.6-TSX-1/1.25 | 54 | 1.6 | 1/1.25 | TSX |
| 3868-54-1.6-TSX-1.6 | | | 1.6 | TSX |
| 3868-54-1.6-TSX-1.4/2 | | | 1.4/2 | TSX |
| 3868-54-1.6-TSX-2 | | | 2 | TSX |
| 3868-54-1.6-TSX-2/3 | | | 2/3 | TSX |
| 3868-54-1.6-TSX-3/4 | | | 3/4 | TSX |
| 3868-67-1.6-TSX-.7/1 | 67 | 1.6 | 0.7/1 | TSX |
| 3868-67-1.6-TSX-1/1.25 | | | 1/1.25 | TSX |
| 3868-67-1.6-TSX-1.4/2 | | | 1.4/2 | TSX |
| 3868-80-1.6-TSX-.7/1 | 80 | 1.6 | 0.7/1 | TSX |

## 3868 CARBIDE TSS

For high efficiency cutting of difficult and abrasive materials.
Designed specifically for cutting stainless steel where vibration is a problem. This blade is pre "run in" using a patented method eliminating vibration from the first cut. The triple set tooth design and good kerf clearance help eliminate tooth loss. Same design as TSX, but with an extremely low noise level. Very suitable in stainless steel applications.

| | Width | Thickness | TPI | Shape |
|---|---|---|---|---|
| 3868-41-1.3-TSS-1.4/2 | 41 | 1.3 | 1.4/2 | TSS |
| 3868-41-1.3-TSS-2/3 | | | 2/3 | TSS |
| 3868-54-1.6-TSS-1/1.25 | 54 | 1.6 | 1/1.25 | TSS |
| 3868-54-1.6-TSS-1.4/2 | | | 1.4/2 | TSS |
| 3868-67-1.6-TSS-1/1.25 | 67 | 1.6 | 1/1.25 | TSS |

## 3881 CARBIDE THQ (Triple High Quad)

Developed for special alloys, particularly where closure is a problem.

| | Width | Thickness | TPI | Shape |
|---|---|---|---|---|
| 3881-34-1.1-THQ-2/3 | 34 | 1.1 | 2/3 | THQ |
| 3881-41-1.3-THQ-1.4/2 | 41 | 1.3 | 1.4/2 | THQ |
| 3881-41-1.3-THQ-2/3 | | | 2/3 | THQ |
| 3881-54-1.6-THQ-1.4/2 | 54 | 1.6 | 1.4/2 | THQ |
| 3881-54-1.6-THQ-2/3 | | | 2/3 | THQ |
| 3881-67-1.6-THQ-1.4/2 | 67 | 1.6 | 1.4/2 | THQ |
| 3881-80-1.6-THQ-1/1.25 | 80 | 1.6 | 1/1.25 | THQ |

* To order a blade: Product code + length of the blade.
Explanation TOOTHSHAPES on pages 8-9.

# Production Cutting Carbide

## 3881 CARBIDE THS

Same design as THQ, but with an extremely low noise level. Not suitable in titanium applications.

| | Width | Thickness | TPI | Shape |
|---|---|---|---|---|
| 3881-41-1.3-THS-1.4/2 | 41 | 1.3 | 1.4/2 | THS |
| 3881-54-1.6-THS-1/1.25 | 54 | 1.6 | 1/1.25 | THS |
| 3881-54-1.6-THS-1.4/2 | | | 1.4/2 | THS |
| 3881-67-1.6-THS-1/1.25 | 67 | 1.6 | 1/1.25 | THS |
| 3881-67-1.6-THS-1.4/2 | | | 1.4/2 | THS |
| 3881-80-1.6-THS-.7/1 | 80 | 1.6 | 0.7/1 | THS |

## 3860 TMC

For high efficiency cutting of difficult and abrasive materials. This unset carbide blade is very well suited for materials such as stainless steels, titanium and abrasive tool steels.

| | Width | Thickness | TPI | Shape |
|---|---|---|---|---|
| 3860-41-1.3-TMC-1.4/2 | 41 | 1.3 | 1.4/2 | TMC |
| 3860-54-1.6-TMC-1/1.25 | 54 | 1.6 | 1/1.25 | TMC |
| 3860-54-1.6-TMC-1.4/2 | | | 1.4/2 | TMC |
| 3860-54-1.6-TMC-1.4/2-W | | | 1.4/2 | TMCW |
| 3860-67-1.6-TMC-1/1.25 | 67 | 1.6 | 1/1.25 | TMC |
| 3860-67-1.6-TMC-1.4/2 | | | 1.4/2 | TMC |
| 3860-67-1.6-TMC-1.4/2-W | | | 1.4/2 | TMCW |
| 3860-80-1.6-TMC-.7/1 | 80 | 1.6 | 0.7/1 | TMC |

## 3866 CARBIDE GRIT EDGE

Multi-grit, a carbide grit edged bandsaw blade for cutting complex and abrasive materials. Four different carbide grit sizes. Available as gulleted or continuous cutting edge. Available in standard widths and sizes. Reversibility extends tool life by up to 25%. No teeth to snag or strip. Will cut ceramics, tyres, graphite, fibreglass, cables composite materials, glass hardened steel, super alloys and cast iron.

| | Width | Thickness | Shape |
|---|---|---|---|
| 3866-6-0.5-G-F | 6 | 0.5 | G F |
| 3866-10-0.6-G-M | 10 | 0.65 | G M |
| 3866-10-0.6-G-MC | | | G MC |
| 3866-13-0.6-C-M | 13 | 0.65 | C M |
| 3866-13-0.6-G-M | | | G M |
| 3866-13-0.6-G-MC | | | G MC |
| 3866-20-0.8-G-M | 20 | 0.8 | G M |
| 3866-20-0.8-G-MC | | | G MC |
| 3866-27-0.9-C-M | 27 | 0.9 | C M |
| 3866-27-0.9-C-MC | | | C MC |
| 3866-27-0.9-G-C | | | G C |
| 3866-27-0.9-G-MC | | | G MC |
| 3866-34-1.1-G-C | 34 | 1.1 | G C |
| 3866-41-1.3-G-C | 41 | 1.3 | G C |
| 3866-54-1.6-G-C | 54 | 1.6 | G C |

4 different grit edge styles:
**F =** Fine
**M =** Medium
**MC** = Medium Course
**C =** Coarse

Blade type:
**C** = Continuous
**G** = Gulleted

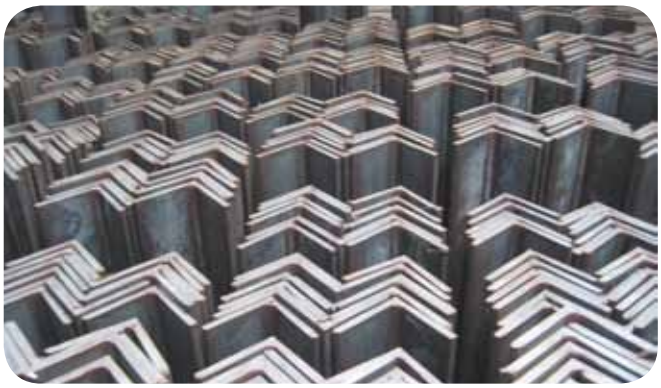
* To order a blade: Product code + length of the blade.
Explanation TOOTHSHAPES on pages 8-9.

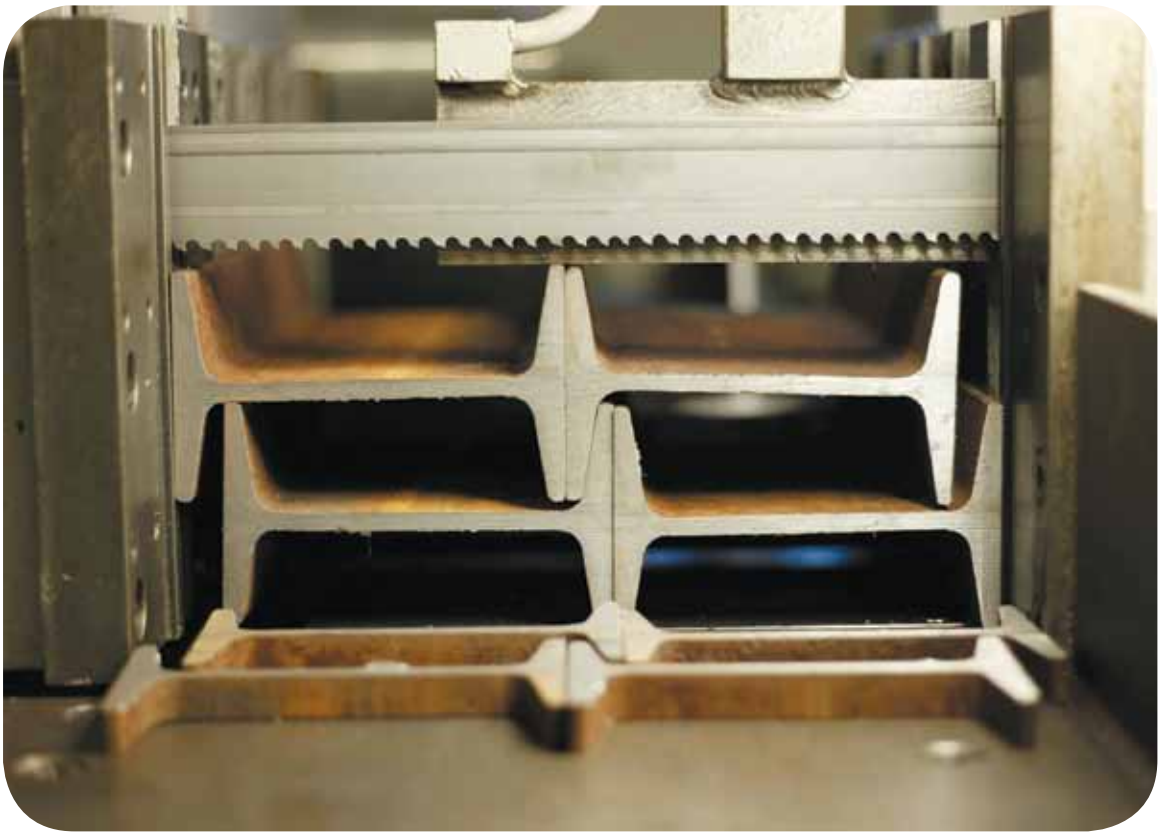
# Cutting of **Tubes and Profiles**

## 3853 SANDFLEX® TOP FABRICATOR

For cutting of structural steels, tubes and profiles in bundles or singularly.
Precise tooth set for smooth surface finish.

| | Width | Thickness | TPI | Shape |
|---|---|---|---|---|
| 3853-27-0.9-3/4 | 27 | 0.9 | 3/4 | PF |
| 3853-27-0.9-4/6 | | | 4/6 | PF |
| 3853-27-0.9-5/8 | | | 5/8 | PF |
| 3853-34-1.1-2/3 | 34 | 1.1 | 2/3 | PF |
| 3853-34-1.1-3/4 | | | 3/4 | PF |
| 3853-34-1.1-4/6 | | | 4/6 | PF |
| 3853-34-1.1-5/8 | | | 5/8 | PF |
| 3853-41-1.3-2/3 | 41 | 1.3 | 2/3 | PF |
| 3853-41-1.3-3/4 | | | 3/4 | PF |
| 3853-41-1.3-4/6 | | | 4/6 | PF |
| 3853-41-1.3-5/8 | | | 5/8 | PF |
| 3853-54-1.6-2/3 | 54 | 1.6 | 2/3 | PF |
| 3853-54-1.6-3/4 | | | 3/4 | PF |
| 3853-54-1.6-4/6 | | | 4/6 | PF |
| 3853-67-1.6-2/3 | 67 | 1.6 | 2/3 | PF |
| 3853-67-1.6-3/4 | | | 3/4 | PF |





* To order a blade: Product code + length of the blade.
Explanation TOOTHSHAPES on pages 8-9.

# Foundry Cutting

## 3851 SANDFLEX® COBRA™

For cutting non-ferrous and abrasive materials.
Special tooth design for foundry use.

| | Width | Thickness | TPI | Shape |
|---|---|---|---|---|
| 3851-13-0.6-HA-4 | 13 | 0.6 | 4 | HA |
| 3851-13-0.6-HA-6 | | | 6 | HA |
| 3851-13-0.9-HA-4 | 13 | 0.9 | 4 | HA |
| 3851-20-0.9-HA-3 | 20 | 0.9 | 3 | HA |
| 3851-27-0.9-HA-2 | 27 | 0.9 | 2 | HA |
| 3851-27-0.9-HA-3 | | | 3 | HA |

## 3869 CARBIDE TRIPLE SET®

For cutting non-ferrous and abrasive materials.
Perfect for aluminium gates and risers, magnesium, zirconium, plastics and other abrasive materials.
Special design for foundry use; fast cutting and easy feeding.

| | Width | Thickness | TPI | Shape |
|---|---|---|---|---|
| 3869-13-0.9-TS-3 | 13 | 0.9 | 3 | TS |
| 3869-20-0.9-TS-3 | 20 | 0.9 | 3 | TS |
| 3869-20-0.9-TS-4 | | | 4 | TS |
| 3869-27-0.9-TS-3 | 27 | 0.9 | 3 | TS |
| 3869-27-0.9-TS-4 | | | 4 | TS |
| 3869-29-1.1-TS-2 | 29 | 1.1 | 2 | TS |
| 3869-34-1.1-TS-3 | 34 | 1.1 | 3 | TS |

# Packaging Information

**Minimum number of loops per packaging / Bi-metal and Carbide 3866, 3868, 3869, 3881, 3860**

| WIDTH | | LENGTH, MM/FT | | | | |
|---|---|---|---|---|---|---|
| MM | INCHES | ≤3000<br>≤9' – 10" | 3001 – 3660<br>9'10" – 12'0" | 3661 – 4120<br>12'1" – 13'6" | 4121 – 5334<br>13'7" – 17'5" | ≥5335<br>≥17'5" |
| ≤13 | ≤1/2 | 5 | 5 | 5 | 5 | 5 |
| 16-27 | 5/8-1 | 5 | 5 | 2 | 2 | 2 |
| 34 | 1-1/4 | 2 | 2 | 2 | 2 | 2 |
| 41-80 | 1-1/2 – 3-1/8 | 2 | 2 | 2 | 2 | 2 |

**Coil packaging**

| WIDTH | | LENGTH, MM/FT | | | |
|---|---|---|---|---|---|
| MM | INCHES | 76<br>250' | 50<br>164' | 30<br>100' | 15<br>50' |
| ≤20 | ≤3/4 | X | - | X | X |
| 27-34 | 1 – 1-1/4 | X | - | - | - |
| ≥41 | ≥1-1/2 | - | X | - | - |

Coil packaging / Carbide 3866, 3868 and 3869, 3881, 3860 – all sizes random coil, approximately 55 m (180 ft) in length.

* To order a blade: Product code + length of the blade.
Explanation TOOTHSHAPES on pages 8-9.

