PRECISION
QUALITY
INNOVATION

Starrett®

BAND SAW BLADES

BI-METAL

CARBIDE

HIGH CARBON

DIAMOND GRIT

WOOD CUTTING

FOOD
PROCESSING

POWER
HACKSAWS

BAND SAW
MACHINES

TECHNICAL
SERVICES &
SUPPORT

CATALOGUE 60E
REVISED 2020

PRECISION, QUALITY, INNOVATION

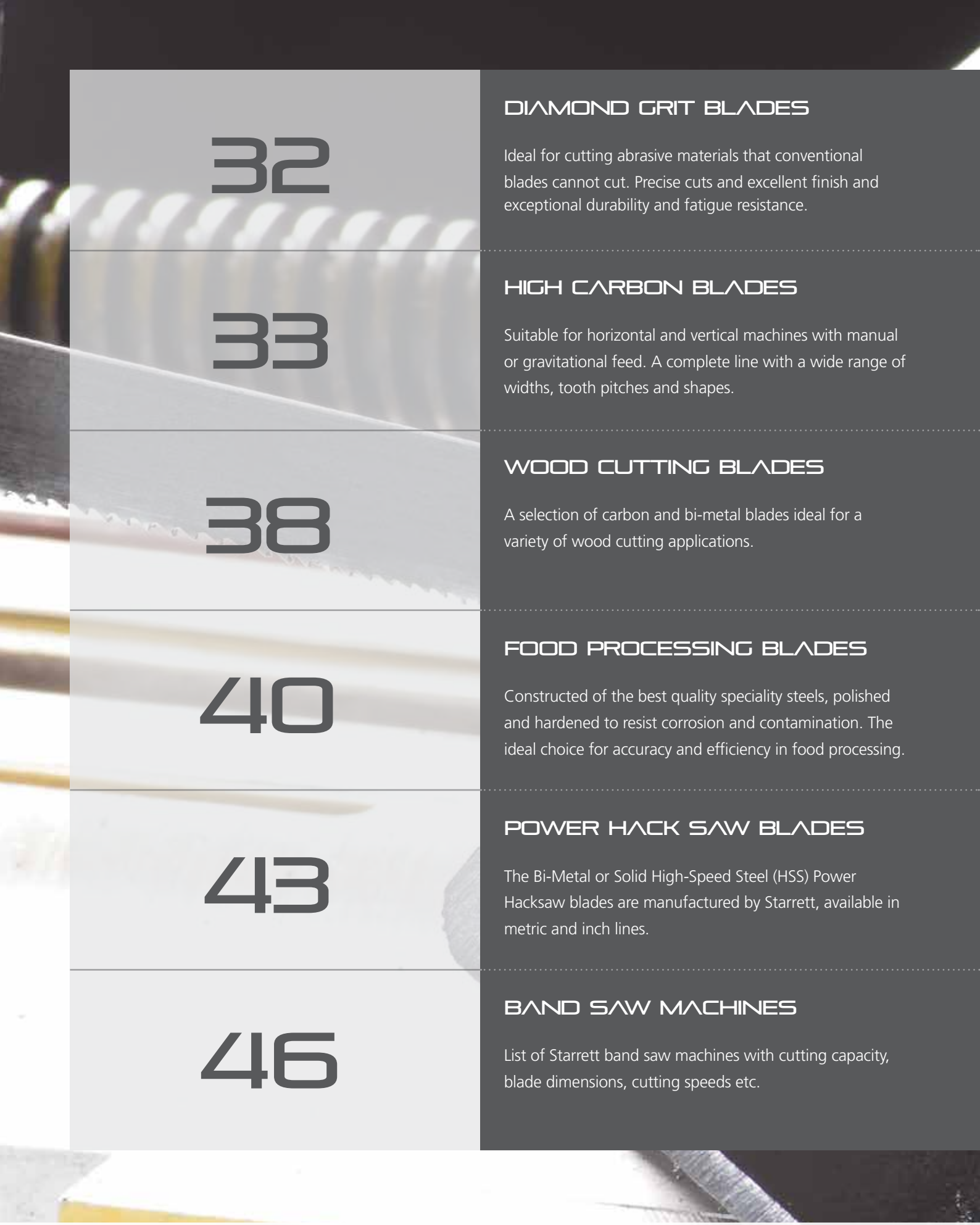
For more than 130 years, manufacturers, builders and craftsmen worldwide have depended upon saws and precision tools from the L.S. Starrett Company to ensure the consistent quality of their manufacturing processes.

They know that the Starrett name on saw blades, hand tools and measuring tools means exceptional quality, innovative products and expert technical assistance.

With strict quality control, state-of-the-art equipment and an ongoing commitment to producing products with superior quality, the 5,000 plus products in today's Starrett line continue to be the most accurate, robust and durable tools available.

This catalogue features Starrett Band Saw Blades, their applications and characteristics, Starrett Power Hacksaw Blades and Starrett Band Saw Machines.

BAND SAW BLADES



BAND SAW BLADES

WORLDWIDE MANUFACTURING

1 - Athol, Massachusetts, USA

2 - Laguna Hills, California, USA

3 - Waite Park, Minnesota, USA

4 - Cleveland, Ohio, USA

5 - Mount Airy, North Carolina, USA

6 - Columbus, Georgia, USA

7 - Itu, São Paulo, Brazil

8 - Jedburgh, Scotland

9 - Suzhou, China

TERMINOLOGY

A - WIDTH
Tip of the cutting edge to the back of the blade.

B - BLADE BODY
Distance between the back of the blade and the gullet.

C - LENGTH
Measurement along the back edge of the blade.

D - THICKNESS
Measurement of the body of the blade.

E - BACK EDGE
Opposite side of the blade from the teeth.

F - TOOTH PITCH
Distance from the tip of one tooth to the next tip.

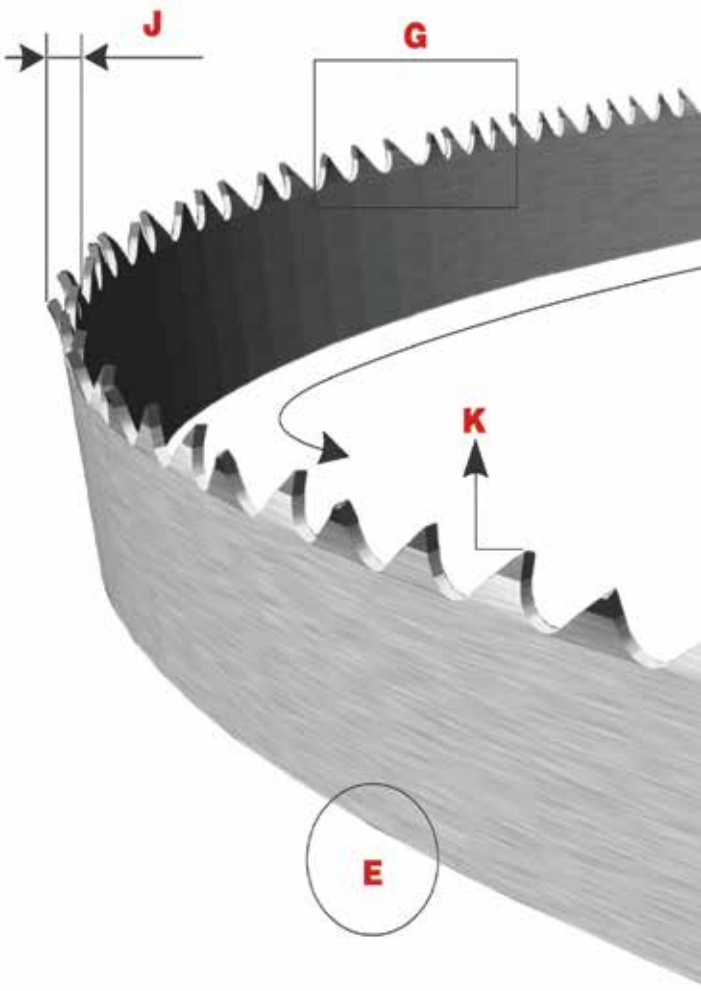
G - TEETH PER INCH / 25MM
Number of teeth per inch (25.4mm).

H - GULLET
The curved area between two teeth, where the chips accumulate until being removed.

I - TOOTH FACE
Surface of the tooth where the chip is formed. The tooth can have a positive, negative or straight angle. (Rake)

J - TOOTH SET
The bending of the teeth (right and left) to allow blade clearance through the cut.

K - BACK ANGLE
Angle formed by the back of the teeth and a parallel line to the tip of the same.

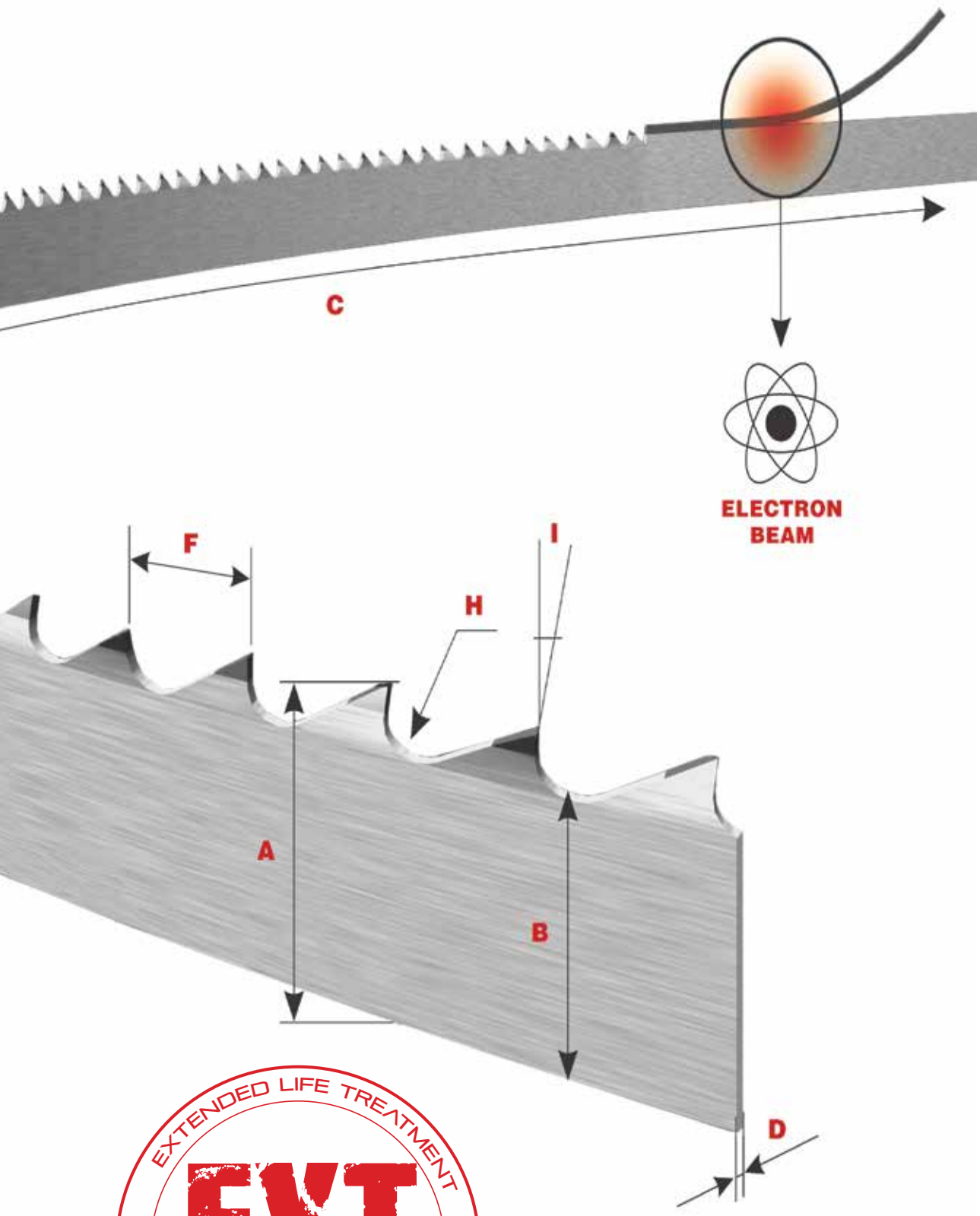


Starrett®
bi-metal unique®
saw technology

170% MORE WELD CONTACT AREA

MULTIPLE CUTTING EDGES

SPLIT CHIP ADVANTAGE



EXTENDED LIFE TREATMENT
EXT™
Starrett®
SAW SOLUTIONS

The Starrett Primalloy Band Saw product line applies a proprietary Extended Life Treatment (EXT) to its alloy steel backing material. This process, in addition to controlled blast peening, enhances the fatigue life of the blade, aiding in the reduction of fatigue cracks that originate along microscopic grain boundaries.