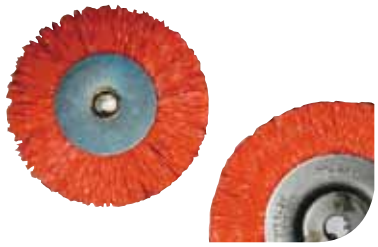
# Trouble Shooting Chart

| | Important Facts | Band breakage | Crooked sawing | Tooth breakage | Rough surface | Rapid tooth wear | Vibration | Band slips on wheel |
|---|---|---|---|---|---|---|---|---|
| MACHINE | **Guides and Guidearms**<br>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 too wide | Guides too far apart, worn out, or poorly adjusted Guidearm loose | | | | Guides poorly adjusted | |
| | **Band Wheels**<br>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 worn out |
| | **Chip Brush**<br>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**<br>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**<br>Needed 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**<br>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 or slightly low | |
| | **Feed Rate**<br>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**<br>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**<br>Every tooth shape has its ideal application. | | | Tooth shape too weak | | Wrong tooth shape selection | Use combo | |
| | **Running In**<br>A new bandsaw blade should be run 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**<br>All blades wear out eventually. Look for signs of wear. | | Blade worn out | | Blade worn out | | | Blade worn out |
| WORKPIECE | **Surface**<br>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**<br>Securely clamp work pieces, especially when bundle cutting. Do not use bent or damaged work pieces. | | | Work piece moves | | | Work piece not properly clamped | |

# Sawing Aids

## 3870 - BRUSH

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



| | Pack Qty. | Weight g |
|---|---|---|
| 3870-BRUSH-60-6 | 4 | 50 |
| 3870-BRUSH-80-6 | 4 | 50 |
| 3870-BRUSH-80-8 | 4 | 50 |
| 3870-BRUSH-80-10 | 4 | 50 |
| 3870-BRUSH-100-10 | 4 | 130 |
| 3870-BRUSH-100-12 | 4 | 130 |

## 3870 - WEDGE

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 whilst cutting.

| | Pack Qty. | Weight g |
|---|---|---|
| 3870-WEDGE-3 | 5 | 60 |

## 3870 - GLOVE

A general purpose work glove. Available in packs of 12.

| | Pack Qty. | Weight g |
|---|---|---|
| 3870-GLOVE | 12 | 223 |

## 3870 - TACHOMETER

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

| | Pack Qty. | Weight g |
|---|---|---|
| 3870-TACHOMETER | 1 | 400 |

## 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 correct blade tension of all bandsaws.

| | Pack Qty. | Weight g |
|---|---|---|
| 3870-TENSIONMETER | 1 | 680 |

## 3870 - REFRACTOMETER

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

| | Pack Qty. | Weight g |
|---|---|---|
| 3870-REFRACTOMETER | 1 | 260 |

## 3870 - BANDCALC™

BandCalc™ is an interactive computer software program available on CD that quickly determines the best bandsaw for a specific application based on the users requirements - material to be cut, machine, workpiece, etc.

| | Pack Qty. | Weight g |
|---|---|---|
| 3870-BANDCALC | 1 | 45 |

## 3870 - SAFETY GLASSES

Sleek and sporty glasses designed for safety and comfort.

| | Pack Qty. | Weight g |
|---|---|---|
| 3870-SAFETYGLASSES | 12 | 45 |

# Holesaws

## HOLESAWS DESIGNED **FOR PROFESSIONAL USE**

Bahco holesaws set a new standard in precision, quality, durability and versatility.
So no matter what you are cutting through, we have the holesaws and arbors to tackle the job, time after time.

Every aspect of a Bahco holesaw is engineered to improve a worker's productivity and craftsmanship from the design of the cutting edges to the technologies used to produce the holesaws. Bahco holesaws fit all standard portable drills and drill presses.

### BI-METAL HOLESAWS

- Create clean, accurate holes in most machinable materials
- High speed cutting edge is laser welded to tough steel alloy back
- Knockout holes allow easy core removal
- Diameters from 9/16" to 8.1/4”. From 14 mm to 210 mm
- Cutting depth for all diameters is 1 1/2". 38 mm

### CARBIDE-TIPPED HOLESAWS

- Carbide saws cut clean holes in ceramics, brick, slate, laminate, fibreglass and hardwood
- Carbide tips are fusion welded to the backing material
- Knockout holes allow easy core removal
- Diameters from 9/16" to 6”. From 14 mm to 152 mm
- Cutting depth for all diameters is 1 1/2”. 38 mm

# Holesaws **System**

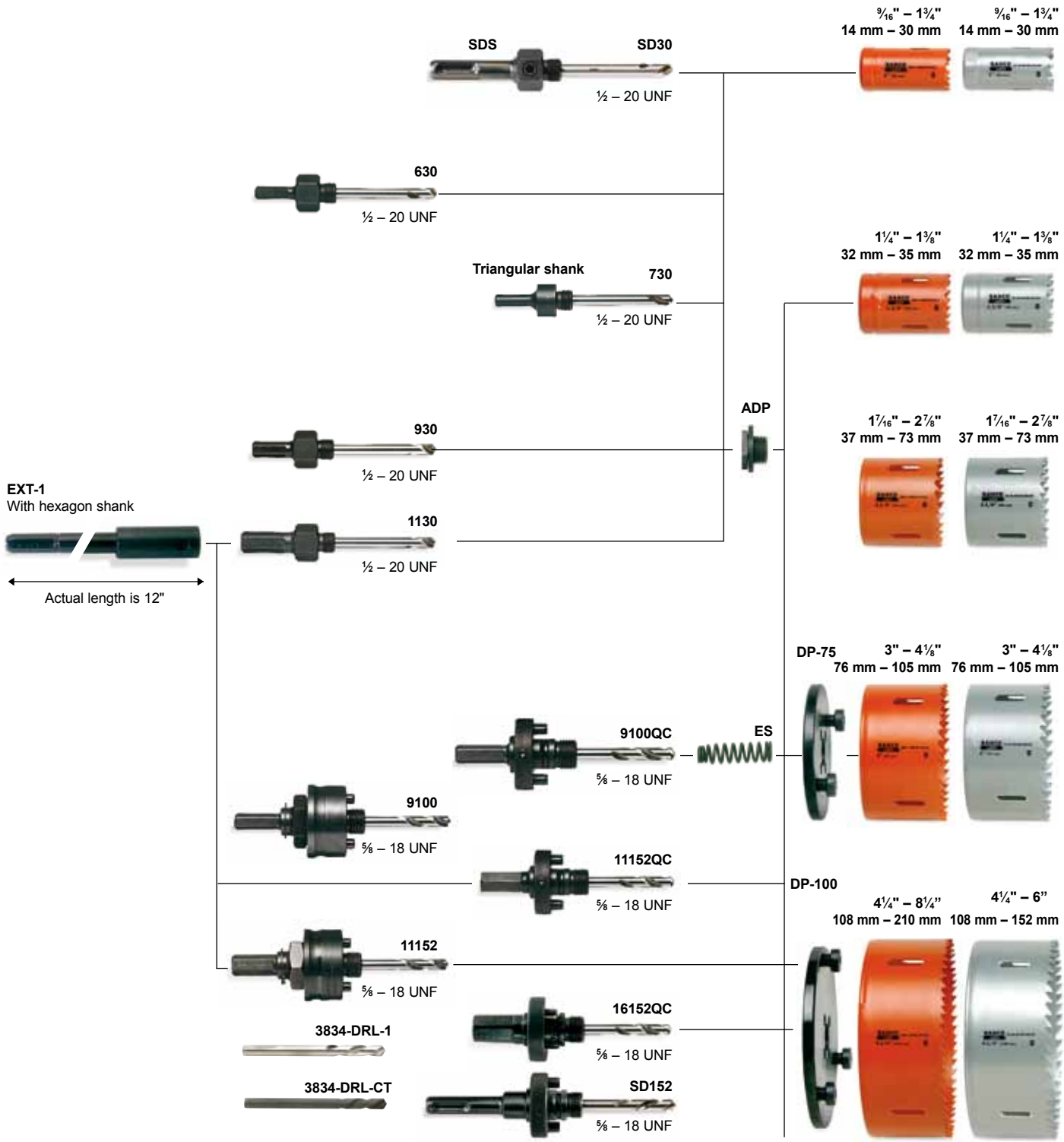
## THE BAHCO **HOLESAW SYSTEM**

### “Sandflex® Bi-Metal Technology
### A visionary solution, still ahead of its time”

A complete line of saws, arbors, drive plates and accessories – everything you need to make perfect holes from 9/16" to 8.1/4” (14 mm to 210 mm).

Designed as a fully interchangeable system, this full line of arbors, arbor extensions, pilot drills, drive plates, ejector springs and adapters maximizes the performance and flexibility of Bahco holesaws.

**Bi-Metal Holesaws** | Carbide Tipped Holesaws



## 3830 SANDFLEX® BI-METAL HOLESAWS

Bahco Sandflex® bi-metal holesaws perform in materials such as wood, plastics, non ferrous and ferrous steel including stainless steel. Fit all power drills, both stationary and portable. Knockout holes allow easy removal of cores. Cutting depth max. 38 mm (1 1/2") 4/6 teeth per inch. All holesaws are packed in a cardboard box with an instruction leaflet enclosed.
Max. holesize = nominal holesaw size +1.5 mm/-0.0 mm extra large size. 168 mm and 210 mm 6 TPI (R6). Cutting depth max. 38 mm. 177 mm 4/6 TPI. Cutting depth max 50 mm.

| | Pack Qty. | mm | inch | Weight g |
|---|---|---|---|---|
| 3830-14-VIP | 6 | 14 | 9/16 | 20 |
| 3830-16-VIP | 6 | 16 | 5/8 | 20 |
| 3830-17-VIP | 6 | 17 | 11/16 | 30 |
| 3830-19-VIP | 6 | 19 | 3/4 | 30 |
| 3830-20-VIP | 6 | 20 | 25/32 | 30 |
| 3830-21-VIP | 6 | 21 | 13/16 | 40 |
| 3830-22-VIP | 6 | 22 | 7/8 | 40 |
| 3830-24-VIP | 6 | 24 | 15/16 | 55 |
| 3830-25-VIP | 6 | 25 | 1 | 55 |
| 3830-27-VIP | 6 | 27 | 1 1/16 | 70 |
| 3830-29-VIP | 6 | 29 | 1 1/8 | 70 |
| 3830-30-VIP | 6 | 30 | 1 3/16 | 70 |
| 3830-32-VIP | 6 | 32 | 1 1/4 | 70 |
| 3830-33-VIP | 6 | 33 | 1 5/16 | 70 |
| 3830-35-VIP | 6 | 35 | 1 3/8 | 70 |
| 3830-37-VIP | 6 | 37 | 1 7/16 | 80 |
| 3830-38-VIP | 6 | 38 | 1 1/2 | 80 |
| 3830-40-VIP | 6 | 40 | 1 9/16 | 80 |
| 3830-41-VIP | 6 | 41 | 1 5/8 | 80 |
| 3830-43-VIP | 6 | 43 | 1 11/16 | 90 |
| 3830-44-VIP | 6 | 44 | 1 3/4 | 100 |
| 3830-46-VIP | 6 | 46 | 1 13/16 | 100 |
| 3830-48-VIP | 6 | 48 | 1 7/8 | 100 |
| 3830-50-VIP | 6 | 50 | 1 9/10 | 120 |
| 3830-51-VIP | 6 | 51 | 2 | 120 |
| 3830-52-VIP | 4 | 52 | 2 1/16 | 120 |
| 3830-54-VIP | 4 | 54 | 2 1/8 | 140 |
| 3830-55-VIP | 4 | 55 | 2 1/12 | 160 |
| 3830-56-VIP | 4 | 56 | 2 3/16 | 140 |
| 3830-57-VIP | 4 | 57 | 2 1/4 | 140 |
| 3830-59-VIP | 4 | 59 | 2 5/16 | 140 |
| 3830-60-VIP | 4 | 60 | 2 3/8 | 160 |
| 3830-62-VIP | 4 | 62 | 2 7/16 | 160 |
| 3830-64-VIP | 4 | 64 | 2 1/2 | 180 |
| 3830-65-VIP | 4 | 65 | 2 9/16 | 180 |
| 3830-67-VIP | 4 | 67 | 2 5/8 | 200 |
| 3830-68-VIP | 4 | 68 | 2 11/16 | 220 |
| 3830-70-VIP | 4 | 70 | 2 3/4 | 220 |
| 3830-73-VIP | 4 | 73 | 2 7/8 | 220 |
| 3830-76-VIP | 4 | 76 | 3 | 240 |
| 3830-79-VIP | 4 | 79 | 3 1/8 | 260 |
| 3830-83-VIP | 4 | 83 | 3 1/4 | 260 |
| 3830-86-VIP | 4 | 86 | 3 3/8 | 260 |
| 3830-89-VIP | 4 | 89 | 3 1/2 | 270 |
| 3830-92-VIP | 4 | 92 | 3 5/8 | 270 |
| 3830-95-VIP | 4 | 95 | 3 3/4 | 270 |
| 3830-98-VIP | 4 | 98 | 3 7/8 | 300 |
| 3830-102-VIP | 4 | 102 | 4 | 320 |
| 3830-105-VIP | 4 | 105 | 4 1/8 | 320 |
| 3830-108-VIP | 4 | 108 | 4 1/4 | 350 |
| 3830-111-VIP | 4 | 111 | 4 3/8 | 350 |
| 3830-114-VIP | 4 | 114 | 4 1/2 | 360 |
| 3830-121-VIP | 1 | 121 | 4 3/4 | 410 |
| 3830-127-VIP | 1 | 127 | 5 | 520 |
| 3830-133-VIP | 1 | 133 | 5 1/4 | 560 |
| 3830-140-VIP | 1 | 140 | 5 1/2 | 560 |
| 3830-146-VIP | 1 | 146 | 5 3/4 | 570 |
| 3830-152-VIP | 1 | 152 | 6 | 610 |
| 3830-177-HIGH | 1 | 177 | 7 | 1340 |
| 3830-210 | 1 | 210 | 8 1/4 | 750 |


## 3832 CARBIDE **HOLESAWS**

Bahco carbide tipped holesaws are capable of cutting through brick and ceramic tiles, laminate, fibreglass and harrwood as well as difficult to cut steel applications.
Fit all power drills, both stationary and portable. Knockout holes allow easy removal of cores.
Cutting depth 38 mm (1 1/2”), ground teeth, 4 TPI. Max. holesize = nominal holesaw size +1.5 mm / - 0.0 mm.

| | Pack Qty. | mm | inch | Weight g |
|---|---|---|---|---|
| 3832-14 | 6 | 14 | 9/16 | 20 |
| 3832-16 | 6 | 16 | 5/8 | 20 |
| 3832-17 | 6 | 17 | 11/16 | 30 |
| 3832-19 | 6 | 19 | 3/4 | 30 |
| 3832-20 | 6 | 20 | 6/8 | 30 |
| 3832-21 | 6 | 21 | 13/16 | 40 |
| 3832-22 | 6 | 22 | 7/8 | 40 |
| 3832-24 | 6 | 24 | 15/16 | 55 |
| 3832-25 | 6 | 25 | 1 | 55 |
| 3832-27 | 6 | 27 | 1 1/16 | 70 |
| 3832-29 | 6 | 29 | 1 1/8 | 70 |
| 3832-30 | 6 | 30 | 1 3/16 | 70 |
| 3832-32 | 6 | 32 | 1 1/4 | 70 |
| 3832-33 | 6 | 33 | 1 5/16 | 70 |
| 3832-35 | 6 | 35 | 1 3/8 | 70 |
| 3832-37 | 6 | 37 | 1 7/16 | 80 |
| 3832-38 | 6 | 38 | 1 1/2 | 80 |
| 3832-40 | 6 | 40 | 1 9/16 | 80 |
| 3832-41 | 6 | 41 | 1 5/8 | 80 |
| 3832-43 | 6 | 43 | 1 11/16 | 90 |
| 3832-44 | 6 | 44 | 1 3/4 | 100 |
| 3832-46 | 6 | 46 | 1 13/16 | 100 |
| 3832-48 | 6 | 48 | 1 7/8 | 100 |
| 3832-51 | 6 | 51 | 2 | 120 |
| 3832-52 | 4 | 52 | 2 1/16 | 120 |
| 3832-54 | 4 | 54 | 2 1/8 | 140 |
| 3832-56 | 4 | 56 | 2 1/4 | 140 |
| 3832-57 | 4 | 57 | 2 1/4 | 140 |
| 3832-59 | 4 | 59 | 2 5/16 | 140 |
| 3832-60 | 4 | 60 | 2 3/8 | 160 |
| 3832-64 | 4 | 64 | 2 1/2 | 180 |
| 3832-65 | 4 | 65 | 2 9/16 | 180 |
| 3832-67 | 4 | 67 | 2 5/8 | 200 |
| 3832-68 | 4 | 68 | 2 11/16 | 220 |
| 3832-70 | 4 | 70 | 2 3/4 | 220 |
| 3832-73 | 4 | 73 | 2 7/8 | 220 |
| 3832-76 | 4 | 76 | 3 | 240 |
| 3832-79 | 4 | 79 | 3 1/8 | 260 |
| 3832-83 | 4 | 83 | 3 1/4 | 260 |
| 3832-86 | 4 | 86 | 3 3/8 | 260 |
| 3832-89 | 4 | 89 | 3 1/2 | 270 |
| 3832-92 | 4 | 92 | 3 5/8 | 270 |
| 3832-95 | 4 | 95 | 3 3/4 | 270 |
| 3832-98 | 4 | 98 | 3 7/8 | 300 |
| 3832-102 | 4 | 102 | 4 | 320 |
| 3832-105 | 4 | 105 | 4 1/8 | 320 |
| 3832-108 | 4 | 108 | 4 1/4 | 350 |
| 3832-111 | 4 | 111 | 4 3/8 | 350 |
| 3832-114 | 4 | 114 | 4 1/2 | 360 |
| 3832-121 | 1 | 121 | 4 3/4 | 410 |
| 3832-127 | 1 | 127 | 5 | 520 |
| 3832-133 | 1 | 133 | 5 1/4 | 560 |
| 3832-140 | 1 | 140 | 5 1/2 | 560 |
| 3832-146 | 1 | 146 | 5 3/4 | 570 |
| 3832-152 | 1 | 152 | 6 | 610 |



# Bahco Holesaws **Sets**

**Assortments of most holesaws and accessories most commonly used by the trades, especially electricians and plumbers.**

## 11 Piece Holesaw **SET 3834-SET-103**

| Includes: | |
|---|---|
| Holesaws: | 3830-16-VIP 16 mm 5/8" |
| | 3830-19-VIP 19 mm 3/4" |
| | 3830-24-VIP 24 mm 15/16 |
| | 3830-29-VIP 29 mm 1 1/8" |
| | 3830-38-VIP 38 mm 1 1/2" |
| | 3830-44-VIP 44 mm 1 3/4" |
| | 3830-57-VIP 57 mm 2 1/4" |
| | 3830-67-VIP 67 mm 2 5/8" |
| Arbors: | 3834-ARBR-1130 (14-30 mm) |
| | 3834-ARBR-11152 (32-210 mm) |
| Pilot drill: | 3834-DRL |

## 8 Piece Holesaw **SET 3834-SET-62**

| Includes: | |
|---|---|
| Holesaws: | 3830-19-VIP 19 mm 3/4" |
| | 3830-21-VIP 21 mm 13/16" |
| | 3830-22-VIP 22 mm 7/8" |
| | 3830-29-VIP 29 mm 1 1/8" |
| | 3830-38-VIP 38 mm 1 1/2" |
| | 3830-48-VIP 48 mm 1 7/8" |
| Arbors: | 3834-ARBR-930 (14-30 mm) |
| | 3834-ARBR-9100 (32-100 mm) |

## 6 Piece Holesaw **SET 3834-SET-42**

| Includes: | |
|---|---|
| Holesaws: | 3830-51-VIP 51 mm 2" |
| | 3830-76-VIP 76 mm 3" |
| | 3830-86-VIP 86 mm 3 3/8" |
| | 3830-111-VIP 111 mm 4 3/8" |
| Arbors and accessories: | 3834-ARBR-9100 (32-100 mm) |
| | 3834-ES - Ejector spring |

## 8 Piece Holesaw **SET 3834-SET-62-16/50**

| Includes: | |
|---|---|
| Holesaws: | 3830-16-VIP 16 mm 5/8" |
| | 3830-20-VIP 20 mm 25/32" |
| | 3830-25-VIP 25 mm 1" |
| | 3830-32-VIP 32 mm 1 1/4" |
| | 3830-40-VIP 40 mm 1 9/16" |
| | 3830-50-VIP 50 mm 2" |
| Arbors: | 3834-ARBR-930 (14-30 mm) |
| | 3834-ARBR-9100 (32-100 mm) |

## 13 Piece Holesaw **SET 3834-SET-53**

| Includes: | |
|---|---|
| Holesaws: | 3830-19-VIP 19 mm 3/4" |
| | 3830-22-VIP 22 mm 7/8" |
| | 3830-25-VIP 25 mm 1" |
| | 3830-29-VIP 29 mm 1 1/8" |
| | 3830-30-VIP 30 mm 1 3/16" |
| | 3830-35-VIP 35 mm 1 3/8" |
| | 3830-37-VIP 37 mm 1 7/16" |
| | 3830-41-VIP 41 mm 1 5/8" |
| | 3830-52-VIP 52 mm 2 1/16" |
| | 3830-60-VIP 60 mm 2 3/8" |
| | 3830-79-VIP 79 mm 3 1/8 |
| Arbors: | 3834-ARBR-930 (14-30 mm) |
| | 3834-ARBR-9100 (32-100 mm) |

## 11 Piece Holesaw **SET 3834-SET-65-16/51**

| Includes: | |
|---|---|
| Holesaws: | 3830-16-VIP 16 mm 5/8" |
| | 3830-20-VIP 20 mm 25/32" |
| | 3830-25-VIP 25 mm 2" |
| | 3830-32-VIP 32 mm 1 1/4" |
| | 3830-40-VIP 40 mm 1 9/16" |
| | 3830-51-VIP 51 mm 2" |
| Arbors: | 3834-ARBR-1130 (14-30 mm) |
| | 3834-ARBR-11152 (32-210 mm) |
| Pilot drill and accesories: | 3834-DRL |
| | Hexagonal key |
| | Chip brush |

## 7 Piece Holesaw **SET 3834-SET-61**

| Includes: | |
|---|---|
| Holesaws: | 3830-44-VIP 44 mm 1 3/4" |
| | 3830-51-VIP 51 mm 2" |
| | 3830-57-VIP 57 mm 2 1/4" |
| | 3830-73-VIP 73 mm 2 7/8" |
| | 3830-86-VIP 86 mm 3 3/8" |
| | 3830-114-VIP 114 mm 4 1/2" |
| Arbors: | 3834-ARBR-9100 (32-100 mm) |

## 11 Piece Holesaw **SET 3834-SET-65-22/64**

| Includes: | |
|---|---|
| Holesaws: | 3830-22-VIP 22 mm 7/8" |
| | 3830-29-VIP 29 mm 1 1/8" |
| | 3830-35-VIP 35 mm 1 3/8" |
| | 3830-44-VIP 44 mm 1 3/4" |
| | 3830-51-VIP 51 mm 2" |
| | 3830-64-VIP 64 mm 2 1/2" |
| Arbors: | 3834-ARBR-1130 (14-30 mm) |
| | 3834-ARBR-11152 (32-210 mm) |
| Pilot drill: | 3834-DRL |

# Bahco Holesaws **Sets**

## 9 Piece Holesaw **SET 3834-SET-72**

| Includes: | |
|---|---|
| Holesaws: | 3830-19-VIP 19 mm 3/4" |
| | 3830-22-VIP 22 mm 7/8" |
| | 3830-29-VIP 29 mm 1 1/8" |
| | 3830-35-VIP 35 mm 1 3/8" |
| | 3830-44-VIP 44 mm 1 3/4" |
| | 3830-51-VIP 51 mm 2" |
| | 3830-64-VIP 64 mm 2 1/2" |
| Arbors: | 3834-ARBR-930 (14-30 mm) |
| | 3834-ARBR-9100 (32-100 mm) |

## 9 Piece Holesaw **SET 3834-SET-73**

| Includes: | |
|---|---|
| Holesaws: | 3830-16-VIP 16 mm 5/8" |
| | 3830-22-VIP 22 mm 7/8" |
| | 3830-51-VIP 51 mm 2" |
| | 3830-57-VIP 57 mm 2 1/4" |
| | 3830-73-VIP 73 mm 2 7/8" |
| | 3830-76-VIP 76 mm 3" |
| | 3830-92-VIP 92 mm 3 5/8" |
| Arbors: | 3834-ARBR-930 (14-30 mm) |
| | 3834-ARBR-9100 (32-100 mm) |

## 10 Piece Holesaw **SET 3834-SET-73-22/68**

| Includes: | |
|---|---|
| Holesaws: | 3830-22-VIP 22 mm 7/8" |
| | 3830-29-VIP 29 mm 1 1/8" |
| | 3830-35-VIP 35 mm 1 3/8" |
| | 3830-44-VIP 44 mm 1 3/4" |
| | 3830-51-VIP 51 mm 2" |
| | 3830-64-VIP 64 mm 2 1/2" |
| | 3830-68-VIP 68 mm 2 11/16" |
| Arbors: | 3834-ARBR-930 (14-30 mm) |
| | 3834-ARBR-9100 (30-100 mm) |
| Pilot drill: | 3834-DRL |

## 12 Piece Holesaw **SET 3834-SET-86**

| Includes: | |
|---|---|
| Holesaws: | 3830-25-VIP 25 mm 1" |
| | 3830-32-VIP 32 mm 1 1/4" |
| | 3830-35-VIP 35 mm 1 3/8" |
| | 3830-51-VIP 51 mm 2" |
| | 3830-54-VIP 54 mm 2 1/8" |
| | 3830-76-VIP 76 mm 3" |
| | 3830-92-VIP 92 mm 3 5/8" |
| | 3830-114-VIP 114 mm 4 1/2" |
| Arbors: | 3834-ARBR-1130 (14-30 mm) |
| | 3834-ARBR-11152 (32-210 mm) |
| Pilot drill and accesories: | 3834-DRL |
| | Hexagonal key |
| Adapter: | 3834-ADP |

## 14 Piece Holesaw **SET 3834-SET-87**

| Includes: | |
|---|---|
| Holesaws: | 3830-19-VIP 19 mm 3/4" |
| | 3830-22-VIP 22 mm 7/8" |
| | 3830-29-VIP 29 mm 1 1/8" |
| | 3830-38-VIP 38 mm 1 1/2" |
| | 3830-43-VIP 43 mm 1 3/4" |
| | 3830-48-VIP 48 mm 1 7/8" |
| | 3830-52-VIP 52 mm 2 1/16" |
| | 3830-65-VIP 65 mm 2 9/16" |
| Arbors: | 3834-ARBR-930 (14-30 mm) |
| | 3834-ARBR-9100 (32-100 mm) |
| Pilot drill and accesories: | 3834-DRL |
| | 3834-ES |
| | Hexagonal key |
| | Chip brush |

## 11 Piece Holesaw **SET 3834-SET-92**

| Includes: | |
|---|---|
| Holesaws: | 3830-16-VIP 16 mm 5/8" |
| | 3830-22-VIP 22 mm 7/8" |
| | 3830-25-VIP 25 mm 1" |
| | 3830-29-VIP 29 mm 1 1/8" |
| | 3830-32-VIP 32 mm 1 1/4" |
| | 3830-41-VIP 41 mm 1 5/8" |
| | 3830-51-VIP 51 mm 2" |
| | 3830-73-VIP 73 mm 2 7/8" |
| | 3830-83-VIP 83 mm 3 1/4" |
| Arbors: | 3834-ARBR-930 (14-30 mm) |
| | 3834-ARBR-9100 (32-100 mm) |

## 13 Piece Holesaw **SET 3834-SET-94**

| Includes: | |
|---|---|
| Holesaws: | 3830-16-VIP 16 mm 5/8" |
| | 3830-19-VIP 19 mm 3/4" |
| | 3830-22-VIP 22 mm 7/8" |
| | 3830-25-VIP 25 mm 1" |
| | 3830-30-VIP 30 mm 1 3/16" |
| | 3830-35-VIP 35 mm 1 3/8" |
| | 3830-41-VIP 41 mm 1 5/8" |
| | 3830-51-VIP 51 mm 2" |
| | 3830-67-VIP 67 mm 2 5/8" |
| Arbors: | 3834-ARBR-1130 (14-30 mm) |
| | 3834-ARBR-11152 (32-210 mm) |
| Accesories: | Hexagonal key |
| | Chip brush |

## 13 Piece Holesaw **SET 3834-SET-95**

| Includes: | |
|---|---|
| Holesaws: | 3830-16-VIP 16 mm 5/8" |
| | 3830-19-VIP 19 mm 3/4" |
| | 3830-22-VIP 22 mm 7/8" |
| | 3830-29-VIP 29 mm 1 1/8" |
| | 3830-35-VIP 35 mm 1 3/8" |
| | 3830-44-VIP 44 mm 1 3/4" |
| | 3830-52-VIP 52 mm 2 1/16" |
| | 3830-57-VIP 57 mm 2 1/4" |
| | 3830-64-VIP 64 mm 2 1/2" |
| Arbors: | 3834-ARBR-1130 (14-30 mm) |
| | 3834-ARBR-11152 (32-210 mm) |
| Pilot drill and accesories: | 3834-DRL |
| | Hexagonal key |
| | Chip brush |

## ARBORS FOR HOLESAWS **14-210 mm**

Select an appropriate arbor according to holesaw size and chuck size of drilling equipment.

3834-ARBR-730, for holesaws 14-30 mm, is an arbor with triangular shank and round arbor body. For sturdier design and easier removal of 14-30 mm holesaws select arbors with hexagonal shank and hexagonal body, i.e. 3834-ARBR-630, -930, -1130.

The design of arbors for 32-210 mm holesaws, 3834-ARBR-9100, -11152 and -16152 Power Driver™, eliminates play and increases the strength of the holesaw by redistributing the load from the thread to the solid cap. The Power Driver™ arbors must be used with hand held machines and when operating with high work load in static machines. QC arbors have a quick change mechanism and tools are not required to change holesaws.