CHOOSING THE CORRECT BLADE

1 Quick Guide

★★★
★★
★
PERFORMANCE

		METALLICS					
		Aluminium	Tubes and Profiles	Carbon Steel	Carbon Steel Alloys	Cast Iron	Copper Alloys
							
BI-METAL	Primalloy™ Page 18				★★★	★★★	★★★
	Intenss™ PRO-VTH Page 19				★★		
	Intenss™ PRO Page 20	★★	★★	★★★	★★	★★	★★
	Versatix™ MP Page 21	★	★★★	★★			
	Intenss™ Page 22	★★	★★	★★	★	★★	★
	Intenss™ PRO-DIE Page 23	★★	★★	★★	★★		★
	Univerz™ Page 24	★	★★	★			
CARBIDE	Advanz™ MC7 Page 26			★★★	★★★		
	Advanz™ MC5 Page 27	★★★				★★★	★★★
	Advanz™ TS Page 28			★★★	★★★	★	
	Advanz™ CS Page 29						
	Advanz™ FS Page 30	★★★				★★★	★★★
	Advanz™ CG Page 31						
DIAMOND	Advanz™ DG Page 32						
HIGH CARBON	Duratec™ Super FB Page 34	★	★	★			
	Duratec™ FC Page 36						
	Band Knives Page 37						
WOOD	Woodpecker™ Premium Page 39						
	Woodpecker™ Pro Page 39	★★★					
FOOD PROCESSING	Meatkutter™ Premium Page 41						
	Meatkutter™ Stainless Page 41						
	Meatkutter™ Frozen Page 42						
	Carcasskutter™ Page 42						

CHOOSING THE CORRECT BLADE

METALLICS				NON METALLICS			
HSS, Nickel & Titanium Alloys 	Stainless Steel 	Tool Steel - Hot & Cold Work 	Steel with hardness above 45 HRC 	Composite materials and abrasives 	Foam, Paper, Plastic & Rubber 	Wood 	Food 
★★★	★★★	★★★					
★★	★★	★★					
★★	★★	★★				★	
						★★	
★	★★	★				★★	
						★	
★★★	★★★	★★★	★★★				
			★★				
★★★	★★★	★★★	★★			★★	
			★★★				
			★			★★★	
			★★★	★★★			
				★★★			
					★★★	★★	
				★★	★	★★	
					★★★		★★
					★★★	★★★	★
					★★	★★★	
					★★	★	★★★
							★★★
						★	★★★
							★★

CHOOSING THE CORRECT BLADE

2 Tooth Shapes

Intenss™ PRO-VTH

Intenss™ PRO-VTH

- Variable tooth height providing pulsating action
- Easy penetration
- Ideal for cutting hard and difficult to machine materials

PS Teeth

Primalloy™ / Intenss™ PRO / Intenss™ PRO-DIE / Univerz™

- Positive Rake angle
- Double back angle
- Fast and efficient chip clearance
- Excellent choice for a wide range of cuts

Versatix™ MP

Versatix™ MP

- Extremely robust, shockproof
- Positive Rake angle
- Ideal for cutting tubes and profiles

Regular

Intenss™ / Duratec™ Super FB / Duratec™ FC / Univerz™

- Standard 0° Rake
- Shock resistant
- Excellent choice for a wide range of cuts
- Suitable for all types of machines

BR Teeth

Intenss™ PRO

- Unique profile, patented by Starrett®
- Extremely robust
- Positive Rake angle
- Fast and efficient chip clearance

Hook

Duratec™ Super FB / Intenss™ PRO-DIE / Woodpecker™ Premium

- Positive Rake angle, extremely aggressive
- Faster cuts
- Suitable for cutting non-ferrous and non-metallic metals

Skip

Duratec™ Super FB / Woodpecker™ Premium

- Standard 0° Rake
- Shock resistant
- Suitable for cutting non-ferrous and non-metallic metals

Advanz™

Advanz™ MC7 / Advanz™ MC5 / Advanz™ TS / Advanz™ CS / Advanz™ FS

- Differential tooth design, accurately ground
- Faster cuts
- Ideal for cutting hard and difficult to machine materials

Advanz™ with GULLET

Advanz™ CONTINUOUS

Advanz™ CG / Advanz™ DG

- Cutting edge coated with grains, continuous or with gullet
- Suitable for cutting abrasive or hardened materials

CHOOSING THE CORRECT BLADE

TOOTH

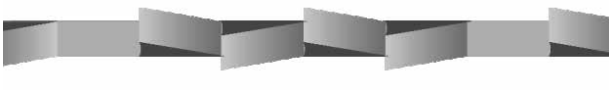
Constant Pitch

All teeth on the blade have uniform spacing. The tooth is defined through the number of teeth per inch (25.4mm).
Example: 4 TPI.

Variable Pitch

Variable distance between the tips of the teeth on the blade. Size of tooth and depth of gullet varies to substantially reduce noise levels and vibrations.
Example: 4-6 TPI.

SETS

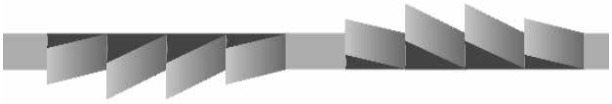


Raker

A recurring sequence of teeth set left and right, followed by one tooth unset.

Progressive

Groups of teeth set to each side of the blade, with progressive set followed by one tooth unset.



Wavy

Groups of teeth set to each side of the blade, with varying amounts of set in a controlled pattern.

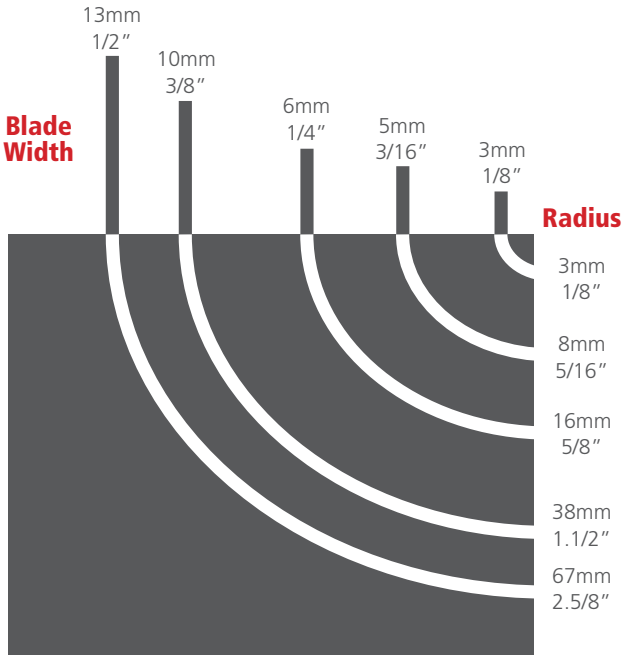
Trapezoidal

Special carbide cylinder welded in the tooth edge, being slightly thicker than the blade, and triple chip grind.

CHOOSING THE CORRECT BLADE

3 Blade Width

Use the blade width recommended by the machine manufacturer, except for contour cutting in vertical machines when you should use the chart below.



4 Pitch

Pitch is the number of teeth per inch or 25.4mm. Cutting thinner sections requires a finer pitch (more teeth per inch/25mm). Thick sections require coarser pitches (fewer teeth per inch/25mm).
The charts are good guidelines. Because the cross section limits in the chart are broad and overlap, choose a coarser pitch if the speed of cut is most important. Choose a finer pitch if finish is most important.

MASSIVE		
Section to be cut (mm)	**Constant Pitch (TPI)**	**Variable Pitch**
4 to 10	32 or 24	14-18
6 to 13	18 or 14	10-14
13 to 19	14 or 10	8-12
19 to 25	10 or 8	6-10
25 to 38	8 or 6	5-8
38 to 88	6 or 4	4-6
88 to 180	4 or 3	3-4
180 to 250	3	2-3
250 to 400	–	1.4-2
350 to 500	1.3	1-2
400 to 800	1.3	1-1.2
Above 750	1	.8-1.3 / .9-1.1

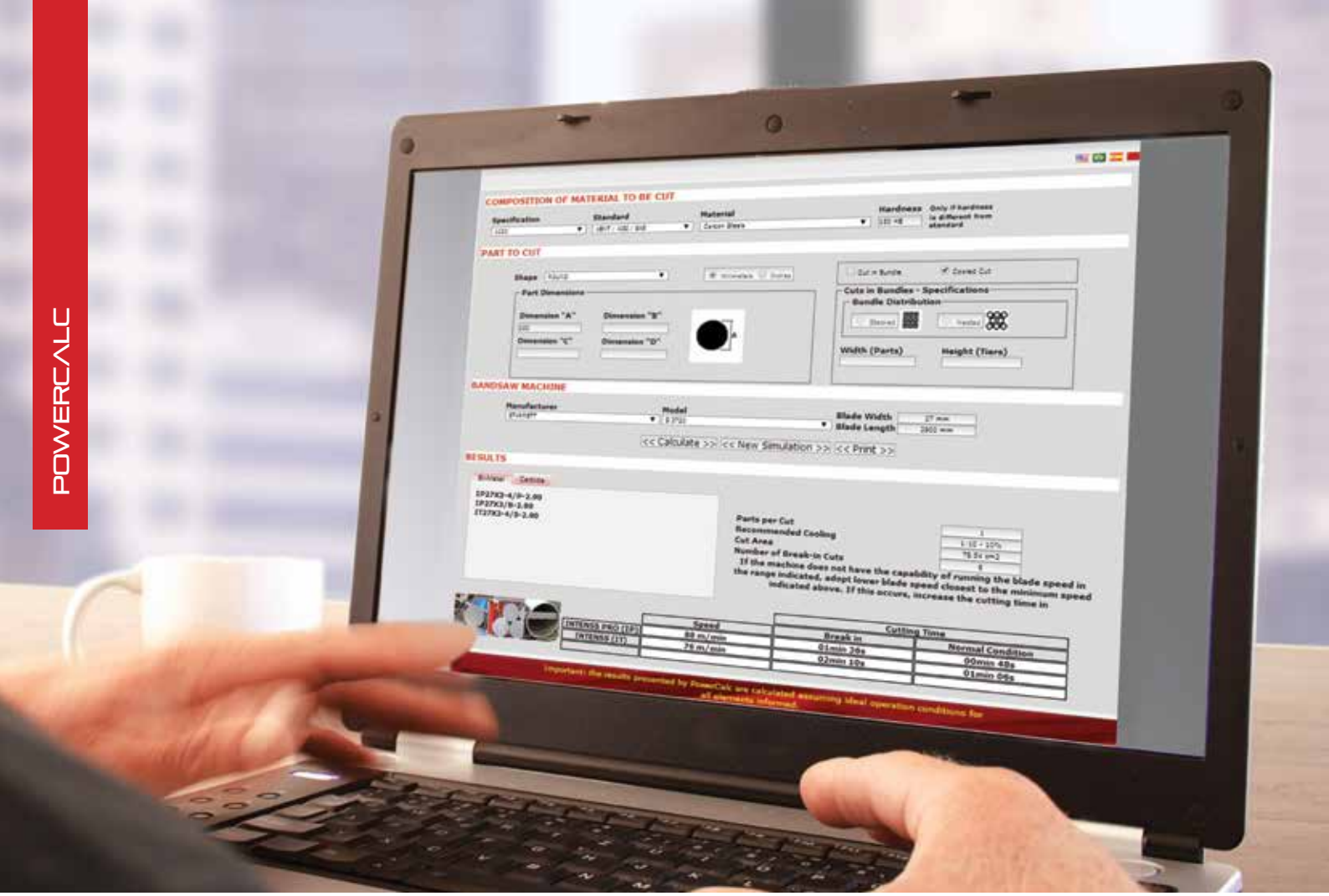
For cutting tubes and profiles, use the horizontal line to find the outside diameter (tube) or the largest section (profile). Find the thickness (tube/profile) using the vertical column. With that information, cross them to find the recommended pitch. (chart below).

TUBES AND PROFILES													
Wall thickness	**Outside diameter of tube or maximum profile section length (mm)**												
(mm)	**10**	**20**	**40**	**60**	**80**	**100**	**120**	**150**	**200**	**300**	**400**	**500**	**600**
2	14-18	14-18	10-14	10-14	10-14	10-14	8-12	8-12	8-12	8-12	6-10	6-10	5-8
3	10-14	10-14	10-14	10-14	10-14	8-12	8-12	8-12	6-10	6-10	6-10	5-8	5-8
4		8-12	8-12	8-12	8-12	6-10	6-10	6-10	5-8	5-8	4-6	4-6	4-6
5		6-10	6-10	6-10	6-10	5-8	5-8	5-8	5-8	4-6	4-6	4-6	4-6
6		5-8	5-8	5-8	5-8	5-8	5-8	5-8	4-6	4-6	4-6	4-6	3-4
8			4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	3-4	3-4	3-4
10			4-6	4-6	3-4	3-4	3-4	3-4	3-4	3-4	3-4	2-3	2-3
12				4-6	3-4	3-4	3-4	3-4	3-4	3-4	2-3	2-3	2-3
15				4-6	3-4	3-4	3-4	3-4	3-4	2-3	2-3	2-3	2-3
20				4-6	3-4	3-4	3-4	3-4	3-4	2-3	2-3	2-3	2-3
25					3-4	3-4	3-4	3-4	2-3	2-3	2-3	1.4-2	1.4-2
30					3-4	3-4	3-4	3-4	2-3	2-3	2-3	1.4-2	1.4-2
40						3-4	3-4	3-4	2-3	2-3	2-3	1.4-2	1.4-2
50							3-4	3-4	2-3	2-3	1.4-2	1.4-2	1-1.2
60									2-3	2-3	1.4-2	1.4-2	1-1.2

CHOOSING THE CORRECT BLADE

5 Blade Length

The blade length varies according to the band saw machine type and specifications. Please find the correct blade length on your band saw machine user manual.



POWERCALC

The online PowerCalc Software helps you to choose the correct Band Saw Blade:

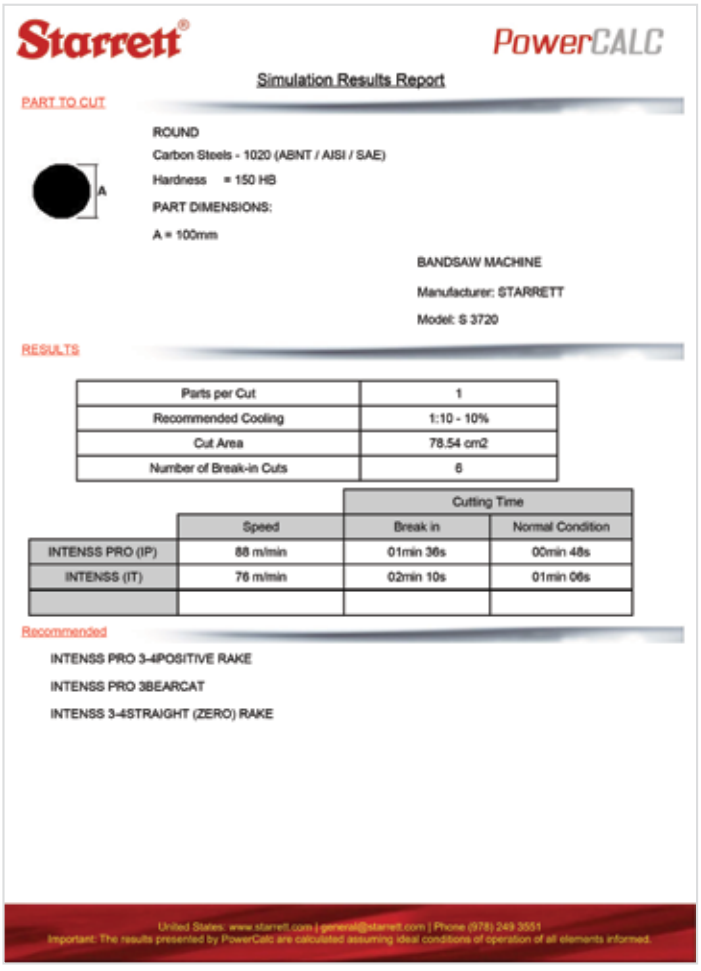
- Assistance in choosing the correct Starrett Blade
- Calculating blade speed and cutting rate for a better performance
- Recommendations of the correct coolant ratio for longer life

POWERCALC DIFFERENTIALS

- The database includes the world's leading band saw machine manufacturers
- PowerCalc generates cutting data reports to improve production performance
- The simulations are recorded in the programme, and can be accessed at any time

HOW TO USE POWERCALC

- The online software is free.
- Access:
  info.starrett.com/powercalc-download



Starrett® PowerCALC

Simulation Results Report

PART TO CUT

ROUND
Carbon Steels - 1020 (ABNT / AISI / SAE)
Hardness = 150 HB
PART DIMENSIONS:
A = 100mm

BANDSAW MACHINE
Manufacturer: STARRETT
Model: S 3720

RESULTS

Parts per Cut	1
Recommended Cooling	1:10 - 10%
Cut Area	78.54 cm2
Number of Break-in Cuts	6

	Cutting Time	
Speed	Break in	Normal Condition
INTENSS PRO (IP)	88 m/min	01min 36s	00min 48s
INTENSS (IT)	76 m/min	02min 10s	01min 06s

Recommended

INTENSS PRO 3-4POSITIVE RAKE
INTENSS PRO 3BEARCAT
INTENSS 3-4STRAIGHT (ZERO) RAKE

BI-METAL BAND SAW BLADES

BI-METAL

PRIMALLOY™

FEATURES

- Special high-speed steel edge
- Exclusive tooth geometry with positive rake angle
- Extended Life Treatment (EXT) functionality - ensures maximum fatigue life
- Ground teeth

BENEFITS

High Cobalt and Vanadium content on teeth guarantees:

- Longer blade life with high quality surface finish
- Increased wear and heat resistance
- Easy penetration in hard and difficult to machine materials, increasing the blade performance
- Cost-effective over conventional bi-metal blades

APPLICATIONS

- Tool steel and high speed steel
- Stainless steels
- Nickel and titanium alloys
- Hardened steel
- For machines with hydraulic feed control

Width x Thickness		Pitch
mm	inches	
27 x 0.90	1 x .035	3 - 4
34 x 1.10	1.1/4 x .042	2 - 3
		3 - 4
41 x 1.30	1.1/2 x .050	1.4 - 2
		2 - 3
		3 - 4
54 x 1.60	2 x .063	1 - 1.2
		1.4 - 2
		2 - 3
		3 - 4
67 x 1.60	2.5/8 x .063	1 - 1.2
		1.4 - 2
		2 - 3

Available as welded bands and random length coils.
Note: Special products on request.

BI-METAL

INTENSS™ PRO-VTH

FEATURES

- Uniquely designed tooth edge with variable height and set
- Ground Teeth with positive rake angle

BENEFITS

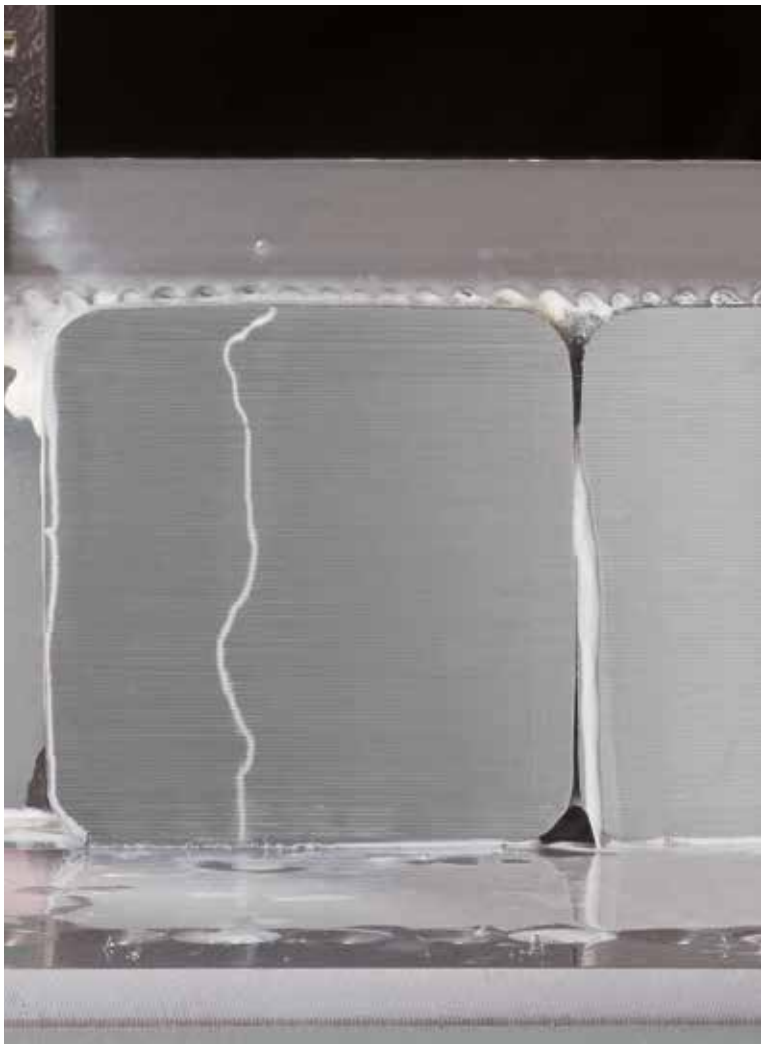
- Easy penetration with faster cuts
- Excellent heat and wear resistance
- Pulsating action allows the teeth to cut in a fast action

APPLICATIONS

- Tool steel and high speed steel
- Stainless steels
- Hardened Copper and aluminium Bronze Alloys
- For machines with hydraulic feed control
- Ideal for cutting all steels and non-ferrous metals up to 40 HRC

Width x Thickness		Pitch
mm	inches	
27 x 0.90	1 x .035	2 - 3
		3 - 4
		4 - 6
34 x 1.10	1.1/4 x .042	2 - 3
		3 - 4
		4 - 6
41 x 1.30	1.1/2 x .050	2 - 3
		3 - 4
54 x 1.60	2 x .063	1 - 1.2
		1.4 - 2
67 x 1.60	2.5/8 x .063	1.4 - 2
80 x 1.60	3.1/8 x .063	1 - 1.2
		1.4 - 2

Raker Tooth Set
Furnished in welded bands and in random length coils.
Note: Special products on request.



BI-METAL

INTENSS™ PRO

FEATURES

- Complete line with a wide range of widths and pitches to suit a huge variety of cutting needs
- Unique tooth geometry provides intense production cutting in ferrous and non-ferrous metals

BENEFITS

- Faster and straighter cuts
- Improved fatigue and wear resistance

APPLICATIONS

- Ideal for production cutting across a wide range of metals
- For solids and thick wall tubes

Width x Thickness		Pitch
mm	inches	
19 x 0.90	3/4 x .035	3 - 4
		4 - 6
		5 - 8
		6 - 10
27 x 0.90	1 x .035	2 - 3
		3 - 4
		4 - 6
		5 - 8
		6 - 10
		3*
34 x 1.10	1.1/4 x .042	2 - 3
		3 - 4
		4 - 6
		5 - 8
		6 - 10
41 x 1.30	1.1/2 x .050	1 - 1.2
		1.4 - 2
		2 - 3
		3 - 4
		4 - 6
		5 - 8
54 x 1.60	2 x .063	0.8 - 1.3
		1 - 1.2
		1.4 - 2
		2 - 3
		3 - 4
67 x 1.60	2.5/8 x .063	0.8 - 1.3
		1 - 1.2
		1.4 - 2
80 x 1.60	3.1/8 x .063	0.8 - 1.3
		1 - 1.2
		1.4 - 2

PS Tooth Shape * = BR Tooth Shape
Raker Tooth Set
Furnished in welded bands and random length coils.
Note: Special products on request.