All arbors are hardened for maximum strength. Large arbors, for holesaws 32-210 mm, have drive pins to transfer large cutting force from power unit to the holesaw. We recommend not to use arbors with 9 mm (11/32”) shank for holesaws above size 100 mm (4”). An HSS Pilot drill (3834-DRL) is included with all arbors. When cutting in abrasive materials we recommend the use of carbide tipped pilot drill, 3834-DRL-CT.

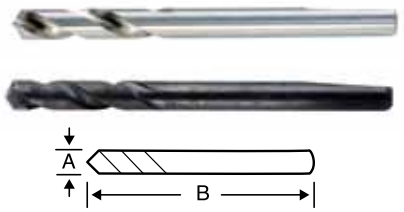
| | Pack Qty. | mm | inch | mm | inch | Weight g |
|---|---|---|---|---|---|---|
| Fits Holesaws 9/16"-1 3/16", 14-30 mm, Industrial Box | | | | | | |
| 3834-ARBR-630 | 1 | 6.4 | 1/4 | 8 | 5/16 | 70 |
| 3834-ARBR-730 | 1 | 6.4 TRI | 1/4 TRI | 8 | 5/16 | 60 |
| 3834-ARBR-930 | 1 | 8.5 | 11/32 | 10 | 3/8 | 80 |
| 3834-ARBR-1130 | 1 | 11.1 | 7/16 | 13 | 1/2 | 90 |
| Fits Holesaws 9/16"-1 3/16", 14-30 mm, Individually Carded | | | | | | |
| 3834-ARBR-630-C | 1 | 6.4 | 1/4 | 8 | 5/16 | 70 |
| 3834-ARBR-730-C | 1 | 6.4 TRI | 1/4 TRI | 8 | 5/16 | 60 |
| 3834-ARBR-930-C | 1 | 8.5 | 11/32 | 10 | 3/8 | 80 |
| 3834-ARBR-1130-C | 1 | 11.1 | 7/16 | 13 | 1/2 | 90 |
| Fits Holesaws 1 1/4"-8 1/4", 32-210 mm, Industrial Box | | | | | | |
| 3834-ARBR-11152 | 1 | 11.1 | 7/16 | 13 | 1/2 | 260 |
| 3834-ARBR-16152 | 1 | 15.4 | 5/8 | 20 | 3/4 | 310 |
| 3834-ARBR-11152QC | 1 | 11.1 | 7/16 | 13 | 1/2 | 250 |
| Fits Holesaws 1 1/4"-8 1/4", 32-210 mm, Individually Carded | | | | | | |
| 3834-ARBR-11152-C | 1 | 11.1 | 7/16 | 13 | 1/2 | 260 |
| 3834-ARBR-11152QC-C | 1 | 11.1 | 7/16 | 13 | 1/2 | 250 |
| Fits Holesaws 1 1/4"-4", 32-100 mm, Industrial Box | | | | | | |
| 3834-ARBR-9100 | 1 | 8.5 | 11/32 | 10 | 3/8 | 250 |
| 3834-ARBR-9100QC | 1 | 8.5 | 11/32 | 10 | 3/8 | 160 |
| Fits Holesaws 1 1/4"-4", 32-100 mm, Individually Carded | | | | | | |
| 3834-ARBR-9100-C | 1 | 8.5 | 11/32 | 10 | 3/8 | 250 |
| 3834-ARBR-9100QC-C | 1 | 8.5 | 11/32 | 10 | 3/8 | 160 |

## OTHER PARTS

**Pilot drill: 3834-DRL**. The HSS pilot drill bores a hole in the workpiece before the teeth of the holesaw become engaged, guiding and keeping the holesaw in the correct position during the sawing operation.
3834-DRL fits all arbors. Standard drill in all arbors.

**Pilot Drill: 3834-DRL-CT.** Carbide tipped pilot drill - Multi purpose CT - drill has a high grade carbide tip with special properties, hardness and geometry. It was specially designed to provide one tool to cover many different materials. It enables high cutting performance in all machinable material from wood and plastic to brick and concrete. Fits all arbors.

| | Pack Qty. | A mm | A inch | B mm | B inch | Weight g |
|---|---|---|---|---|---|---|
| Fits arbors -730, -930, -1130, -9100QC, -11152QC, -16152QC | | | | | | |
| 3834-DRL | 1 | 6.35 | 1/4 | 81 | 3 3/16 | 20 |
| Fits arbors -730, -930, -1130, -9100QC, -11152QC, -16152QC | | | | | | |
| 3834-DRL-CT | 1 | 6.35 | 1/4 | 84 | 3 5/16 | 35 |




**Extension: 3834-EXT**
Extension for difficult to reach applications.

| | Pack Qty. | mm | inch | mm | inch | Weight g |
|---|---|---|---|---|---|---|
| Fits arbors -1130, -11152, -11152QC | | | | | | |
| 3834-EXT-1 | 1 | 11.1 | 7/16 | 330 | 12 | 340 |
| Fits arbors -930, -9100 | | | | | | |
| 3834-EXT-2 | 1 | 8.5 | 11/32 | 330 | 12 | 340 |

**Arbor adaptor: 3834-ADP**
Adapts small arbor thread (1/2”-20 UNF) to accommodate large holesaw thread (5/8”-18 UNF). Not recommended for holesaws larger than 44 mm. 19 mm across the flats.
Fits holesaw 32-44 mm.

| | Pack Qty. | Weight g |
|---|---|---|
| Fits arbors -630, -730, -930, -1130 | | |
| 3834-ADP | 1 | 20 |

**Ejector spring: 3834-ES**
For pilot drills, to facilitate core removal.

| | Pack Qty. | Weight g |
|---|---|---|
| Fits pilot Drill 3834-DRL-US | | |
| 3834-ES | 1 | 10 |

**Morse taper adaptors: 3834-MRS**
Converts the arbor hexagonal shank to suit Morse taper system on stationary machine.

| | Pack Qty. | Weight g |
|---|---|---|
| Fits arbors -1130, -11152, -11152QC | | |
| 3834-MRS-2 | 1 | 220 |
| Fits Arbor -16152 | | |
| 3834-MRS-3 | 1 | 220 |

# Reciprocating **Sawblades**

## QUICK, ACCURATE AND SAFE **CUTTING THROUGH A WIDE RANGE OF MATERIALS**

Bahco offers a range of reciprocating sawblades that is up to every cutting task.

Built using the most advanced alloys and tooth designs, Bahco reciprocating sawblades combine high strength (and shatter resistance) with greater cutting power and control. That's why they let you produce faster, cleaner and more accurate cuts, time after time.

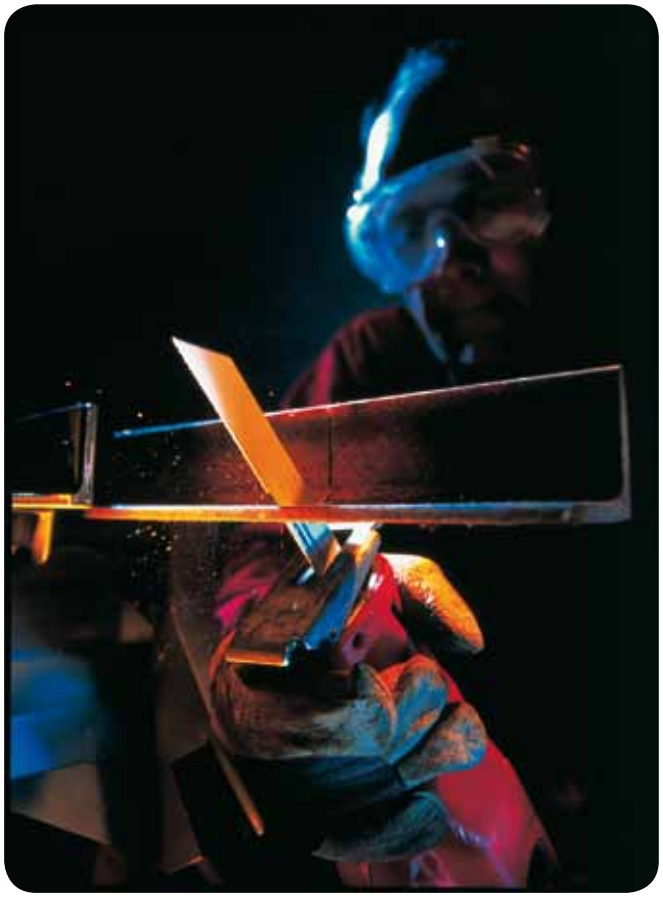
The Bahco line of reciprocating sawblades is truly unique. With three separate types, each is available in a wide range of designs, lengths and toothings. There is a blade that is perfect for every application.

### BAHCO CARBIDE BLADES

- Tough carbide blade delivers impressive cutting power and life
- Exceptional performance

### BAHCO BI-METAL BLADES

- Hardened high speed steel teeth provide aggressive bite into toughest materials
- High performance tooth design resistant to chipping
- Spring steel backing provides flexibility and resilience to prevent shattering



# Choosing the Right **Reciprocating Blade**

How to select the perfect blade for the job from Bahco comprehensive line of professional grade reciprocating sawblades.

## STEP 1: DETERMINE THE RIGHT TOOTHING

Bahco reciprocating sawblades feature aggressive, precision-ground teeth. In addition, many bi-metal blades feature variable teeth spacing. It all adds up to unbeatable sawing performance and versatility. Material type and thickness determine which toothing pattern and TPI will work best.

1. Select material and dimension with the help of the material guide
2. Choose group of toothings (TPI's) which can be used for the application

| Material thickness mm | Metal/ Steel | Plastic | Laminates/ Chipboard | Wood | Plaster boards | Ceramics/ Glass/ Tiles | Bricks/ Fibreglass |
|---|---|---|---|---|---|---|---|
| >50 | | 4/6 | 4/6 | 7”<br>4/6 | | | 3* |
| 20-50 | 5/8 | 5/8<br>6<br>8<br>10 | 5/8<br>6<br>8<br>10 | 7”<br>5/8<br>8<br>10 | 5/8<br>6<br>8<br>10 | | 6** |
| 10-20 | 8/12<br>14 | 8/12<br>14 | 8/12<br>14 | 8/12<br>14 | 8/12<br>14 | | 6** |
| 3-10 | 18 | 18 | 18 | 18 | 18 | GRIT | |
| 0-3 | 24 | 24 | 24 | 24 | | | |

**“Difficult applications require a specialist blade”**

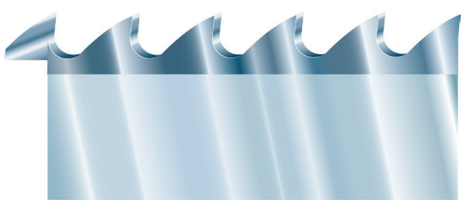
The numbers in the table stands for the number of teeth per inch (TPI).
* Wood-cutting blades. Special blades for pure wood cutting.
** Blades with carbide-tipped teeth for cutting abrasive non-ferrous material.
While using reciprocating sawblades in wood with embedded nails we recommend a slightly higher TPI than for pure wood cutting.

## STEP 2: IDENTIFY AND CHOOSE THE RIGHT BAHCO RECIPROCATING SAWBLADE

Here is how to read product codes for Bahco reciprocating sawblades.

**Example:** **3840-** **150-** **14-** **ST-** **5P**

- **5P** — Packaging Quantity: 1, 2, 5, 10, 100 depending on product
- **ST-** — Blade shape: ST = Standard; UST = U-shank; SL = Slope; SC = Scroll; DSL = Demolition Slope
- **14-** — Teeth Per Inch (TPI)
- **150-** — Blade Length in mm
- **3840-** — Blade Material



## 3840 SANDFLEX® ST/SL/SC

New assortment with improved performance and precision-ground teeth. Virtually unbreakable Sandflex® bi-metal blade for all materials and type of cut. Specially developed for cutting metal.

**ST (Standard)** For straight and quick cutting of metal, plastic, laminates and wood with nails.

**Blade length:** 100, 150, 228, 253 and 300 mm.

**Toothing:** 6, 8/12, 10, 14, 18 and 24 teeth per inch.

| | Blade-length mm | Blade Thickness mm | |T/"| |
|---|---|---|---|
| 5-PACK | | | |
| 3840-100-6-ST-5P | 100 | 1.3 | 6 |
| 3840-100-10-ST-5P | 100 | 0.9 | 10 |
| 3840-100-14-ST-5P | 100 | 0.9 | 14 |
| 3840-100-18-ST-5P | 100 | 0.9 | 18 |
| 3840-100-24-ST-5P | 100 | 0.9 | 24 |
| 3840-150-6-ST-5P | 150 | 1.3 | 6 |
| 3840-150-8/12-ST-5P | 150 | 0.9 | 8/12 |
| 3840-150-10-ST-5P | 150 | 0.9 | 10 |
| 3840-150-14-ST-5P | 150 | 0.9 | 14 |
| 3840-150-18-ST-5P | 150 | 0.9 | 18 |
| 3840-150-24-ST-5P | 150 | 0.9 | 24 |
| 3840-228-8/12-ST-5P | 228 | 1.3 | 8/12 |
| 3840-228-10-ST-5P | 228 | 0.9 | 10 |
| 3840-228-14-ST-5P | 228 | 0.9 | 14 |
| 3840-228-18-ST-5P | 228 | 0.9 | 18 |
| 3840-300-14-ST-5P | 300 | 0.9 | 14 |
| 3840-300-18-ST-5P | 300 | 0.9 | 18 |
| 10-PACK | | | |
| 3840-100-6-ST-10P | 100 | 1.3 | 6 |
| 3840-100-10-ST-10P | 100 | 0.9 | 10 |
| 3840-100-14-ST-10P | 100 | 0.9 | 14 |
| 3840-100-18-ST-10P | 100 | 0.9 | 18 |
| 3840-100-24-ST-10P | 100 | 0.9 | 24 |
| 3840-150-6-ST-10P | 150 | 1.3 | 6 |
| 3840-150-8/12-ST-10P | 150 | 0.9 | 8/12 |
| 3840-150-10-ST-10P | 150 | 0.9 | 10 |
| 3840-150-14-ST-10P | 150 | 0.9 | 14 |
| 3840-150-18-ST-10P | 150 | 0.9 | 18 |
| 3840-150-24-ST-10P | 150 | 0.9 | 24 |
| 3840-228-8/12-ST-10P | 228 | 1.3 | 8/12 |
| 3840-228-10-ST-10P | 228 | 0.9 | 10 |
| 3840-228-14-ST-10P | 228 | 0.9 | 14 |
| 3840-228-18-ST-10P | 228 | 0.9 | 18 |
| 3840-300-14-ST-10P | 300 | 0.9 | 14 |
| 3840-300-18-ST-10P | 300 | 0.9 | 18 |
| 100-PACK | | | |
| 3840-150-10-ST-100P | 150 | 0.9 | 10 |
| 3840-150-14-ST-100P | 150 | 0.9 | 14 |
| 3840-150-18-ST-100P | 150 | 0.9 | 18 |
| 3840-150-24-ST-100P | 150 | 0.9 | 24 |
| 3840-150-8/12-ST-100P | 150 | 1.3 | 8/12 |
| 3840-228-8/12-ST-100P | 228 | 0.9 | 8/12 |
| 3840-228-10-ST-100P | 228 | 0.9 | 10 |
| 3840-228-14-ST-100P | 228 | 0.9 | 14 |
| 3840-228-18-ST-100P | 228 | 0.9 | 18 |
| 3840-300-14-ST-100P | 300 | 0.9 | 14 |
| 3840-300-18-ST-100P | 300 | 0.9 | 18 |