BI-METAL

VERSATIX™ MP

FEATURES

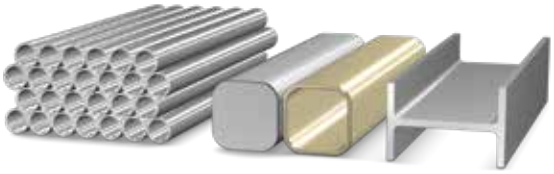
- Special tooth geometry developed for cutting structural materials
- Increased tooth strength

BENEFITS

- Faster and straighter cuts
- Less tooth breakage

APPLICATIONS

- Tubes and structurals
- Small solids
- Bundles
- For all machines: manual, hydraulic, gravitational etc.



Width x Thickness		Pitch
mm	inches	
19 x 0.90	3/4 x .035	4 - 6
		5 - 8
		6 - 10
		8 - 12
		10 - 14
27 x 0.90	1 x .035	3 - 4
		4 - 6
		5 - 8
		6 - 10
		8 - 12
		10 - 14
34 x 1.10	1.1/4 x .042	2 - 3
		3 - 4
		4 - 6
		5 - 8
		6 - 10

Width x Thickness		Pitch
mm	inches	
41 x 1.30	1.1/2 x .050	2 - 3
		3 - 4
		4 - 6
		5 - 8
54 x 1.60	2 x .063	2 - 3
		3 - 4
		4 - 6
67 x 1.60	2.5/8 x .063	2 - 3
		3 - 4

Raker Tooth Set
Furnished in welded bands and random length coils.
Note: Special products on request.

BI-METAL

INTENSS™

FEATURES

- Strong tooth geometry
- M42 high speed steel teeth combined with a fatigue resistant alloy backing material

BENEFITS

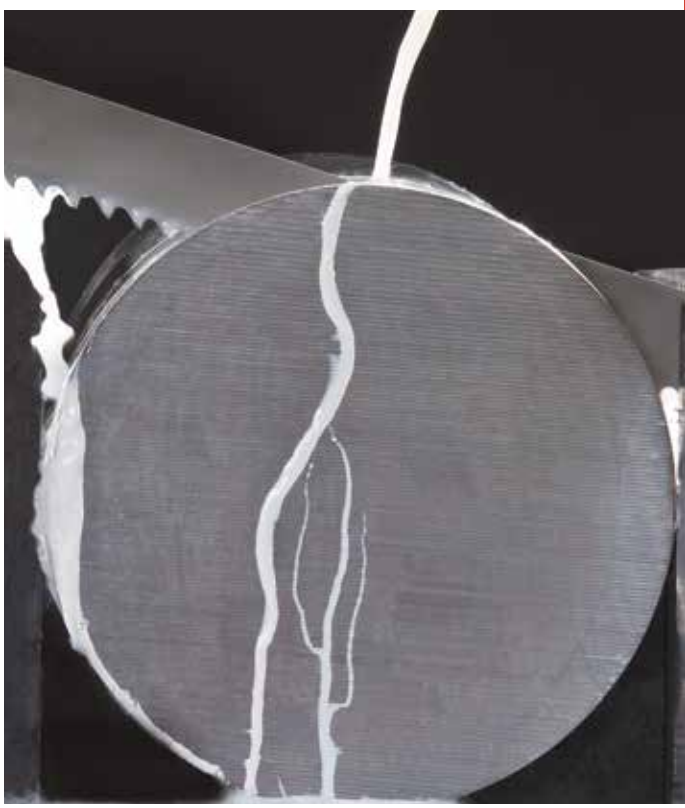
- Ideal for using with manual feed and vertical band saw machines, as well as conventional machines with gravitational feed
- Ideal for tool rooms, service and maintenance and small machine shops

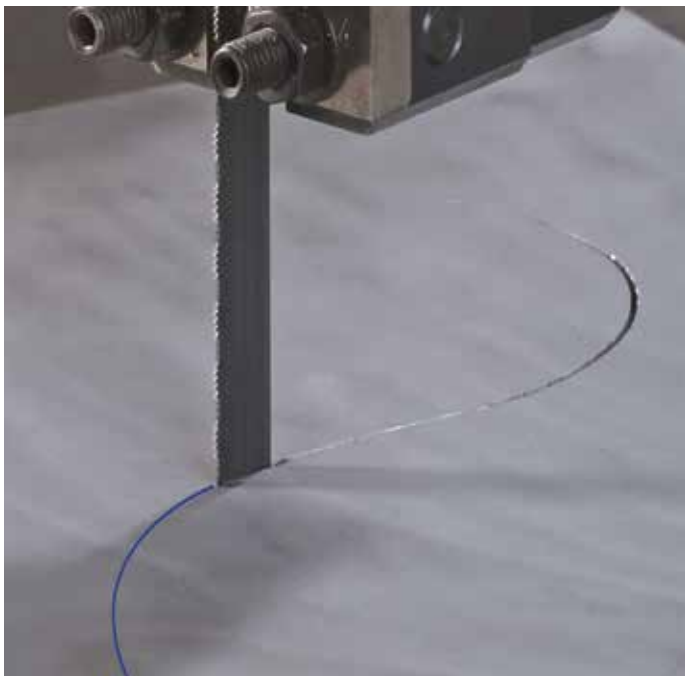
Width x Thickness		Pitch
mm	inches	
13 x 0.65	1/2 x .025	14
		18
13 x 0.90	1/2 x .035	10
		14
19 x 0.90	3/4 x .035	3 - 4
		4 - 6
		5 - 8
		6 - 10
		8 - 12
		10 - 14
		14
27 x 0.90	1 x .035	3 - 4
		4 - 6
		5 - 8
		6 - 10
		8 - 12
		10 - 14
		14
34 x 1.10	1.1/4 x .042	2 - 3
		3 - 4
		4 - 6
		5 - 8
		6 - 10
		8 - 12

Furnished in welded bands and random length coils.
Note: Special products on request.

APPLICATIONS

- Cut steel sheets, carbon steel solids and structurals, aluminium, copper, brass, cast iron, alloy steel, stainless steel etc.
- Cut small and medium solids





BI-METAL

INTENSS™ PRO-DIE

FEATURES

- Split Chip Advantage Technology
- Multiple cutting edges - Multi Edge Performance

BENEFITS

- Technology that allows faster cutting rates for longer blade life
- Cost-effective over conventional carbon steel blades
- Excellent fatigue, abrasion and shock resistance

APPLICATIONS

- Ideal for contour cutting on vertical machines
- Carbon steel and low alloy steels
- Sheet metal
- Die and Mould steel
- Stainless steel

Width x Thickness		Pitch
mm	inches	
6 x 0.65	1/4 x .025	10 - 14
		14 - 18
6 x 0.90	1/4 x .035	10 - 14
10 x 0.65	3/8 x .025	8 - 12
		10 - 14
		14 - 18
13 x 0.65	1/2 x .025	4*
		6*
		6 - 10
		8 - 12
		10 - 14
		14 - 18
13 x 0.90	1/2 x .035	4*
		6 - 10
		8 - 12
		10 - 14

PS Tooth (Variable Pitch)
* = HK Tooth (Constant Pitch)
All Raker Tooth Set apart from 14-18 TPI (Wavy Tooth Set)
Furnished in welded bands, random length coils and 30 metre (100') coils
Note: Special products on request

BI-METAL

UNIVERZ™

FEATURES

- Split Chip Advantage Technology
- Multiple cutting edges - Multiple Edge Performance
- Blade thickness: 0.50mm (0.020")

BENEFITS

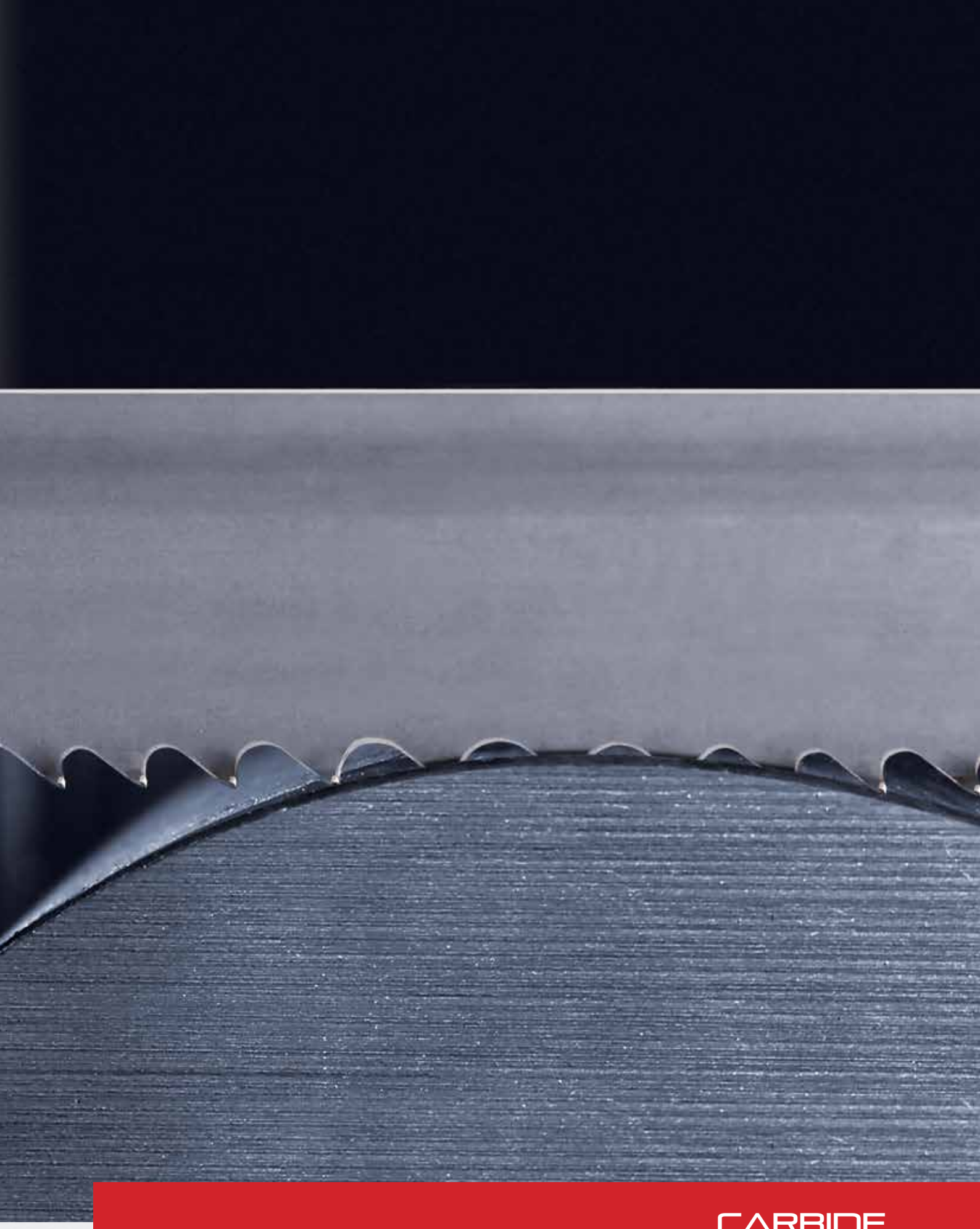
- Technology that allows faster cutting rates, increasing the blade life
- Cost-effective over conventional carbon steel blades
- Excellent fatigue, abrasion and shock resistance
- For contour cuts

APPLICATIONS

- Portable machines
- Vertical machines with reduced wheel diameter
- Ideal for metal work shops, construction and hobbyists
- Steel, iron, aluminium, metalon

Width x Thickness		Pitch
mm	inches	
13 x 0.35	1/2 x .014	10 - 14*
		14 - 18*
		24
13 x 0.50	1/2 x .020	10 - 14*
		14 - 18*
		10
		14
		18
		24

Regular Tooth Shape * = PS Tooth Shape
Furnished in 30 metre coils and welded bands.
Note: Special products on request.



CARBIDE

CARBIDE

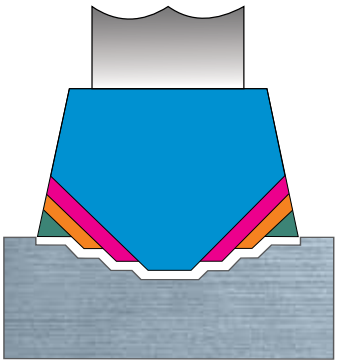
ADVANZ™ MC7

FEATURES

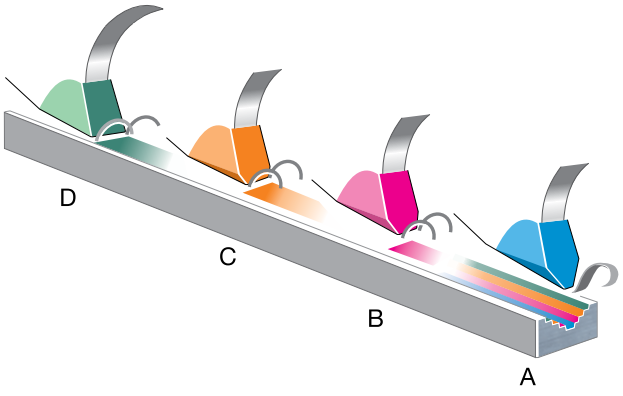
- Carbide tipped teeth
- Trapezoidal teeth with progressive grinding
- Ground Teeth forming 7 chips
- Positive Rake angle
- Dedicated geometry

BENEFITS

- Ideal for cutting ferrous metals
- Reduced cutting time
- Higher productivity
- Precise cuts and excellent finish
- Excellent cost-benefit ratio for production cutting



MC7 (Seven Multiple Chips)



APPLICATIONS

- Mechanical construction steels
- Tool steels, stainless steels
- Inconel
- Titanium
- For machines with hydraulic feed control

Width x Thickness		Pitch
mm	inches	
34 x 1.10	1.1/4 x .042	2 - 3
41 x 1.30	1.1/2 x .050	1.4 - 2
		2 - 3
54 x 1.60	2 x .063	1.4 - 2
		2 - 3
67 x 1.60	2.5/8 x .063	.9 - 1.1
		1.4 - 2

All blades are Trapezoidal Tooth Set
Furnished in welded bands and random length coils.
Note: Special products on request.

CARBIDE

ADVANZ™ MC5

FEATURES

- Carbide tipped teeth
- Ground Teeth forming 5 chips
- Positive Rake angle
- Dedicated geometry

BENEFITS

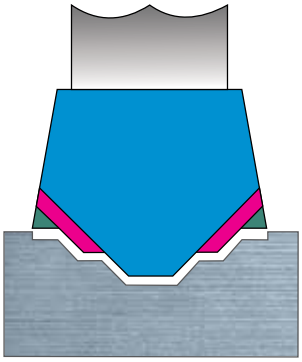
- Ideal for cutting ferrous metals
- Reduced cutting time
- Higher productivity
- Precise cuts and excellent finishing
- Excellent cost-benefit ratio for production cutting

APPLICATIONS

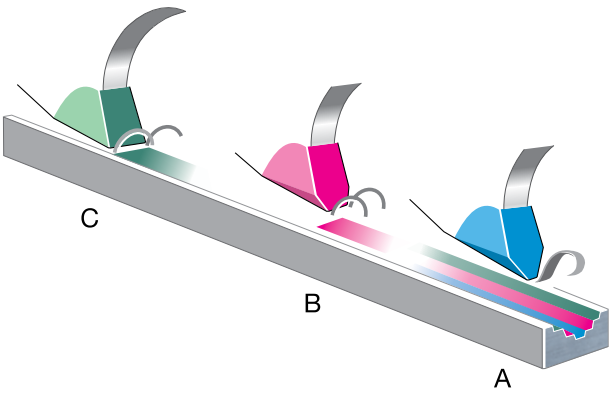
- Automotive aluminium casting blocks
- Cast iron
- Bronze
- Copper
- For machines with hydraulic feed control

Width x Thickness		Pitch
mm	inches	
34 x 1.10	1.1/4 x .042	2 - 3
41 x 1.30	1.1/2 x .050	1.4 - 2
		2 - 3
54 x 1.60	2 x .063	1.4 - 2
		2 - 3

All blades are Trapezoidal Tooth Set
Furnished in welded bands and random length coils.
Note: Special products on request.



MC5 (Five Multiple Chips)



CARBIDE

ADVANZ™ TS

FEATURES

- Carbide tipped teeth
- Triple chip tooth geometry
- Aggressive Rake angle

BENEFITS

- Ideal for cutting hard materials that bi-metal blades cannot cut
- Extreme resistance to wear when cutting difficult to machine steels
- Reduced cutting time-higher productivity
- Precise cuts and excellent finish

APPLICATIONS

- High-alloy metals
- Aerospace alloys
- Stainless steel
- Nickel alloys
- Hard and abrasive materials
- For machines with hydraulic feed control

Width x Thickness		Pitch
mm	inches	
19 x 0.90	3/4 x .035	3 - 4
		3
19 x 1.30	3/4 x .050	3
27 x 0.90	1 x .035	3 - 4
		3
34 x 1.10	1.1/4 x .042	2 - 3
		3 - 4
34 x 1.30	1.1/4 x .050	2 - 3
		3
41 x 1.30	1.1/2 x .050	1.4 - 2
		2 - 3
		3 - 4
		1
		1.3

Width x Thickness		Pitch
mm	inches	
41 x 1.30	1.1/2 x .050	3
54 x 1.60	2 x .063	1.4 - 2
		2 - 3
		1
		1.3
67 x 1.60	2.5/8 x .063	.9 - 1.1
		1.4 - 2
		2 - 3
80 x 1.60	3.1/8 x .063	.9 - 1.1
		1.4 - 2
		2 - 3
		1

All blades are Trapezoidal Tooth Set
Furnished in welded bands, random length coils, 40 metre coils (54mm - 80mm width blades only) and 45 metre coils (19mm - 41mm width blades only).
Note: Special products on request.

CARBIDE

ADVANZ™ CS

FEATURES

- Carbide tipped teeth
- Triple chip tooth geometry
- Negative Rake angle

BENEFITS

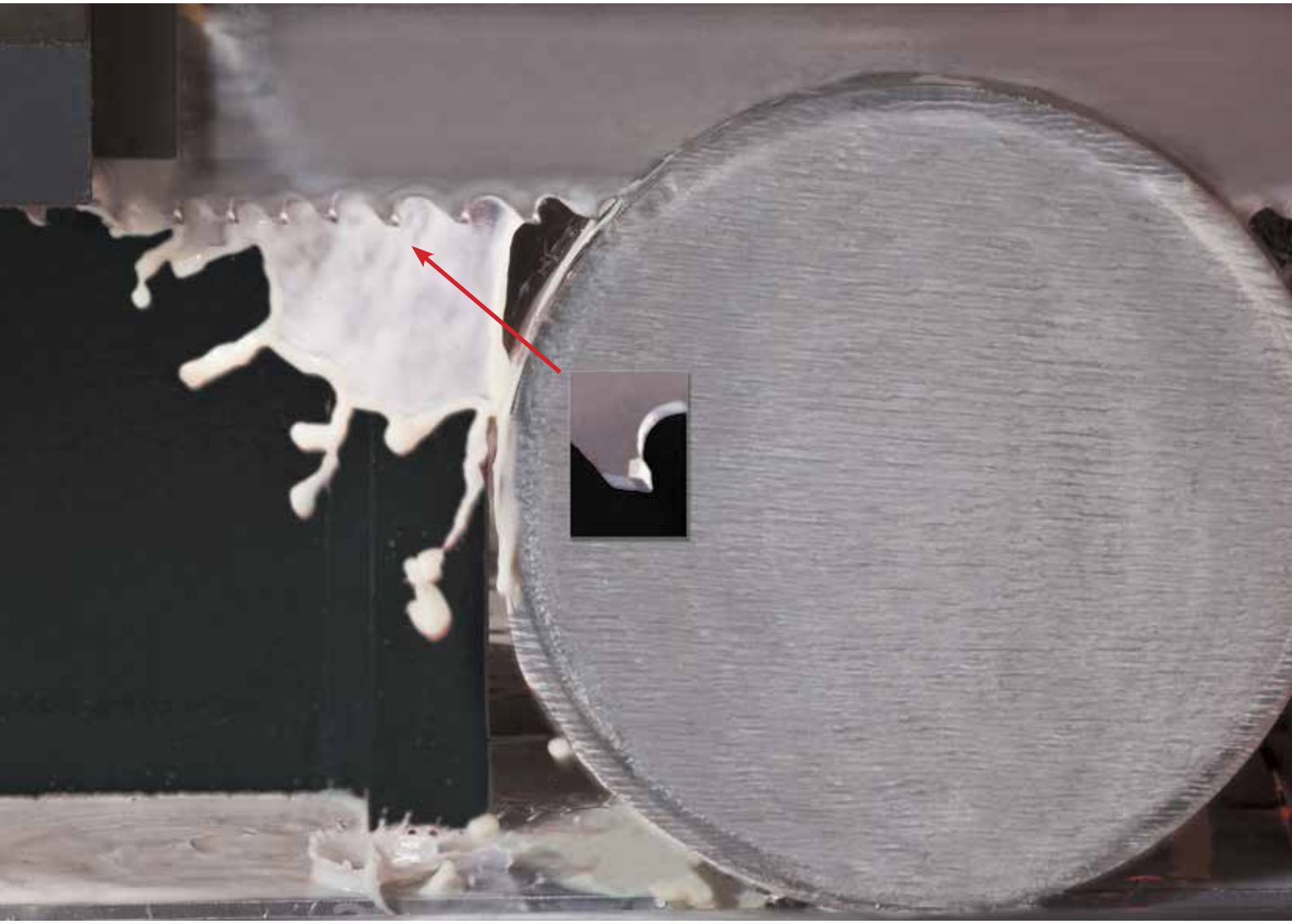
- Ideal for cutting hardened materials
- High resistance to abrasion
- Reduced cutting time-higher productivity
- Precise cuts and excellent finish

APPLICATIONS

- Case hardened steel
- Steel for shafts and linear guides
- Case hardened materials up to 60 HRC
- For machines with hydraulic feed control

Width x Thickness		Pitch
mm	inches	
27 x 0.90	1 x .035	3 - 4
34 x 1.10	1.1/4 x .042	3 - 4
41 x 1.30	1.1/2 x .050	2 - 3
		3 - 4

All blades are Trapezoidal Tooth Set
Furnished in welded bands, random length coils and 45 metre coils.
Note: Special products on request.



CARBIDE

ADVANZ™ FS

FEATURES

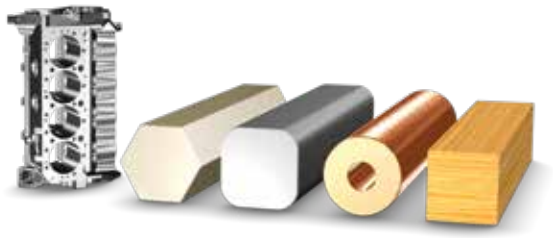
- Carbide tipped teeth
- Triple chip tooth geometry
- Positive Rake angle

BENEFITS

- Ideal for cutting abrasive materials that bi-metal blades cannot cut
- Exceptional resistance to fatigue, abrasion and shocks
- Reduced cutting time - Higher productivity
- Precise cuts and excellent finish

APPLICATIONS

- Abrasive non-ferrous metals
- Cast materials and risers
- Composite materials
- Fibreglass
- Graphite
- Abrasive hard woods
- Suitable for robust vertical machines and horizontal machines with hydraulic feed control

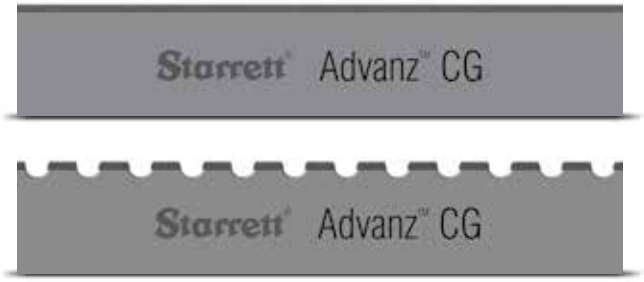


Width x Thickness		Pitch
mm	inches	
19 x 0.90	3/4 x .035	3
27 x 0.90	1 x .035	2 - 3
		3
27 x 1.30	1 x .050	2 - 3
		3
34 x 1.10	1.1/4 x .042	3
34 x 1.30	1.1/4 x .050	3
41 x 1.30	1.1/2 x .050	2 - 3

All blades are Trapezoidal Tooth Set
Furnished in welded bands, random length coils and 45 metre coils.
Note: Special products on request.