**SL (Slope)** For all-round cutting of metal, plastic, laminates and wood with nails.

**Blade length:** 150, 228 and 300 mm.

**Toothing:** 5/8, 6 and 8/12 teeth per inch.

| | Blade-length mm | Blade Thickness mm | |T/"| |
|---|---|---|---|
| 5-PACK | | | |
| 3840-150-5/8-SL-5P | 150 | 1.3 | 5/8 |
| 3840-228-6-SL-5P | 228 | 1.3 | 6 |
| 3840-300-6-SL-5P | 300 | 1.3 | 6 |
| 3840-300-8/12-SL-5P | 300 | 1.3 | 8/12 |
| 10-PACK | | | |
| 3840-150-5/8-SL-10P | 150 | 1.3 | 5/8 |
| 3840-228-6-SL-10P | 228 | 1.3 | 6 |
| 3840-300-6-SL-10P | 300 | 1.3 | 6 |
| 3840-300-8/12-SL-10P | 300 | 1.3 | 8/12 |
| 100-PACK | | | |
| 3840-150-5/8-SL-100P | 150 | 1.3 | 5/8 |

**SC (Scroll)** For contour sawing of metal, plastic, laminates, wood with nails.

**Blade length:** 100 and 150 mm.

**Toothing:** 4/6, 10, 14 and 18 teeth per inch.

| | Blade-length mm | Blade Thickness mm | |T/"| |
|---|---|---|---|
| 5-PACK | | | |
| 3840-100-10-SC-5P | 100 | 0.9 | 10 |
| 3840-100-14-SC-5P | 100 | 0.9 | 14 |
| 3840-100-18-SC-5P | 100 | 0.9 | 18 |
| 3840-150-4/6-SC-5P | 150 | 1.3 | 4/6 |
| 10-PACK | | | |
| 3840-150-4/6-SC-10P | 150 | 1.3 | 4/6 |

# Bi-Metal

## 3840 SANDFLEX® DSL

Sandflex® blades are a series of extra thick and wide saw blades for demolition and heavy-duty work.
Perfect for nail-embedded wood. Slope shaped for various types of cut.

**DSL (Demolition slope)**
**Blade length:** 150, 228 and 300 mm.
**Toothing:** 5/8 teeth per inch.

| | Blade-length mm | Blade Thickness mm | |
|---|---|---|---|
| 5-PACK | | | |
| 3840-150-5/8-DSL-5P | 150 | 1.6 | 5/8 |
| 3840-228-5/8-DSL-5P | 228 | 1.6 | 5/8 |
| 3840-300-5/8-DSL-5P | 300 | 1.6 | 5/8 |
| 10-PACK | | | |
| 3840-150-5/8-DSL-10P | 150 | 1.6 | 5/8 |
| 3840-228-5/8-DSL-10P | 228 | 1.6 | 5/8 |
| 3840-300-5/8-DSL-10P | 300 | 1.6 | 5/8 |

## 3840 SANDFLEX® UST

Sandflex® blades are a series of saw blades with extra wide U-shank, Rems, Roller, Hitachi, and Flex machines.
Suitable for steel and metal applications. These extra wide blades are normally used for cutting in pipes.

**UST (U-shank standard)**
**Blade length:** 150,200 and 300 mm.
**Toothing:** 8 and 10/14 teeth per inch.

| | Blade-length mm | Blade Thickness mm | |
|---|---|---|---|
| 5-PACK | | | |
| 3840-150-8-UST-5P | 150 | 1.6 | 8 |
| 3840-200-8-UST-5P | 200 | 1.6 | 8 |
| 3840-300-8-UST-5P | 300 | 1.6 | 8 |
| 3840-150-10/14-UST-5P | 150 | 1.6 | 10/14 |
| 3840-200-10/14-UST-5P | 200 | 1.6 | 10/14 |
| 3840-300-10/14-UST-5P | 300 | 1.6 | 10/14 |

## 3840 PALLET CUTTING BLADE

Designed for pallet repair shops. Unique V-shape front design prevents the blade from jamming in the wood when cutting nails in damaged parts of the pallet.

| | Blade-length mm | Blade Thickness mm | |
|---|---|---|---|
| 10-PACK | | | |
| 3840-228-10/14-PR09-10P | 228 | 0.9 | 10/14 |
| 3840-228-10/14-PR13-10P | 228 | 1.3 | 10/14 |
| 100-PACK | | | |
| 3840-228-10/14-PR09-100P | 228 | 0.9 | 10/14 |
| 3840-228-10/14-PR13-100P | 228 | 1.3 | 10/14 |

## 3840-P PALLET SAWBLADES

Especially developed sawblade for transport pallet repairs. Used in pneumatic hand held saw machines, to cut nails in order to replace damaged parts on a transport pallet.

| | Blade-length mm | Blade Thickness mm | |
|---|---|---|---|
| 100-PACK | | | |
| 3840-220-24 | 220 | 0.75 | 24 |
| 3840-260-24 | 260 | 0.75 | 24 |

## 3840 WOOD

Bi-metal blades with special toothing for all-round wood-cutting.
The toothing allows considerably faster cross-cutting and ripping compared to traditional blades.
The blade is coated for minimum friction.

**Blade length:** 150, 228 and 300 mm.
**Toothing:** 7 teeth per inch.

| | Blade-length mm | Blade Thickness mm | |
|---|---|---|---|
| 5-PACK | | | |
| 3842-150-7-SL-5P | 150 | 1.0 | 7 |
| 3842-228-7-SL-5P | 228 | 1.0 | 7 |
| 3842-300-7-SL-5P | 300 | 1.0 | 7 |
| 10-PACK | | | |
| 3842-150-7-SL-10P | 150 | 1.0 | 7 |
| 3842-228-7-SL-10P | 228 | 1.0 | 7 |
| 3842-300-7-SL-10P | 300 | 1.0 | 7 |

# Carbide

## 3846 CARBIDE

Blade with carbide-tipped teeth. Ideal for demanding building and industrial applications, such as cutting of bricks, porous concrete, Leca, Siporex, fibreglass and plastic laminates.

**Blade length:** 150, 228 and 300 mm.
**Toothing:** 3 and 6 teeth per inch.

| | Blade-length mm | Blade Thickness mm | |
|---|---|---|---|
| 1-PACK | | | |
| 3846-150-6-SL-1P | 150 | 0.9 | 6 |
| 3846-228-3-ST-1P | 228 | 1.3 | 3 |
| 3846-228-6-ST-1P | 228 | 0.9 | 6 |
| 3846-300-3-ST-1P | 300 | 1.3 | 3 |

## 3846 CARBIDE GRIT

Blade with carbide grit cutting edge. For precision cutting of extremely hard materials, such as glass, glazed tiles and ceramics.

**Blade length:** 100 to 150 mm.


| | Blade-length mm | Blade Thickness mm |
|---|---|---|
| 2-PACK | | |
| 3846-100-G-ST-2P | 100 | 0.9 |
| 3846-150-G-ST-2P | 150 | 0.9 |

# Power Hacksaw **Blades**

## 3809 SANDFLEX® BI-METAL POWER HACKSAW BLADES

Sandflex® is a virtually unbreakable bi-metal hacksaw blade. The bi-metal construction results in a shatterproof blade that can withstand high feed pressures giving accurate, fast cutting rates. Their shatterproof nature also makes Sandflex® blades safer to use in all circumstances, especially on old machines or with unskilled operators. Suitable for use on any material.


| | | L x W x T mm | T/" | Weight g |
|---|---|---|---|---|
| 3809-300-25-1.25-10 | 10 | 300 x 25 x 1.25 | 10 | 73 |
| 3809-300-25-1.25-14 | 10 | 300 x 25 x 1.25 | 14 | 73 |
| 3809-300-32-1.60-6 | 10 | 300 x 32 x 1.60 | 6 | 120 |
| 3809-300-32-1.60-10 | 10 | 300 x 32 x 1.60 | 10 | 120 |
| 3809-350-25-1.25-6 | 10 | 350 x 25 x 1.25 | 6 | 88 |
| 3809-350-25-1.25-10 | 10 | 350 x 25 x 1.25 | 10 | 88 |
| 3809-350-25-1.25-14 | 10 | 350 x 25 x 1.25 | 14 | 88 |
| 3809-350-32-1.60-4 | 10 | 350 x 32 x 1.60 | 4 | 145 |
| 3809-350-32-1.60-6 | 10 | 350 x 32 x 1.60 | 6 | 145 |
| 3809-350-32-1.60-8 | 10 | 350 x 32 x 1.60 | 8 | 145 |
| 3809-350-32-1.60-10 | 10 | 350 x 32 x 1.60 | 10 | 145 |
| 3809-350-32-1.60-14 | 10 | 350 x 32 x 1.60 | 14 | 145 |
| 3809-350-32-2.00-4 | 10 | 350 x 32 x 2.00 | 4 | 159 |
| 3809-350-32-2.00-6 | 10 | 350 x 32 x 2.00 | 6 | 159 |
| 3809-350-32-2.00-10 | 10 | 350 x 32 x 2.00 | 10 | 159 |
| 3809-350-38-2.00-4 | 10 | 350 x 38 x 2.00 | 4 | 204 |
| 3809-350-38-2.00-6 | 10 | 350 x 38 x 2.00 | 6 | 204 |
| 3809-350-38-2.00-10 | 10 | 350 x 38 x 2.00 | 10 | 204 |
| 3809-400-25-1.25-10 | 10 | 400 x 25 x 1.25 | 10 | 108 |
| 3809-400-25-1.25-14 | 10 | 400 x 25 x 1.25 | 14 | 108 |
| 3809-400-32-1.60-4 | 10 | 400 x 32 x 1.60 | 4 | 160 |
| 3809-400-32-1.60-6 | 10 | 400 x 32 x 1.60 | 6 | 160 |
| 3809-400-32-1.60-8 | 10 | 400 x 32 x 1.60 | 8 | 160 |
| 3809-400-32-1.60-10 | 10 | 400 x 32 x 1.60 | 10 | 160 |
| 3809-400-32-1.60-14 | 10 | 400 x 32 x 1.60 | 14 | 160 |
| 3809-400-32-2.00-4 | 10 | 400 x 32 x 2.00 | 4 | 184 |
| 3809-400-32-2.00-6 | 10 | 400 x 32 x 2.00 | 6 | 184 |
| 3809-400-32-2.00-8 | 10 | 400 x 32 x 2.00 | 8 | 184 |
| 3809-400-32-2.00-10 | 10 | 400 x 32 x 2.00 | 10 | 184 |
| 3809-400-38-2.00-4 | 10 | 400 x 38 x 2.00 | 4 | 219 |
| 3809-400-38-2.00-6 | 10 | 400 x 38 x 2.00 | 6 | 219 |
| 3809-400-38-2.00-10 | 10 | 400 x 38 x 2.00 | 10 | 219 |
| 3809-425-32-1.60-10 | 10 | 425 x 32 x 1.60 | 10 | 170 |
| 3809-450-32-1.60-4 | 10 | 450 x 32 x 1.60 | 4 | 177 |
| 3809-450-32-1.60-6 | 10 | 450 x 32 x 1.60 | 6 | 177 |
| 3809-450-32-1.60-10 | 10 | 450 x 32 x 1.60 | 10 | 177 |
| 3809-450-32-1.60-14 | 10 | 450 x 32 x 1.60 | 14 | 177 |
| 3809-450-32-2.00-4 | 10 | 450 x 32 x 2.00 | 4 | 209 |

| | | L x W x T mm | T/" | Weight g |
|---|---|---|---|---|
| 3809-450-32-2.00-6 | 10 | 450 x 32 x 2.00 | 6 | 209 |
| 3809-450-32-2.00-10 | 10 | 450 x 32 x 2.00 | 10 | 209 |
| 3809-450-38-2.00-4 | 10 | 450 x 38 x 2.00 | 4 | 249 |
| 3809-450-38-2.00-6 | 10 | 450 x 38 x 2.00 | 6 | 249 |
| 3809-450-38-2.00-8 | 10 | 450 x 38 x 2.00 | 8 | 249 |
| 3809-450-38-2.00-10 | 10 | 450 x 38 x 2.00 | 10 | 249 |
| 3809-450-45-2.25-4 | 10 | 450 x 45 x 2.25 | 4 | 358 |
| 3809-450-45-2.25-6 | 10 | 450 x 45 x 2.25 | 6 | 358 |
| 3809-475-45-2.25-6 | 10 | 475 x 45 x 2.25 | 6 | 378 |
| 3809-500-38-2.00-4 | 10 | 500 x 38 x 2.00 | 4 | 304 |
| 3809-500-38-2.00-6 | 10 | 500 x 38 x 2.00 | 6 | 304 |
| 3809-500-38-2.00-10 | 10 | 500 x 38 x 2.00 | 10 | 304 |
| 3809-500-45-2.25-4 | 10 | 500 x 45 x 2.25 | 4 | 398 |
| 3809-500-45-2.25-6 | 10 | 500 x 45 x 2.25 | 6 | 398 |
| 3809-500-50-2.50-4 | 10 | 500 x 50 x 2.50 | 4 | 513 |
| 3809-500-50-2.50-6 | 10 | 500 x 50 x 2.50 | 6 | 513 |
| 3809-500-50-2.50-8 | 10 | 500 x 50 x 2.50 | 8 | 513 |
| 3809-525-38-2.00-6 | 10 | 525 x 38 x 2.00 | 6 | 314 |
| 3809-525-38-2.00-10 | 10 | 525 x 38 x 2.00 | 10 | 314 |
| 3809-525-45-2.25-4 | 10 | 525 x 45 x 2.25 | 4 | 423 |
| 3809-525-45-2.25-6 | 10 | 525 x 45 x 2.25 | 6 | 423 |
| 3809-550-45-2.25-4 | 10 | 550 x 45 x 2.25 | 4 | 433 |
| 3809-550-45-2.25-6 | 10 | 550 x 45 x 2.25 | 6 | 433 |
| 3809-550-50-2.50-4 | 10 | 550 x 50 x 2.50 | 4 | 553 |
| 3809-550-50-2.50-6 | 10 | 550 x 50 x 2.50 | 6 | 553 |
| 3809-575-45-2.25-4 | 10 | 575 x 45 x 2.25 | 4 | 453 |
| 3809-575-50-2.50-4 | 10 | 575 x 50 x 2.50 | 4 | 568 |
| 3809-575-50-2.50-6 | 10 | 575 x 50 x 2.50 | 6 | 568 |
| 3809-600-45-2.25-4 | 10 | 600 x 45 x 2.25 | 4 | 478 |
| 3809-600-45-2.25-6 | 10 | 600 x 45 x 2.25 | 6 | 478 |
| 3809-600-50-2.50-3 | 10 | 600 x 50 x 2.50 | 3 | 588 |
| 3809-600-50-2.50-4 | 10 | 600 x 50 x 2.50 | 4 | 588 |
| 3809-600-50-2.50-6 | 10 | 600 x 50 x 2.50 | 6 | 588 |
| 3809-650-50-2.50-4 | 5 | 650 x 50 x 2.50 | 4 | 634 |
| 3809-650-50-2.50-6 | 5 | 650 x 50 x 2.50 | 6 | 634 |
| 3809-700-50-2.50-4 | 5 | 700 x 50 x 2.50 | 4 | 679 |
| 3809-700-50-2.50-6 | 5 | 700 x 50 x 2.50 | 6 | 679 |
| 3809-750-50-2.50-4 | 5 | 750 x 50 x 2.50 | 4 | 690 |