CARBIDE

ADVANZ™ CG



FEATURES

- With continuous or gulleted cutting edge
- Excellent blade life with high fatigue resistance

BENEFITS

- Ideal for cutting hard and or abrasive materials
- Excellent finish and cut accuracy
- Superior durability

Width x Thickness		Edge	Grain
mm	inches		
6 x 0.50	1/4 x .020	Gulleted	Medium Grain
		Gulleted	Fine Grain
10 x 0.65	3/8 x .025	Gulleted	Medium/Thick Grain
		Gulleted	Medium Grain
		Continuous	Medium Grain
13 x 0.50	1/2 x .020	Gulleted	Medium/Thick Grain
		Gulleted	Medium Grain
		Continuous	Medium Grain
13 x 0.65	1/2 x .025	Gulleted	Medium/Thick Grain
		Gulleted	Medium Grain
		Continuous	Medium Grain
19 x 0.80	3/4 x .032	Gulleted	Thick Grain
		Gulleted	Medium/Thick Grain
		Gulleted	Medium Grain
		Continuous	Thick Grain
		Continuous	Medium Grain
25 x 0.90	1 x .035	Gulleted	Thick Grain
		Gulleted	Medium/Thick Grain
		Continuous	Medium Grain
25 x 1.10	1 x .042	Gulleted	Medium/Thick Grain
32 x 0.90	1.1/4 x .035	Gulleted	Thick Grain
		Continuous	Thick Grain
32 x 1.10	1.1/4 x .042	Gulleted	Medium/Thick Grain

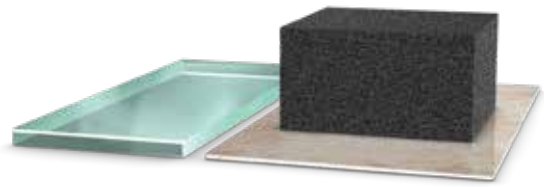
Furnished in welded bands and 75 metre coils.
Note: Special products on request.

APPLICATIONS

- Steel-belted tires
- Composite materials
- Reinforced plastics
- Composite Graphite
- Case-Hardened steels
- Fibreglass

DIAMOND GRIT

ADVANZ™ DG



APPLICATIONS

- Glass
- Glazed ceramic
- Silicon
- Graphite
- Fibreglass
- Stones
- Pyrex
- Ideal for machines with high cutting speed

FEATURES

- Cutting edge coated with diamond grains
- Continuous or Gulleted cutting edge
- High strength body

BENEFITS

- Ideal for cutting abrasive materials that conventional blades cannot cut
- Precise cuts and excellent finish
- Exceptional durability and fatigue resistance

Width x Thickness				
mm	inches	Cutting Edge	Grit	Product
13 x 0.50	1/2 x .020	Continuous	Medium 60/85	ADVDG-CM

Furnished in welded bands and random length coils.
Note: Special products on request. The availability of widths and cutting edges may be subject to change without notice.

HIGH CARBON

HIGH CARBON

DURATEC™ SUPER FB

FEATURES

- Made from special high carbon steel
- Flexible back

BENEFITS

- Contour and straight cutting
- Economical cutting
- Can be welded with 'standard' welders

APPLICATIONS

- Easy-to-machine carbon steel
- Metalon
- Non-ferrous metals
- Celeron and plastics
- Plywood and MDF
- Cardboard
- Ideal for light vertical and horizontal machines
- For workshop and carpentry use

HIGH CARBON

Width x Thickness		Pitch	Tooth Shape
mm	inches		
3 x 0.65	1/8 x .025	14	Regular
		18	Regular
5 x 0.35	3/16 x .014	8	Regular
5 x 0.65	3/16 x .025	4	Skip
		10	Regular
		14	Regular
		18	Regular
		24	Regular (Wavy Set)
6 x 0.35	1/4 x .014	14	Regular
6 x 0.65	1/4 x .025	4	Skip
		4	Hook
		6	Skip
		6	Regular
		6	Hook
		8	Regular
		10	Regular
		14	Regular (Wavy Set)
		18	Regular (Wavy Set)
		24	Regular (Wavy Set)
		32	Regular (Wavy Set)
10 x 0.65	3/8 x .025	3	Regular
		3	Hook
		4	Skip
		4	Hook
		6	Skip
		6	Regular
		6	Hook
		8	Regular
		10	Regular
		14	Regular (Wavy Set)
		18	Regular (Wavy Set)
		24	Regular (Wavy Set)
13 x 0.65	1/2 x .025	3	Hook
		3	Skip
		4	Skip
		4	Hook
		6	Skip

Width x Thickness		Pitch	Tooth Shape
mm	inches		
13 x 0.65	1/2 x .025	6	Regular
		6	Hook
		8	Regular
		10	Regular
		14	Regular (Wavy Set)
		18	Regular (Wavy Set)
		24	Regular (Wavy Set)
16 x 0.80	5/8 x .032	3	Skip
		4	Skip
		6	Skip
		6	Regular
		8	Regular
		10	Regular
		14	Regular (Wavy Set)
19 x 0.80	3/4 x .032	3	Skip
		3	Hook
		4	Skip
		4	Regular
		4	Hook
		6	Regular
		8	Regular
		10	Regular
		14	Regular (Wavy Set)
		18	Regular (Wavy Set)
25 x 0.90	1 x .035	2	Hook
		3	Skip
		3	Hook
		4	Skip
		4	Regular
		6	Regular
		8	Regular
		10	Regular
		14	Regular (Wavy Set)

Raker Tooth Set
Furnished in welded bands, random length coils, 30 metre and 75 metre coils.
Note: Special products on request.

HIGH CARBON

DURATEC™ FC

FEATURES

- Made of high-carbon steel with 1.5% silicon-content alloy
- Highly flexible backing material

BENEFITS

- Ideal for cutting materials that conventional blades cannot cut
- High resistance to wear and abrasion

APPLICATIONS

- Steel-belted radial tires
- Hardened sheets with thickness up to 16mm (5/8")
- For vertical machines at speeds over 2,000m/min.

Width x Thickness		Pitch	Tooth Shape
mm	inches		
25 x 0.90	1 x .035	8	Regular
		10	Regular

Furnished in welded bands and random length coils.
Note: Special products on request.

HIGH CARBON

BAND KNIVES

FEATURES

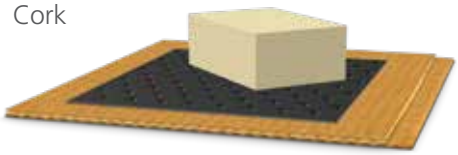
- Available with straight, scallop, wavy or "V" tooth cutting edges and a single or double edge bevel
- Made of high-carbon steel and stainless steel
- Blades extremely sharp

BENEFITS

- Quick, smooth and precise cuts, with excellent finish
- No material waste.

APPLICATIONS

- Foam
- Rubber and soft plastics
- Cardboard and paper
- Cork



Straight Edge, Single Bevel

Wavy Edge, Double Bevel

Straight Edge, Double Bevel

"V" Edge, Double Bevel – 10 TPI

Scallop Edge, Double Bevel

"V" Edge, Double Bevel – 14 TPI

Width x Thickness		Edge & Bevel
mm	inches	
6 x 0.50	1/4 x .020	Straight Edge, Single Bevel
		Straight Edge, Double Bevel
10 x 0.55	3/8 x .022	Straight Edge, Single Bevel
		Straight Edge, Double Bevel
		Wavy Edge, Double Bevel
		Scallop Edge, Double Bevel
13 x 0.55	1/2 x .022	Straight Edge, Single Bevel
		Straight Edge, Double Bevel
		Wavy Edge, Double Bevel
		Scallop Edge, Double Bevel
		"V" Edge, Double Bevel – 10 TPI
		"V" Edge, Double Bevel – 14 TPI
16 x 0.45	5/8 x .018	Straight Edge, Single Bevel
		Straight Edge, Double Bevel
		Wavy Edge, Double Bevel
		Scallop Edge, Double Bevel
		Scallop Edge, Double Bevel*
16 x 0.55	5/8 x .022	Straight Edge, Single Bevel
		Straight Edge, Double Bevel
		Wavy Edge, Double Bevel
		Scallop Edge, Double Bevel
19 x 0.55	3/4 x .022	Straight Edge, Single Bevel
		Straight Edge, Double Bevel

Width x Thickness		Edge & Bevel
mm	inches	
19 x 0.55	3/4 x .022	Wavy Edge, Double Bevel
		Scallop Edge, Double Bevel
		"V" Edge, Double Bevel – 10 TPI
		"V" Edge, Double Bevel – 14 TPI
19 x 0.70	3/4 x .028	Straight Edge, Single Bevel
		Straight Edge, Double Bevel
		Wavy Edge, Double Bevel
		Scallop Edge, Double Bevel
25 x 0.60	1 x .0236	Straight Edge, Single Bevel
		Straight Edge, Double Bevel
		Wavy Edge, Double Bevel
		Scallop Edge, Double Bevel
		"V" Edge, Double Bevel – 14 TPI
25 x 0.90	1 x .035	Straight Edge, Single Bevel
		Straight Edge, Double Bevel
		Wavy Edge, Double Bevel
		Scallop Edge, Double Bevel
38 x 1.10	1.1/2 x .045	Straight Edge, Double Bevel

Furnished in welded bands and 30 metre (100') coils for 6mm - 25mm widths.
Furnished in welded bands and random length coils for 1.1/2" width.
Note: Special products on request.
*Stainless steel blade.

WOOD CUTTING

WOOD CUTTING

WOODPECKER™ PREMIUM

FEATURES

- High carbon steel with a polished finish
- Hardened spring tempered back and ground, precision set teeth with positive tooth angles
- A selection of blades ideal for a variety of woodworking applications
- Includes blades as thin as 0.50mm (.020") for contour cutting fine hardwoods and thicker blades for tough tasks including pallet work
- Thin kerf available
- Longer life and faster cutting with less feed
- High production rates and increased yields
- The teeth can be re-sharpened

Width x Thickness		Pitch
mm	Inches	
6 x 0.50	1/4 x .020	4
		6*
10 x 0.55	3/8 x .022	3
		4
		6*
13 x 0.55	1/2 x .022	3
		4
		6*
16 x 0.55	5/8 x .022	3
		4
19 x 0.70	3/4 x .028	3
27 x 0.60	1 x .023	3
27 x 0.90	1 x .035	1.3
		2
32 x 0.90	1.1/4 x .035	1.1
		1.3
32 x 1.10	1.1/4 x .042	1.1
		1.3
38 x 1.10	1.1/2 x .042	1.1
50 x 1.10	2 x .042	1.1
65 x 1.10	2.9/16 x .042	1.1

Tooth shape: Hook
* = Skip Tooth, Straight (Zero) Rake
All blades are Raker Tooth Set
Furnished in welded bands, random length coils and 30 metre (100') coils.

BI-METAL WOODPECKER™ PRO

FEATURES

- Manufactured from high speed steel M42 containing 8% cobalt
- Specifically designed for all types of hard wood
- Electron beam welded bi-metal construction
- Rockwell tooth hardness C67-69 ensures longer blade life

Width x Thickness		Pitch
mm	Inches	
6 x 0.65	1/4 x .025	6*
10 x 0.65	3/8 x .025	4
13 x 0.65	1/2 x .025	3
19 x 0.90	3/4 x .035	3
27 x 0.90	1 x .035	2
34 x 0.90	1.1/4 x .035	1.1
		1.3
34 x 1.10	1.1/4 x .042	1.1
		1.3
41 x 1.30	1.1/2 x .050	1.1
54 x 1.60	2 x .063	1.1

Tooth shape: Hook
* = Positive Rake, High Profile Teeth
All blades are Raker Tooth Set
Furnished in welded bands, random length coils and 30 metre (100') coils.

FOOD PROCESSING

FOOD PROCESSING

MEATKUTTER™ PREMIUM

SPECIFICATIONS

- Polished high carbon steel
- Hardened, ground teeth
- Hardened back

FEATURES

- Clean and sanitary operation
- Fast, smooth and clean cuts, with less waste
- Accurate cuts with less effort
- Laser-etched blade identification guarantees product quality and satisfaction

MEAT TYPES

- Fresh meat
- Frozen meat
- Poultry
- Fish

APPLICATIONS

- Suitable for butcheries, food industry, slaughterhouses, supermarkets

Width x Thickness		Pitch
mm	Inches	
13 x 0.55	1/2 x .022	3
		4
		6*
16 x 0.46	5/8 x .018	4
		6*
16 x 0.55	5/8 x .022	3
		4
		6*
16 x 0.63	5/8 x .025	3
		4
19 x .0.55	3/4 x .022	3
		4

Hook
* = Skip
Furnished in welded bands and random length coils..

MEATKUTTER™ STAINLESS

SPECIFICATIONS

- Stainless steel AISI 420
- Ground teeth

FEATURES

- Rust-proof
- Fast, smooth and clean cuts, with less waste
- Laser-etched blade identification guarantees product quality and satisfaction

MEAT TYPES

- Bone-in or boneless, thawed or frozen
- Poultry
- Fish

APPLICATIONS

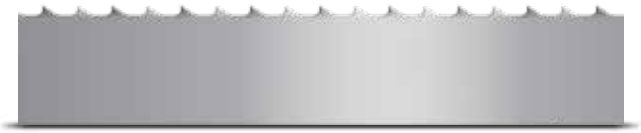
- Suitable for butcheries, food industry, slaughterhouses, supermarkets

Width x Thickness		Pitch
mm	Inches	
16 x 0.46	5/8 x .018	4
		6*

Hook
* = Skip
Furnished in welded bands and random length coils..

FOOD PROCESSING

MEATKUTTER™ FROZEN



SPECIFICATIONS
- Polished high carbon steel
- Hardened, ground teeth

FEATURES
- Minimal meat residue guaranteeing clean and sanitary operation
- Fast, smooth and clean cuts, with less food loss in comparison to conventional blades
- Excellent cutting precision

MEAT TYPES
- Fish & frozen meat up to -4˚F (-20˚ C)

APPLICATIONS
- Meat packing industries

Width x Thickness		Pitch
mm	Inches	
16 x 0.35	5/8 x .014	3
16 x 0.50	5/8 x .020	3
		4
		6
19 x 0.55	3/4 x .022	3
27 x 0.60	1 x .0236	3
35 x 0.80	1-1/4 x .032	2
50 x 0.90	2 x .035	1.3

Tooth shape: Hook. Furnished in welded bands and random length coils.

MEATKUTTER™ FROZEN BI-METAL

SPECIFICATIONS
- Bi-metal high-speed steel band saw blade
- Hardened teeth and back

FEATURES
- Greater durability compared to conventional blades
- Fast, clean, accurate cuts with less waste

MEAT TYPES
- Large frozen fish up to -76˚F (-60° C)

APPLICATIONS
- Suitable for meat packing, portioning and seafood processing

Width x Thickness		Pitch
mm	Inches	
34 x 0.90	1-1/4 x .035	2

Tooth shape: Hook
Furnished in welded bands and random length coils..

CARCASSKUTTER™ PREMIUM

FEATURES
- Fast, smooth and clean cuts with less waste
- Accurate cuts with less effort
- Laser-etched blade identification guarantees product quality and satisfaction

CARCASS TYPES
- Animal carcass cuts - Cattle, Pigs, etc.

APPLICATIONS
- Suitable for frozen meat and slaughter houses
- Cold storage facilities
- Meat packing and processing plants

SPECIFICATIONS
- Polished high carbon steel
- Hardened, ground teeth & hardened back

Width x Thickness		Pitch
mm	Inches	
19 x 0.55	3/4 x .022	3
		4

Hook. Furnished in welded bands, random length coils and 30 metre (100') coils..

POWER HACK SAW BLADES

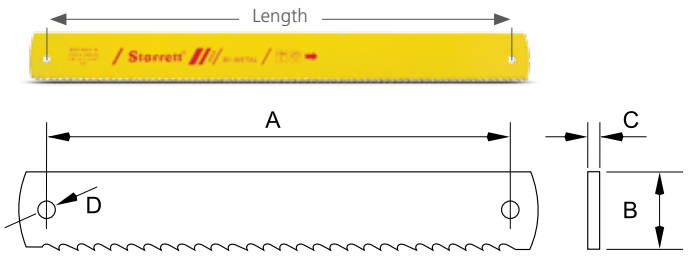
BI-METAL HIGH SPEED STEEL TEETH

The bi-metal construction of these power hacksaw blades provides exceptional cutting action in a wide variety of applications. The hardened and tempered high speed steel teeth and durable alloy steel backing is resistant to shocks, breakages and can handle irregular shaped work pieces and interrupted cuts.

METRIC LINE

Dimensions in mm (A x B x C x D)	Teeth per 25mm	Pack Qty	Cat. No.
300 x 34 x 2.00 x 8.50	6	5	BS300-6
	10	5	BS300-10
350 x 34 x 2.00 x 8.50	6	5	BS350-6
	10	5	BS350-10
400 x 34 x 2.00 x 8.50	4	5	BS400-4
	6	5	BS400-6
	10	5	BS400-10
450 x 41 x 2.00 x 8.50	4	5	BS450-4
	6	5	BS450-6
	10	5	BS450-10

Blades from 300mm to 450mm in length are packaged and sold 5 blades per plastic tube.



INCH LINE

Length x Width x Thickness x Diameter		Teeth per inch	Pack Qty	Cat. No.
inch (A x B x C x D)	mm (A x B x C x D)			
12 x 1.1/8 x .050 x .334	300 x 28 x 1.25 x 8.50	10	5	BS1210-5
		14	5	BS1214-5
14 x 1.1/8 x .050 x .334	350 x 28 x 1.25 x 8.50	10	5	BS1410-5
		14	5	BS1414-5
14 x 1.3/8 x .062 x .334	350 x 34 x 1.60 x 8.50	6	5	BS1406-6
		10	5	BS1410-6
14 x 1.5/8 x .075 x .413	350 x 41 x 2.00 x 10.50	4	5	BS1404-7
		6	5	BS1406-7
16 x 1.3/8 x .062 x .334	400 x 34 x 1.60 x 8.50	6	5	BS1606-6
		10	5	BS1610-6
16 x 1.5/8 x .075 x .413	400 x 41 x 2.00 x 10.50	4	5	BS1604-7
		6	5	BS1606-7
		10	5	BS1610-7
17 x 1.3/8 x .062 x .334	425 x 34 x 1.60 x 8.50	6	5	BS1706-6
		10	5	BS1710-6
18 x 1.3/8 x .062 x .413	450 x 34 x 1.60 x 10.50	4	5	BS1804-6
		6	5	BS1806-6
		10	5	BS1810-6
18 x 1.5/8 x .075 x .413	450 x 41 x 2.00 x 10.50	4	5	BS1804-7
		6	5	BS1806-7
		10	5	BS1810-7
18 x 1.7/8 x .088 x .413	450 x 47 x 2.25 x 10.50	4	5	BS1804-8
		6	5	BS1806-8
21 x 1.5/8 x .075 x .413	525 x 41 x 2.00 x 10.50	6	1	BS2106-7
21 x 1.7/8 x .088 x .413	525 x 47 x 2.25 x 10.50	4	1	BS2104-8
		6	1	BS2106-8
24 x 1.7/8 x .088 x .413	600 x 47 x 2.25 x 10.50	4	1	BS2404-8
		6	1	BS2406-8

Blades from 12" to 18" in length are packaged and sold 5 blades per plastic tube.
Blades from 21" or wider, packaged and sold 1 blade per envelope.

REDSTRIPE® SOLID HIGH SPEED STEEL

The solid, fully hardened molybdenum high speed steel composition of Redstripe power hacksaw blades delivers extended life and efficient cutting action in a broad range of materials. These blades can withstand heavier feed pressures and provide faster cut rates than blades made from composite designs. Redstripe power hacksaw blades will effectively cut tough alloys such as stainless steels.

METRIC LINE

Dimensions in mm (A x B x C x D)	Teeth per 25mm	Pack Qty	Cat. No.
300 x 32 x 2.00 x 8.50	6	5	RS300-6
	10	5	RS300-10
350 x 32 x 2.00 x 8.50	6	5	RS350-6
	10	5	RS350-10
400 x 32 x 2.00 x 8.50	4	5	RS400-4
	6	5	RS400-6
	10	5	RS400-10
450 x 38 x 2.00 x 8.50	4	5	RS450-4
	6	5	RS450-6
	10	5	RS450-10
500 x 45 x 2.00 x 10.50	4	5	RS500-4
	6	5	RS500-6
	10	5	RS500-10
550 x 45 x 2.00 x 10.50	4	1	RS550-4
	6	1	RS550-6
	10	1	RS550-10
575 x 50 x 2.50 x 10.50	4	1	RS575-4
	6	1	RS575-6
600 x 50 x 2.50 x 10.50	4	1	RS600-4
	6	1	RS600-6
650 x 54 x 2.50 x 10.50	4	1	RS650-4
	6	1	RS650-6
700 x 54 x 2.50 x 10.50	4	1	RS700-4
	6	1	RS700-6
850 x 60 x 3.00 x 12.50	4	1	RS850-4
	6	1	RS850-6
	10	1	RS850-10
1000 x 125 x 3.50 x 12.50	2.1/2	1	RS1000-2.1/2

Blades from 300mm (12") to 500mm (20") length packaged and sold 5 blades per plastic tube.
Blades from 525mm (21") or wider, packaged and sold 1 blade per envelope.

INCH LINE

Length x Width x Thickness x Diameter		Teeth per inch	Pack Qty	Cat. No.
inch (A x B x C x D)	mm (A x B x C x D)			
12 x 1 x .050 x .334	300 x 25 x 1.25 x 8.50	10	5	RS1210-5
		14	5	RS1214-5
14 x 1 x .050 x .334	350 x 25 x 1.25 x 8.50	10	5	RS1410-5
		14	5	RS1414-5
14 x 1.1/4 x .062 x .334	350 x 32 x 1.60 x 8.50	6	5	RS1406-6
		10	5	RS1410-6
		14	5	RS1414-6
16 x 1.1/4 x .062 x .334	400 x 32 x 1.60 x 8.50	6	5	RS1606-6
		10	5	RS1610-6
16 x 1.1/2 x .075 x .334	400 x 38 x 2.00 x 8.50	4	5	RS1604-7
		6	5	RS1606-7
17 x 1.1/4 x .062 x .334	425 x 32 x 1.60 x 8.50	6	5	RS1706-6
		10	5	RS1710-6
18 x 1.1/4 x .062 x .413	450 x 32 x 1.60 x 10.50	6	5	RS1806-6
		10	5	RS1810-6
18 x 1.1/2 x .075 x .413	450 x 38 x 2.00 x 10.50	4	5	RS1804-7
		6	5	RS1806-7
		10	5	RS1810-7
18 x 1.3/4 x .088 x .413	450 x 45 x 2.25 x 10.50	4	5	RS1804-8
		6	5	RS1806-8
20 x 1.1/2 x .075 x .413	500 x 38 x 2.00 x 10.50	6	5	RS2006-7
		10	5	RS2010-7
20 x 1.3/4 x .088 x .413	500 x 45 x 2.25 x 10.50	4	5	RS2004-8
21 x 1.1/2 x .075 x .413	525 x 38 x 2.00 x 10.50	10	1	RS2110-7
21 x 1.3/4 x .088 x .413	525 x 45 x 2.25 x 10.50	4	1	RS2104-8
		6	1	RS2106-8
24 x 1.3/4 x .088 x .492	600 x 45 x 2.25 x 12.50	4	1	RS2404-8
		6	1	RS2406-8
24 x 2 x .100 x .492	600 x 50 x 2.50 x 12.50	4	1	RS2404-0
		6	1	RS2406-0
26 x 2 x .100 x .492	650 x 50 x 2.50 x 12.50	4	1	RS2604-0
30 x 2.1/2 x .100 x .492	750 x 63 x 2.50 x 12.50	4	1	RS3004-0

BAND SAW MACHINES

Starrett®

NEW

S1005 PORTABLE BAND SAW

DESIGNED FOR THE PROFESSIONALS

LITHIUM-ION POWERED

LONG LIFE

1 YEAR WARRANTY

FREE Starrett Tool Bag & Starrett Univerz™ Band Saw Blade

FREE Second Battery 20 V / 2.0 Ah

Starrett Univerz™ **50% More Blade Life***

bi-metal unique saw technology

0.35mm Blade Thickness - Designed by Starrett® Specifically for Portable Band Saws

Blade:	**Starrett® Univerz™ Bi-Metal Band Saw Blade**
Blade Size:	**732mm x 13mm x 0.35mm**
Tooth Pitches:	**10-14 TPI • 14-18 TPI • 24 TPI**

Specifications subject to change without notice. Images for illustration purposes only.