# Power Hacksaw **Blades**

## 3809 KA BI-METAL FOR **KASTO MACHINES**

Designed with holes for KASTO machines.

| | | L x W x T | | Weight g |
|---|---|---|---|---|
| 3809-400-32-2.00-6-KA | 10 | 400 x 32 x 2.00 | 6 | 184 |
| 3809-450-38-2.00-4-KA | 10 | 450 x 38 x 2.00 | 4 | 249 |
| 3809-450-38-2.00-6-KA | 10 | 450 x 38 x 2.00 | 6 | 249 |
| 3809-450-38-2.00-10-KA | 10 | 450 x 38 x 2.00 | 10 | 249 |
| 3809-500-45-2.25-6-KA | 10 | 500 x 45 x 2.25 | 6 | 398 |
| 3809-500-50-2.50-4-KA | 10 | 500 x 50 x 2.50 | 4 | 513 |
| 3809-500-50-2.50-6-KA | 10 | 500 x 50 x 2.50 | 6 | 513 |
| 3809-550-50-2.50-4-KA | 10 | 550 x 50 x 2.50 | 4 | 553 |
| 3809-550-50-2.50-6-KA | 10 | 550 x 50 x 2.50 | 6 | 553 |
| 3809-575-50-2.50-3-KA | 10 | 575 x 50 x 2.50 | 3 | 568 |
| 3809-575-50-2.50-4-KA | 10 | 575 x 50 x 2.50 | 4 | 568 |
| 3809-575-50-2.50-6-KA | 10 | 575 x 50 x 2.50 | 6 | 568 |
| 3809-575-50-2.50-10-KA | 10 | 575 x 50 x 2.50 | 10 | 568 |
| 3809-600-50-2.50-4-KA | 10 | 600 x 50 x 2.50 | 4 | 588 |
| 3809-600-50-2.50-6-KA | 10 | 600 x 50 x 2.50 | 6 | 588 |
| 3809-650-50-2.50-3-KA | 5 | 650 x 50 x 2.50 | 3 | 634 |
| 3809-650-50-2.50-4-KA | 5 | 650 x 50 x 2.50 | 4 | 634 |
| 3809-650-50-2.50-6-KA | 5 | 650 x 50 x 2.50 | 6 | 634 |
| 3809-700-50-2.50-3-KA | 5 | 700 x 50 x 2.50 | 3 | 679 |
| 3809-700-50-2.50-4-KA | 5 | 700 x 50 x 2.50 | 4 | 679 |
| 3809-700-50-2.50-6-KA | 5 | 700 x 50 x 2.50 | 6 | 679 |

# Hand Hacksaw **Blades**

## 3906 SANDFLEX® **BI-METAL**

With a blade back of strong, flexible spring steel and a tooth line in high-alloyed super high speed steel, this blade is guaranteed to keep its sharpness for a long time. The Sandflex® blade combines extreme cutting performance and wear resistance with a high degree of flexibility and is vastly superior to all-hard high speed blades or conventional, flexible blades. **Packaged as:**

- **100:** 10 bundles of 10 blades in black, plastic box with transparent cover
- **10P:** 10 blades in a special package with hanging loop, packs of 10
- **5P:** 5 blades in a special package with hanging loop, packs of 10
- **3P:** 3 blades, 1 each of 18, 24 and 32 TPI, in plastic pouch, packs of 10
- **2P:** 2 carded blades, box of 10 packs

| | | Length mm | |
|---|---|---|---|
| 3906-250-18-100 | 100 | 250 x 13 x 0.65 | 18 |
| 3906-250-24-100 | 100 | 250 x 13 x 0.65 | 24 |
| 3906-250-32-100 | 100 | 250 x 13 x 0.65 | 32 |
| 3906-300-14-100 | 100 | 300 x 13 x 0.65 | 14 |
| 3906-300-18-100 | 100 | 300 x 13 x 0.65 | 18 |
| 3906-300-24-100 | 100 | 300 x 13 x 0.65 | 24 |
| 3906-300-32-100 | 100 | 300 x 13 x 0.65 | 32 |
| 3906-300-18-2P | 10 | 300 x 13 x 0.65 | 18 |
| 3906-300-24-2P | 10 | 300 x 13 x 0.65 | 24 |
| 3906-300-32-2P | 10 | 300 x 13 x 0.65 | 32 |
| 3906-300-3P | 10 | 300 x 13 x 0.65 | 18/24/32 |
| 3906-300-24-5P | 10 | 300 x 13 x 0.65 | 24 |
| 3906-300-32-5P | 10 | 300 x 13 x 0.65 | 32 |
| 3906-300-14-10P | 10 | 300 x 13 x 0.65 | 14 |
| 3906-300-18-10P | 10 | 300 x 13 x 0.65 | 18 |
| 3906-300-24-10P | 10 | 300 x 13 x 0.65 | 24 |
| 3906-300-32-10P | 10 | 300 x 13 x 0.65 | 32 |

## 325 HAND HACKSAW **FRAME** ergo®

A truly unique and professional hacksaw frame. Ergonomically designed with very high blade tension for straight, accurate and exact kerfs. Centred blade for correct balance and spring tensioned blade loading mechanism for quick blade changes. Alternative 55° blade mounting for flush cutting. Supplied with the reliable and shatterproof Sandflex® bi-metal blade 24 TPI with excellent cutting performance.

| | | Length mm | Weight g |
|---|---|---|---|
| 325 | 5 | 300 | 720 |

## 319 HAND HACKSAW **FRAME**

A compact and stable hacksaw for all round use. Alternative 55° blade mounting for flush cutting. Offers a strong steel frame that is covered with a protective dual component plastic. Comfortable, non-slip back handle and front grip ensures a solid, secure grip. Tension mechanism is fully integrated into the handles so there is no obstruction during use. Supplied with reliable and shatterproof 12 inch bi-metal blade, 24 TPI.

| | | Length mm | Weight g |
|---|---|---|---|
| 319 | 5 | 300 | 510 |

## 320 HAND HACKSAW **FRAME**

A one of a kind, top-of-the-line, traditional hacksaw frame with comfortable handles and extra depth allowing for cutting materials of big dimensions. Comes equipped with a Sandflex® hand hacksaw blade.

| | | Length mm | Weight g |
|---|---|---|---|
| 320 | 10 | 300 | 820 |

# Engineering **Files**

**Bahco's current file assortment represents the accumulated knowledge of 160 years of file-production.**

Drawing on this knowledge, the company has continuously developed the design of this tool and now applies the most modern, efficient manufacturing methods to its production. Rigorous quality control throughout the manufacturing process, from incoming raw material to the finished product, ensures high quality and performance.


All the Bahco files fulfill the requirements stated in the following standards: ISO 234/1 & 2, DIN File Standards, BS 498:1990, US Fed.spec. GGG-F-325b/GGG-F-331b.

Bahco has established its reputation on the world market by investing substantial resources in research and development over the years. With a dedicated commitment to remain at the forefront of file development in the future, the company is determined to continue meeting customer needs, both for industry and the home user.

The files shown on the following pages are only part of the Bahco assortment.

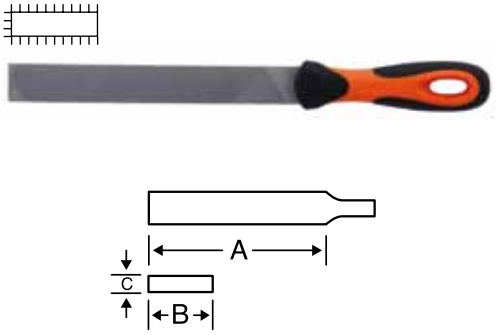
# Engineering **Files**

## HAND FILE / 1-100...-2

**Use:** For filing flat surfaces, sharp corners and shoulders as well as for deburring. A double cut file should be used for work in high-alloy tool steels. Also useful for the sharpening of heavy implements. High removal rate.

**Shape:** Edges and surfaces parallel. Surfaces double cut, one edge uncut, one edge single cut.

| | Pack Qty. | A mm | B mm | C mm | T/cm | Cut Type | Weight g |
|---|---|---|---|---|---|---|---|
| 1-100-04-1-2 | 5 | 100 | 12 | 3.0 | 17 | 1 | 67 |
| 1-100-04-2-2 | 5 | 100 | 12 | 3.0 | 22 | 2 | 67 |
| 1-100-06-1-2 | 5 | 150 | 16 | 4.0 | 13 | 1 | 110 |
| 1-100-06-2-2 | 5 | 150 | 16 | 4.0 | 18 | 2 | 110 |
| 1-100-06-3-2 | 5 | 150 | 16 | 4.0 | 18 | 3 | 110 |
| 1-100-08-1-2 | 5 | 200 | 20 | 5.0 | 10 | 1 | 200 |
| 1-100-08-2-2 | 5 | 200 | 20 | 5.0 | 14 | 2 | 200 |
| 1-100-08-3-2 | 5 | 200 | 20 | 5.0 | 18 | 3 | 200 |
| 1-100-10-1-2 | 5 | 250 | 25 | 5.5 | 9 | 1 | 310 |
| 1-100-10-2-2 | 5 | 250 | 25 | 5.5 | 12 | 2 | 310 |
| 1-100-10-3-2 | 5 | 250 | 25 | 5.5 | 16 | 3 | 310 |
| 1-100-12-1-2 | 5 | 300 | 30 | 6.0 | 8 | 1 | 431 |
| 1-100-12-2-2 | 5 | 300 | 30 | 6.0 | 11 | 2 | 431 |
| 1-100-12-3-2 | 5 | 300 | 30 | 6.0 | 14 | 3 | 431 |

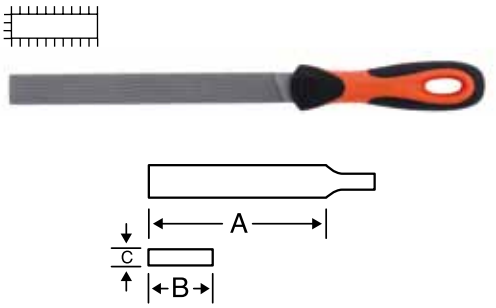



## HAND FILE "OBERG CUT" / 1-106...-2

**Use:** Useful for all flat filing. Oberg cut gives a high removal rate and smooth surface finish on most materials.

**Shape:** Edges and surfaces parallel. Surfaces single cut, bastard, with chipbreaking teeth. One edge single cut.

| | Pack Qty. | A mm | B mm | C mm | T/cm | Cut Type | Weight g |
|---|---|---|---|---|---|---|---|
| 1-106-08-1-2 | 5 | 200 | 20 | 5.0 | 10 | 1 | 200 |
| 1-106-10-1-2 | 5 | 250 | 25 | 5.5 | 9 | 1 | 310 |
| 1-106-12-1-2 | 5 | 300 | 30 | 6.0 | 8 | 1 | 431 |

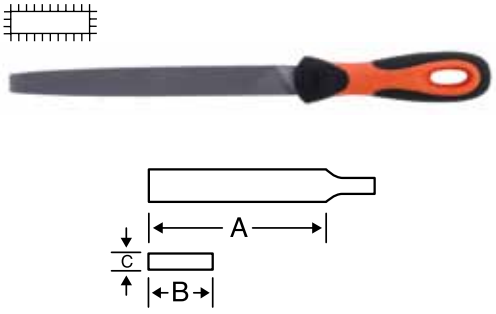



## FLAT FILE / 1-110...-2

**Use:** For the same jobs as the hand file 100, but is sometimes preferred because its tapered shape enables the user to reach into angles and corners more easily.

**Shape:** Edges tapered towards the point, surfaces parallel. Surfaces double cut, edges single cut. 4" and 6" pointed, 8" and longer semi-pointed.

| | Pack Qty. | A mm | B mm | C mm | T/cm | Cut Type | Weight g |
|---|---|---|---|---|---|---|---|
| 1-110-06-1-2 | 5 | 150 | 16 | 4.0 | 13 | 1 | 110 |
| 1-110-06-2-2 | 5 | 150 | 16 | 4.0 | 18 | 2 | 110 |
| 1-110-06-3-2 | 5 | 150 | 16 | 4.0 | 22 | 3 | 110 |
| 1-110-08-1-2 | 5 | 200 | 20 | 5.0 | 10 | 1 | 180 |
| 1-110-08-2-2 | 5 | 200 | 20 | 5.0 | 14 | 2 | 180 |
| 1-110-08-3-2 | 5 | 200 | 20 | 5.0 | 18 | 3 | 180 |
| 1-110-10-1-2 | 5 | 250 | 25 | 5.5 | 9 | 1 | 270 |
| 1-110-10-2-2 | 5 | 250 | 25 | 5.5 | 12 | 2 | 270 |
| 1-110-10-3-2 | 5 | 250 | 25 | 5.5 | 16 | 3 | 270 |
| 1-110-12-1-2 | 5 | 300 | 30 | 6.0 | 8 | 1 | 431 |
| 1-110-12-2-2 | 5 | 300 | 30 | 6.0 | 11 | 2 | 431 |
| 1-110-12-3-2 | 5 | 300 | 30 | 6.0 | 14 | 3 | 431 |




**Type of cut:** 1 = Bastard, 2 = Second, 3 = Smooth.

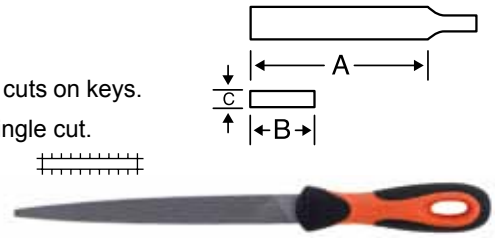
# Engineering **Files**

## WARDING FILE / 1-111...-2

**Use:** For filing narrow grooves and passages, etc. Particularly well suited for filing cuts on keys.

**Shape:** Edges tapered to a point, surfaces parallel. Surfaces double cut, edges single cut.

| | Pack Qty. | A mm | B mm | C mm | T/cm | Cut Type | Weight g |
|---|---|---|---|---|---|---|---|
| 1-111-06-2-2 | 5 | 150 | 15 | 1.9 | 18 | 2 | 65 |

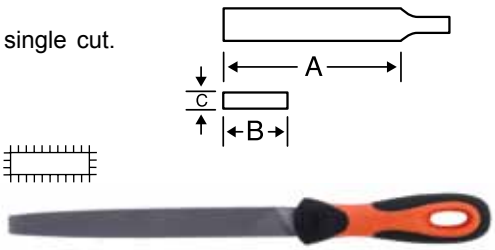



## MILL FILE, 2 FLAT EDGES (TYPE USA) / 1-143...-2

**Use:** This type of file is suitable both as an engineering file and a sharpening file. It is useful for filing where a smooth finish is important. Also good for polishing and deburring work in lathes. This file is also widely applicable for sharpening tools and implements such as spades, shovels, hoes, scrapers, etc.

**Shape:** Surfaces parallel. Edges tapered towards the point. Surfaces and edges single cut. Bastard cut commonly referred to as Mill bastard.

| | Pack Qty. | A mm | B mm | C mm | T/cm | Cut Type | Weight g |
|---|---|---|---|---|---|---|---|
| 1-143-06-1-2 | 5 | 150 | 16 | 2.7 | 20 | 1 | 90 |
| 1-143-08-1-2 | 5 | 200 | 20 | 3.3 | 18 | 1 | 140 |
| 1-143-10-1-2 | 5 | 250 | 25 | 4.0 | 16 | 1 | 222 |
| 1-143-12-1-2 | 5 | 300 | 30 | 5.0 | 14 | 1 | 431 |

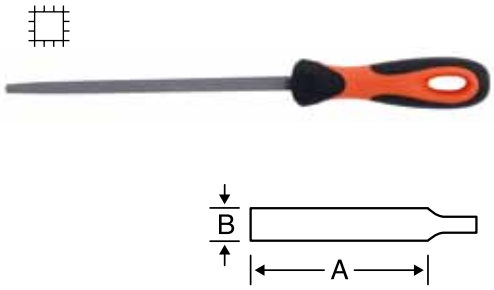



## SQUARE FILE / 1-160...-2

**Use:** For filing grooves, rectangular holes, internal corners and for fine-adjustment of cutting tools.

**Shape**: Surfaces tapered towards the point. Double cut.

| | Pack Qty. | A mm | B mm | T/cm | Cut Type | Weight g |
|---|---|---|---|---|---|---|
| 1-160-04-1-2 | 5 | 100 | 4.5 | 17 | 1 | 42 |
| 1-160-04-2-2 | 5 | 100 | 4.5 | 22 | 2 | 42 |
| 1-160-06-1-2 | 5 | 150 | 6.0 | 13 | 1 | 79 |
| 1-160-06-2-2 | 5 | 150 | 6.0 | 18 | 2 | 79 |
| 1-160-06-3-2 | 5 | 150 | 6.0 | 22 | 3 | 79 |
| 1-160-08-1-2 | 5 | 200 | 8.0 | 10 | 1 | 132 |
| 1-160-08-2-2 | 5 | 200 | 8.0 | 14 | 2 | 132 |
| 1-160-08-3-2 | 5 | 200 | 8.0 | 18 | 3 | 132 |
| 1-160-10-1-2 | 5 | 250 | 10.0 | 9 | 1 | 212 |
| 1-160-10-2-2 | 5 | 250 | 10.0 | 12 | 2 | 212 |
| 1-160-10-3-2 | 5 | 250 | 10.0 | 16 | 3 | 212 |
| 1-160-12-1-2 | 5 | 300 | 12 | 8 | 1 | 347 |
| 1-160-12-2-2 | 5 | 300 | 12 | 11 | 2 | 347 |

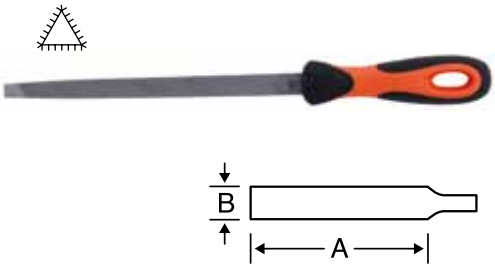



## THREE SQUARE FILE / 1-170...-2

**Use:** For deburring and filing angles and internal corners.
For filing of holes and large fillets as well as concave surfaces. Its tapered surfaces make it well suited for flat filing.

**Shape:** Equilateral triangle. Tapered towards the point. Double cut surfaces.

| | Pack Qty. | A mm | B mm | T/cm | Cut Type | Weight g |
|---|---|---|---|---|---|---|
| 1-170-06-1-2 | 5 | 150 | 11.0 | 13 | 1 | 103 |
| 1-170-06-2-2 | 5 | 150 | 11.0 | 18 | 2 | 103 |
| 1-170-06-3-2 | 5 | 150 | 11.0 | 22 | 3 | 103 |
| 1-170-08-1-2 | 5 | 200 | 15.5 | 10 | 1 | 203 |
| 1-170-08-2-2 | 5 | 200 | 15.5 | 14 | 2 | 203 |
| 1-170-08-3-2 | 5 | 200 | 15.5 | 18 | 3 | 203 |
| 1-170-10-1-2 | 5 | 250 | 17.5 | 9 | 1 | 282 |
| 1-170-10-2-2 | 5 | 250 | 17.5 | 12 | 2 | 282 |
| 1-170-10-3-2 | 5 | 250 | 17.5 | 16 | 3 | 282 |
| 1-170-12-1-2 | 5 | 300 | 19.5 | 8 | 1 | 420 |
| 1-170-12-2-2 | 5 | 300 | 19.5 | 11 | 2 | 420 |




**Type of cut:** 1 = Bastard, 2 = Second, 3 = Smooth.

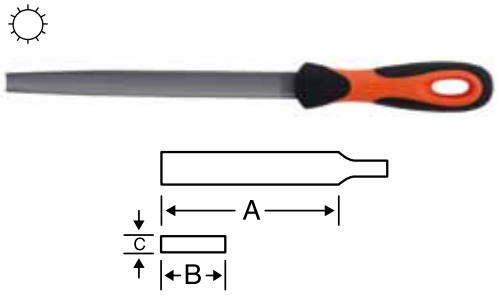
# Engineering **Files**

## HALF-ROUND FILE / 1-210...-2

**Use:** For filing concave and flat surfaces and large holes. Suitable for deburring work.

**Shape:** Edges and surfaces tapered towards the point. 4” and 6” fully pointed, 8” and longer semi-pointed. Double cut.

| | Pack Qty. | A mm | B mm | C mm | T/cm | Cut Type | Weight g |
|---|---|---|---|---|---|---|---|
| 1-210-04-2-2 | 5 | 100 | 10.0 | 3.0 | 22 | 2 | 52 |
| 1-210-06-1-2 | 5 | 150 | 16.0 | 4.7 | 13 | 1 | 100 |
| 1-210-06-2-2 | 5 | 150 | 16.0 | 4.7 | 18 | 2 | 100 |
| 1-210-06-3-2 | 5 | 150 | 16.0 | 4.7 | 22 | 3 | 100 |
| 1-210-08-1-2 | 5 | 200 | 20.5 | 6.0 | 10 | 1 | 170 |
| 1-210-08-2-2 | 5 | 200 | 20.5 | 6.0 | 14 | 2 | 170 |
| 1-210-08-3-2 | 5 | 200 | 20.5 | 6.0 | 18 | 3 | 170 |
| 1-210-10-1-2 | 5 | 250 | 26.5 | 7.5 | 9 | 1 | 344 |
| 1-210-10-2-2 | 5 | 250 | 26.5 | 7.5 | 12 | 2 | 344 |
| 1-210-10-3-2 | 5 | 250 | 26.5 | 7.5 | 16 | 3 | 344 |
| 1-210-12-1-2 | 5 | 300 | 31.0 | 9.0 | 8 | 1 | 480 |
| 1-210-12-2-2 | 5 | 300 | 31.0 | 9.0 | 11 | 2 | 480 |
| 1-210-12-3-2 | 5 | 300 | 31.0 | 9.0 | 14 | 3 | 480 |

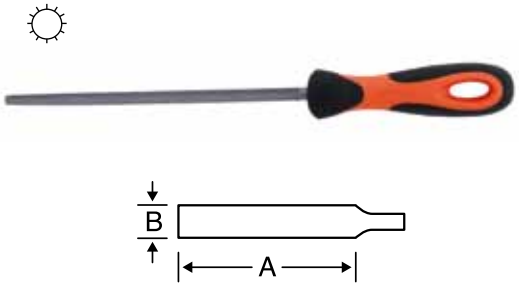



## ROUND FILE / 1-230...-2

**Use:** For filing holes, large fillets and concave surfaces.

**Shape:** Tapered towards the point. 4” and 6” fully pointed, 8” and longer semi-pointed. Double cut.

| | Pack Qty. | A mm | B mm | T/cm | Cut Type | Weight g |
|---|---|---|---|---|---|---|
| 1-230-04-1-2 | 5 | 100 | 3.6 | 17 | 1 | 39 |
| 1-230-04-2-2 | 5 | 100 | 3.6 | 22 | 2 | 39 |
| 1-230-04-3-2 | 5 | 100 | 3.6 | 22 | 3 | 39 |
| 1-230-06-1-2 | 5 | 150 | 6.0 | 13 | 1 | 74 |
| 1-230-06-2-2 | 5 | 150 | 6.0 | 18 | 2 | 74 |
| 1-230-06-3-2 | 5 | 150 | 6.0 | 18 | 3 | 74 |
| 1-230-08-1-2 | 5 | 200 | 8.0 | 10 | 1 | 112 |
| 1-230-08-2-2 | 5 | 200 | 8.0 | 14 | 2 | 112 |
| 1-230-08-3-2 | 5 | 200 | 8.0 | 14 | 3 | 112 |
| 1-230-10-1-2 | 5 | 250 | 10.0 | 9 | 1 | 183 |
| 1-230-10-2-2 | 5 | 250 | 10.0 | 12 | 2 | 183 |
| 1-230-10-3-2 | 5 | 250 | 10.0 | 16 | 3 | 183 |
| 1-230-12-1-2 | 5 | 300 | 12.0 | 8 | 1 | 297 |
| 1-230-12-2-2 | 5 | 300 | 12.0 | 11 | 2 | 297 |




## FILE SETS / 1-473

Sets of three files with handle. A paper packed set, a plastic roll-up wallet included in the box, for future easy storage. Contains one each of: hand, half round and round engineering files. Available in 2 different lenghts: 200 and 250 mm ( 8 and 10 inch).

| | Pack Qty. | mm | Cut Type | Weight g |
|---|---|---|---|---|
| 1-473-08-2-2 | 5 | 200 | 2 | 635 |
| 1-473-10-2-2 | 5 | 250 | 2 | 925 |

## FILE SETS / 1-476

A set of six 4” smooth double cut files, for fine filing and polishing jobs. The set contains one of each handled files: hand, warding, square, three square, half round and round. Supplied in a snap-shut plastic wallet with hanging hole.

| | Pack Qty. | mm | Cut Type | Weight g |
|---|---|---|---|---|
| 1-476-04-3-2 | 1 | 100 | 3 | 200 |

## FILE SETS / 1-479

Sets of five 8” files with handle for carpentry and repair jobs. A paper packed set, a plastic roll-up wallet included in the box, for future easy storage. Contains one each of: hand, half round and round engineering files, a flat sharpening file and a cabinet rasp.

| | Pack Qty. | mm | Cut Type | Weight g |
|---|---|---|---|---|
| 1-479-08-1-2 | 5 | 200 | 1 | 935 |
| 1-479-08-2-2 | 5 | 200 | 2 | 935 |

**Type of cut:** 1 = Bastard, 2 = Second, 3 = Smooth.

# Rotary **Burrs**

**Bahco Rotary Burrs are used to deburr irregular objects or to do finishing work inside a confined space.**

The burrs are manufactured in two different materials, tungsten carbide or high speed steel. It all depends on the application, as to which burr you should choose.

Carbide rotary burrs is an indispensable tool, its use is extremely widespread, particularly in the aviation, marine, automotive, machinery, chemical and other industrial sectors. It can be used for machining cast iron, cast steel, carbon steel, alloy steel, stainless steel, hardened steel, copper and aluminum.

# Rotary **Burrs**

## Identification system

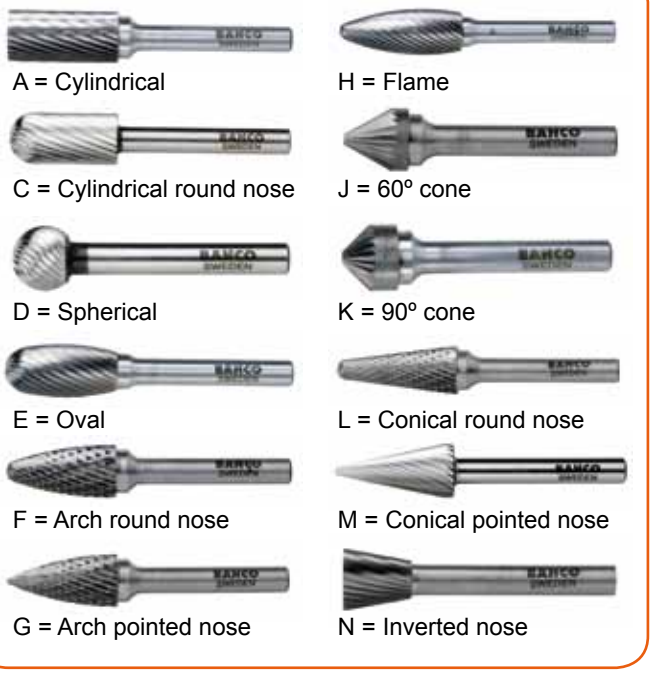
High Speed Steel rotary burrs

**HSSG - A 12 25 M** HSS = High Speed Steel. G = Ground.

Tungsten carbide rotary burrs

**A 12 25 M 06 X E**

- **E** — End cut
- **X** — Choose **X** for X-cut, **D** for Diamond cut
- **06** — Shank diameter, mm.
- **M** — Type of cut. Carbide burrs, choose **F** for Fine, **M** for Medium, **C** for Coarse, **AL** for Aluminium. HSS burrs, choose **M** for Medium toothing, **MC** for Chipbreaker, **EC** for Extra Coarse
- **25** — Length of head, mm,
- **12** — Diameter of head, mm.
- **A** — Letter indicates the shape of the burr




### Choose the Right Rotary Burrs

| TOOTHING | TUNGSTEN CARBIDE BURRS | HIGH-SPEED STEEL (HSS) BURRS |
|---|---|---|
| Fine  | For hard and/or tough materials when a good surface finish is required and stock removal demands are modest. | |
| Medium  | For machining hard and/or tough materials under normal conditions. | For machining unhardened steel and other moderately hard materials under normal conditions. |
| Coarse  | Particularly suitable for machining stainless steel, soft materials or light alloys. | |
| AL-cut  | For machining aluminium. Wax should be used to avoid chip build-up. | |
| Extra Coarse  | Blunt | For soft materials when good stock removal is required. Counteracts chip build-up between teeth. |
| X-cut  | For hard and soft materials. Produces short and blunt chips. Runs smoothly even at low cutting speeds. | |
| Diamond-cut  | For heat treated and tough alloy steels and epoxy. Excellent finish. Minimal axial forces. | |
| Chip-breakers  | | Produces short chips. Runs smoothly even at low cutting speeds. |
| End cut  | Cylindrical burrs (A) and inverted cone burrs (N) can be supplied with end cut. | |

Rotary burrs can be classified by cut info four major groups: fine, medium, coarse and extra coarse (which AL-cut belongs to). As a general rule, a fine cut is selected for hard materials and when a good surface finish is required. Note the exception is stainless steel, which needs a coarse cut. A coarse cut is selected for soft materials and for high stock removal demands.

It should be pointed out, however, that a smaller diameter burr will have a finer cut than a larger diameter burr belonging to the same cut category, for example, medium-cut. That's why we indicate not only the type of cut for each of our rotary burrs, but also the number of teeth.

* Additional sizes available on request.
* Bahco has a wide range of HSS rotary burrs, for an update of this assortment contact your Bahco local sales representative.

# Rotary **Burrs**

**Tungsten Carbide** burrs are designed for use in sturdy, well-maintained machines running at highly stable speeds above 15.000 r.p.m. They can be utilised on most materials with degrees or hardness up to about 67 HRC (Rockwell C).

The cutting head of the burr is made of tungsten carbide with an approximate hardness of 1500 HV (Vickers). Close co-operation between experts have produced different carbides for different sizes to ensure best cutting performance.

The cutting head on large burrs is brazed to a shank of hardened steel, tempered to 46 HRC. A unique brazing method produces exceptionally strong joints. The joint is so strong that, if it should fail, the company will replace the burr free of charge. Smaller burrs, on the other hand, are made in a single solid piece entirely of tungsten carbide. **High Speed Steel** burrs are primarily used for deburring soft steel, bronze, brass, etc.

## Recommended operating speeds R.P.M.

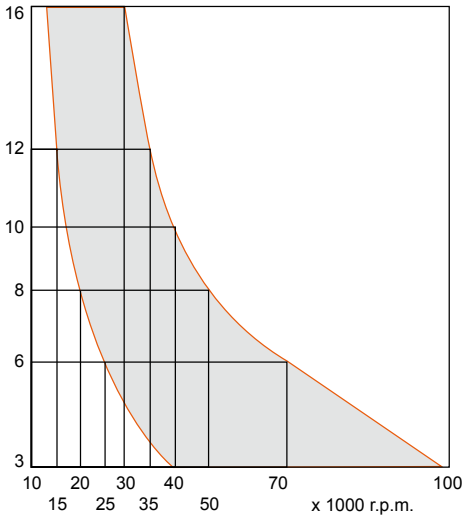
### Tungsten Carbide

| Head Ø mm | Hardened steels, high-strength materials. | Unhardened steels, softer materials and cast iron. | Soft materials, aluminium, thermoplastics, brass. |
|---|---|---|---|
| | R.P.M x 1000 | R.P.M x 1000 | R.P.M x 1000 |
| 3 | 40 - 80 | 50 - 90 | 50 - 100 |
| 6 | 25 - 60 | 30 - 60 | 30 - 70 |
| 8 | 20 - 45 | 25 - 50 | 25 - 50 |
| 10 | 17 - 40 | 20 - 40 | 20 - 40 |
| 12 | 15 - 30 | 17 - 30 | 17 - 35 |
| 16 | 12 - 25 | 15 - 25 | 15 - 30 |

### High Speed Steel

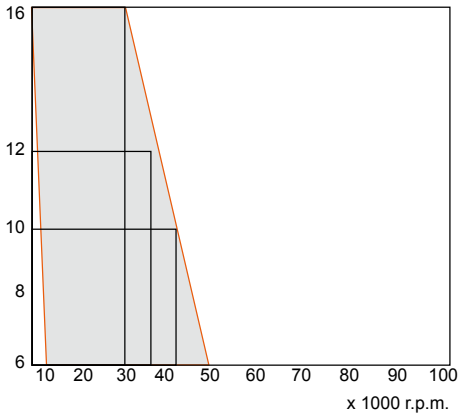
| Head Ø mm | Unhardened steels, softer materials and cast iron. | Soft materials, aluminium, thermoplastics, brass. |
|---|---|---|
| | R.P.M x 1000 | R.P.M x 1000 |
| | | |
| 6 | 5 - 20 | 20 - 40 |
| | | |
| 10 | 3 - 10 | 10 - 30 |
| 12 | 1 - 10 | 10 - 30 |
| 16 | 1 - 8 | 10 - 25 |

**Burr head, Ø mm**




For machining in harder materials use lower speed and finer cut. Note that the cutting performance is highly dependable on the machine bearing condition and the characteristics of the machine (the cutting speed must not slow down when deburring).

**Burr head, Ø mm**




* Additional sizes available on request.
* Bahco has a wide range of HSS rotary burrs, for an update of this assortment contact your Bahco local sales representative.

# Rotary **Burrs**

## A = Cylindrical

| 3 mm | 6 mm | 8 mm | 10 mm | 12 mm | 16 mm |
|---|---|---|---|---|---|
| A0313C03 | A0610F06D | A0810F06D | A1020C06 | A1225AL06E | A1625C06 |
| A0313F03 | A0613M03X | A0820C06 | A1020F06 | A1225AL08E | A1625C08 |
| A0313F03E | A0616AL06E | A0820F06 | A1020M06 | A1225C06 | A1625F06 |
| A0313M03 | A0616C06 | A0820F06E | A1020M06E | A1225C08 | A1625F08 |
| A0313M03E | A0616F06 | A0820M06 | A1020M06X | A1225F06 | A1625M06 |
| A0313M03X | A0616M06 | A0820M06E | A1020M06XE | A1225F06E | A1625M06X |
| A0313M03XE | A0616M06DE | A0820M06X | A1040M06X | A1225F08 | A1625M06XE |
| A0313M03XE-60 | A0616M06E | A0820M06XE | A1050M06X | A1225M06 | A1625M08 |
| A0313M03XE-80 | A0616M06X | | | A1225M06DE | A1625M08E |
| A0320M03X | A0616M06XE | | | A1225M06E | A1625M08X |
| | A0625M06X | | | A1225M06X | A1625M08XE |
| | | | | A1225M06XE | |
| | | | | A1225M08 | |
| | | | | A1225M08E | |
| | | | | A1225M08X | |
| | | | | A1225M08XE | |


## C = Cylindrical round nose

| 3 mm | 6 mm | 8 mm | 10 mm | 12 mm | 16 mm |
|---|---|---|---|---|---|
| C0313C03 | C0613M03X | C0820C06 | C1020C06 | C1225AL06 | C1625C06 |
| C0313F03 | C0616AL06 | C0820F06 | C1020F06 | C1225AL08 | C1625C08 |
| C0313M03 | C0616C06 | C0820M06 | C1020M06 | C1225C06 | C1625F06 |
| C0313M03X | C0616F06 | C0820M06X | C1020M06X | C1225C08 | C1625F08 |
| | C0616M03X | | | C1225F06 | C1625M06 |
| | C0616M06 | | | C1225F08 | C1625M06X |
| | C0616M06D | | | C1225M06 | C1625M08 |
| | C0616M06X | | | C1225M06X | C1625M08X |
| | | | | C1225M08 | |
| | | | | C1225M08X | |


## D = Spherical

| 3 mm | 6 mm | 8 mm | 10 mm | 12 mm | 16 mm |
|---|---|---|---|---|---|
| D0303C03 | D0605M03X | D0807C06 | D1009C06 | D1211AL06 | D1614C06 |
| D0303F03 | D0606C06 | D0807F06 | D1009F06 | D1211AL08 | D1614C08 |
| D0303M03 | D0606F06 | D0807M06 | D1009M06 | D1211C06 | D1614F06 |
| D0303M03X | D0606M06 | D0807M06X | D1009M06X | D1211F06 | D1614F08 |
| | D0606M06X | | | D1211F06D | D1614M06 |
| | | | | D1211M06 | D1614M06X |
| | | | | D1211M06X | D1614M08 |
| | | | | | D1614M08X |


## E = Oval

| 3 mm | 6 mm | 8 mm | 10 mm | 12 mm | 16 mm |
|---|---|---|---|---|---|
| E0308C03 | E0614C06 | E0816C06 | E1018C06 | E1222C06 | E1625C06 |
| E0308F03 | E0614F06 | E0816F06 | E1018F06 | E1222C08 | E1625C08 |
| E0308M03 | E0614M06 | E0816M06 | E1018M06 | E1222F06 | E1625F06 |
| E0308M03X | E0614M06X | E0816M06X | E1018M06X | E1222F08 | E1625F08 |
| | | | | E1222M06 | E1625M06 |
| | | | | E1222M06X | E1625M06X |
| | | | | E1222M08 | E1625M08 |
| | | | | E1222M08X | E1625M08X |


## F = Arch round nose

| 3 mm | 6 mm | 8 mm | 10 mm | 12 mm | 16 mm |
|---|---|---|---|---|---|
| F0313C03 | F0612C04 | F0820C06 | F1020C06 | F1225AL06 | F1625C06 |
| F0313F03 | F0612F04 | F0820F06 | F1020F06 | F1225AL08 | F1625C08 |
| F0313M03 | F0612M04 | F0820M06 | F1020M06 | F1225C06 | F1625F06 |
| F0313M03X | F0612M04X | F0820M06X | F1020M06X | F1225C08 | F1625F08 |
| | F0613M03X | | | F1225F06 | F1625M06 |
| | F0618AL06 | | | F1225F08 | F1625M06X |
| | F0618C06 | | | F1225M06 | F1625M08 |
| | F0618F06 | | | F1225M06X | F1625M08X |
| | F0618M06 | | | F1225M08 | |
| | F0618M06X | | | F1225M08X | |


* Additional sizes available on request.
* Bahco has a wide range of HSS rotary burrs, for an update of this assortment contact your Bahco local sales representative.

# Rotary **Burrs**

## G = Arch pointed nose

| 3 mm | 6 mm | 8 mm | 10 mm | 12 mm | 16 mm |
|---|---|---|---|---|---|
| G0313C03 | G0613M03X | G0820C06 | G1020C06 | G1225C06 | G1625C06 |
| G0313F03 | G0618C06 | G0820F06 | G1020F06 | G1225C08 | G1625C08 |
| G0313M03 | G0618F06 | G0820M06 | G1020M06 | G1225F06 | G1625F06 |
| G0313M03X | G0618M06 | G0820M06X | G1020M06X | G1225F08 | G1625F08 |
| | G0618M06X | G0845M6.6X | G1050M8.3X | G1225M06 | G1625M06 |
| | G0645M4.9X | | | G1225M06X | G1625M06X |
| | | | | G1225M08 | G1625M08 |
| | | | | G1225M08X | G1625M08X |

## H = Flame

| 3 mm | 6 mm | 8 mm | 10 mm | 12 mm | 16 mm |
|---|---|---|---|---|---|
| | H0613M03X | | H1025C06 | H1232M06 | H1635C06 |
| | | | H1025F06 | H1232M06X | H1635C08 |
| | | | H1025M06 | | H1635F06 |
| | | | H1025M06X | | H1635F08 |
| | | | H1025M08 | | H1635M06 |
| | | | | | H1635M06X |
| | | | | | H1635M08 |
| | | | | | H1635M08X |

## J = 60º cone

| 3 mm | 6 mm | 8 mm | 10 mm | 12 mm | 16 mm |
|---|---|---|---|---|---|
| | J0604C06 | | J1010C06 | J1212M06 | J1616C06 |
| | J0604F06 | | J1010F06 | | J1616C08 |
| | J0604M06 | | J1010M06 | | J1616F06 |
| | | | | | J1616F08 |
| | | | | | J1616M06 |
| | | | | | J1616M08 |

## K = 90º cone

| 3 mm | 6 mm | 8 mm | 10 mm | 12 mm | 16 mm |
|---|---|---|---|---|---|
| | K0602C06 | | K1008C06 | K1210C06 | K1612C06 |
| | K0602F06 | | K1008F06 | K1210F06 | K1612C08 |
| | K0602M06 | | K1008M06 | K1210M06 | K1612F06 |
| | | | | | K1612F08 |
| | | | | | K1612M06 |
| | | | | | K1612M08 |

## L = Conical round nose

| 3 mm | 6 mm | 8 mm | 10 mm | 12 mm | 16 mm |
|---|---|---|---|---|---|
| | | | L1020C06 | L1225F06 | L1630C06 |
| | | | L1020F06 | L1225M06 | L1630C08 |
| | | | L1020M06 | L1225M06X | L1630F06 |
| | | | L1020M06X | L1230AL06 | L1630F08 |
| | | | | L1230AL08 | L1630M06 |
| | | | | L1230C06 | L1630M06X |
| | | | | L1230F06 | L1630M08 |
| | | | | L1230M06 | L1630M08X |
| | | | | L1230M06X | |

## M = Conical pointed nose

| 3 mm | 6 mm | 8 mm | 10 mm | 12 mm | 16 mm |
|---|---|---|---|---|---|
| M0310C03 | M0613M03X | | M1022C06 | M1227C06 | M1630C06 |
| M0310F03 | M0618C06 | | M1022F06 | M1227C08 | M1630C08 |
| M0310M03 | M0618F06 | | M1022M06 | M1227F06 | M1630F06 |
| M0310M03X | M0618M06 | | M1022M06D | M1227F08 | M1630F08 |
| | M0618M06X | | M1022M06X | M1227M06 | M1630M06 |
| | | | | M1227M06X | M1630M06X |
| | | | | M1227M08 | M1630M08 |
| | | | | M1227M08X | M1630M08X |

## N = Inverted nose

| 3 mm | 6 mm | 8 mm | 10 mm | 12 mm | 16 mm |
|---|---|---|---|---|---|
| N0306C03 | N0607C06 | | | N1213C06 | N1613C06 |
| N0306F03 | N0607F06 | | | N1213F06 | N1613C08 |
| N0306M03 | N0607M06 | | | N1213M06 | N1613F06 |
| N0306M03E | N0607M06E | | | N1213M06E | N1613F08 |
| | | | | | N1613M06 |
| | | | | | N1613M06E |
| | | | | | N1613M06X |
| | | | | | N1613M08 |

* Additional sizes available on request.
* Bahco has a wide range of HSS rotary burrs, for an update of this assortment contact your Bahco local sales representative.


**BAHCO IS A WORLD LEADER** in producing a broad range of metal cutting and hand tools used by professionals in the construction and engineering industries as well as automotive, aeronautical, electronic, telecommunication and horticultural industries.

**BAHCO IS GLOBALLY** renowned for quality, performance and value for money. Professionals the world over rely on our tools, and for good reasons: we control the entire cycle, from basic research through product development and manufacturing to distribution. We regularly launch innovations that help users do a better job and do it more easily.

**WE SPECIFY AND DESIGN** all Bahco tools are of high quality and have a unique design, intended to give the best professional performance.

**THE RESULT IS BETTER** ergonomic hand tools are easier to use, more comfortable to hold and significantly more functional, because they are developed in close cooperation with professional users, together with specialists in industrial design.

**QUALITY AND ERGONOMICS** has made us one of the world´s largest manufacturers of tools for professional use within a wide range of industries.

7 314150 180226 >

BAHCO

www.bahco.com

IND-0675-INT

SNA Europe