** When compared with directly comparable blades in other portable band saw machines.*

NEW

MEAT CUTTING BANDSAW MACHINES

S2610 | S2630

THESE MACHINES ARE CONSTRUCTED ENTIRELY OF STAINLESS STEEL AISI 304

SPECIFICATIONS

Cat. No. (220V / 50 Hz)	S2610-G4	S2630-G4
Cat. No. (400V / 50 Hz)	S2610-Q4	S2630-Q4
Dimension of Machine (mm)	785 x 666 x 1640	930 x 1000 x 1930
Electricity	220 / 380 - 50Hz	220 / 380 - 50Hz
Motor - Watt	1100	2200
Motor - Hp	1.5	3
Blade Dimension (mm)	2428 x 16 x 0.56 x 4T	3330 x 16 x 0.56 x 4T
Cutting Size (W) - (mm)	250	380
Cutting Size (H) - (mm)	300	450
Machine Weight - Kg	165	245
Blade Speed (m/s)	1200	1920
Blade Speed (m/min)	20	32
Body	SUS 304	SUS 304
Wheels	SUS 304	SUS 304
Benefits	Water proof and easy to clean	
	Automatic hydraulic blade tensioning system	
	Gradual startup and emergency stop device for safety	
	Dynamic balance design, low vibration, high speed, low waste, slice platform easy operation	

FEATURES AND BENEFITS

- The entire machine is constructed of stainless steel AISI 304, besides a superficial treatment that provides better cutting
- Band wheels made of cast stainless steel
- Band wheels with double sheet - Better protection for the user in a possible blade break
- Hydraulic blade tensioning system - Always maintain the correct tension
- Tungsten machine guides for higher durability and hygiene, as well as reducing blade vibration
- Hygienic - Easy to clean
- IP65 Protection - It can be washed with high pressure of water in its entirety
- Guide wheels - Guarantee a higher precision, stability, and smoothness during cutting
- Motor brake with frequency inverter - Ensure that the saw stops immediately in the case of an emergency
- It is possible to change the machine speed to adapt to different types and needs of cutting
- High cutting speed - It ensures faster cuts
- Adjustable table to change the cutting thickness.
- Machine doors with safety switch
- Removeable waste collection box - generated by cutting

BENCH TOP MACHINE

S1101-F1 (220V)

S1101-B1 (110V)

Ideal for small to 100 x 150mm cuts in thin tubes and structural sections, the S1101 is a machine designed for maintenance workshops and metalworking. Its measurements and low weight allow for easy and safe transportation. In addition, its versatility ensures a range of cutting angles, a unique feature for a machine this size.

FEATURES

- Manufactured with an injected aluminium bow for maximum strength and durability
- Compact and sturdy base
- Manual vice with quick grip system
- Extremely robust, and yet lightweight at only 23kg
- Single phase motor
- Gravity feed, three feed pressure options
- Removable swarf box
- Easily accessible emergency stop button
- Automatic stop at the end of the cut
- Quick blade tensioning system
- Cut at 0° to 45° angles
- Dry cut, without lubrication
- CE compliant

Optional Extra
S1101 Bench
Sold Separately

	CAPACITIES (mm)	
	d	a b axb
0°	100	100 x 150
45°	60	60 x 100

For thin-wall pipes and structural profiles only.

TECHNICAL SPECIFICATIONS

Voltage	Power (hp/kW)	Blade Speed (m/min. 50 Hz)	Blade Speed (m/min. 60 Hz)	Blade Sizes (mm)	Machine Sizes (m)	Net Weight (kg)
220V or 110V	0.5 / 0.37	45	54	1470 x 13 x 0.5 or 0.65	0.72a x 0.38b x 0.46c	23

GRAVITATIONAL AND MANUAL MACHINE

S3120

The S3120 has been developed with productivity, robustness, and high-speed cutting performance in mind. It is ideally suited for professionals or businesses looking to acquire a versatile, low-maintenance piece of equipment that offers them an excellent cost-benefit ratio.

FEATURES

- **TWO-SPEED SWITCH**
- **60° ANGLE CUTTING**

- Manual, gravity fed machine
- Cast iron bow
- Combined guides with bearings
- Cooling pump
- Dynamometric blade tensioning system
- Two cutting speeds
- Vice with quick holding system
- Cleaning brush
- Control panel (internal voltage 24V)
- CE compliant

Optional Extra

- Infeed and outfeed roller table (sold separately)

	CAPACITIES (mm)		
	d	a x a	b x b
0°	170	170 x 170	95 x 210
45°	120	100 x 100	-
60°	70	60 x 60	-

TECHNICAL SPECIFICATIONS						
Three-Phase Voltage	Power (hp/kW)	Motor Frequency (Hz)	Blade Speed (m/min.)	Blade Sizes (mm)	Machine Sizes (m)	Net Weight (kg)
400V	1.0 / 0.75	50	35 and 70	2110 x 19	1.20a x 0.45b x 1.61c	155

GRAVITATIONAL AND MANUAL MACHINE

S3720NG

With excellent cutting and production capabilities, the S3720NG model is designed for companies where mitre cutting of larger, structural profiles and solid materials is required. They are part of a new generation of machines and rely on their robustness, simplicity, low cost, optimized productivity and safety.

FEATURES

- **DYNAMOMETRIC SAW TENSION INDICATOR**
- **TWO-SPEED SWITCH**

- Gravitational and manual feeding
- Cast iron bow
- Adjustable blade guides with roller bearings and hard-metal plates
- Coolant pump
- Vice with quick clamping system
- Cleaning brush
- Tension gauge for blade
- Worm-geared motor
- Safety device for band saw blade breakage
- CE compliant

Optional Extra

- Infeed and outfeed roller table (sold separately)

TECHNICAL SPECIFICATIONS						
Three-Phase Voltage	Power (hp/kW)	Motor Frequency (Hz)	Blade Speed (m/min.)	Blade Sizes (mm)	Machine Sizes (m)	Net Weight (kg)
400V	1.5 / 0.75	50	45 and 90	2710 x 27	1.40a x 0.68b x 1.96c	250

CAPACITIES (mm)			
	d	a x a	a x b
0°	250	250 x 250	250 x 320
45°	230	145 x 145	145 x 240
60°	110	80 x 80	80 x 130

SEMI-AUTOMATIC MACHINE

S4230

As a semi-automatic machine, this model uses state-of-the-art technology for this type of equipment. The technical characteristics provide users with high production capacity and versatility for the most varied types of cuts and shapes. This model can cut mitred corners on both negative (-45º) and positive sides (60º), which makes it more versatile.

FEATURES

- **DYNAMOMETRIC SAW TENSION INDICATOR**
- **BLADE SPEED CONTROLLED BY A VARIABLE-FREQUENCY DRIVE**

- Hydraulic feed control
- Cast iron bow
- Combined blade guides, hard-metal plates, and roller bearings
- Coolant pump
- Hydraulically clamping vice with cutting capacity on both sides
- Cleaning brush
- Saw tension gauge
- Worm-geared motor
- Safety device for band saw blade breakage
- CE compliant

Optional Extra (sold separately)

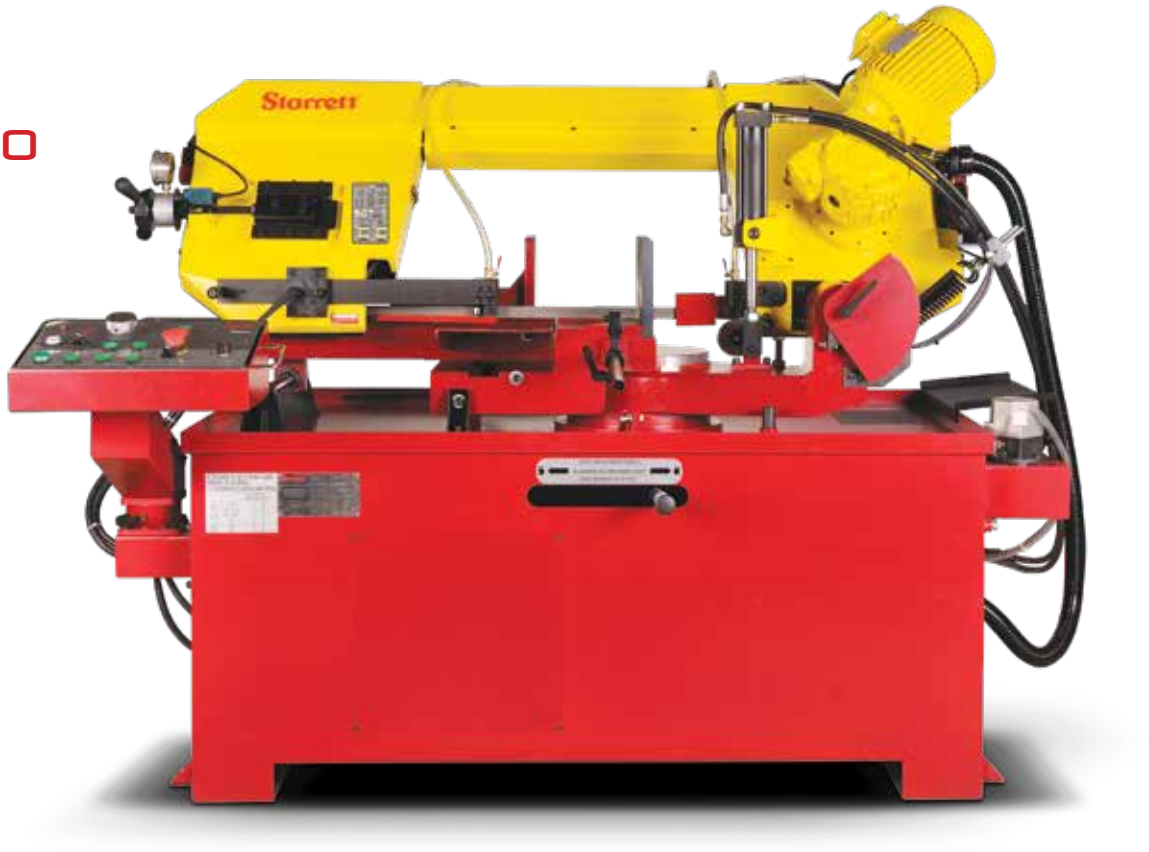
- Infeed and outfeed roller table

TECHNICAL SPECIFICATIONS						
Three-Phase Voltage	Power (hp/kW)	Motor Frequency (Hz)	Blade Speed (m/min.)	Blade Sizes (mm)	Machine Sizes (m)	Net Weight (kg)
400V	2.0 / 1.5	50	20 - 85	3140 x 27	1.86a x 0.73b x 1.56c	475

	CAPACITIES (mm)		
	d	a x a	a x b
0º	300	270 x 270	250 x 350
45º	235	220 x 220	200 x 225
60º	140	115 x 115	115 x 130
-45º	220	150 x 150	115 x 220

SEMI-AUTOMATIC MACHINE

S4240



This semi-automatic machine can perform mitre cutting of structural profiles up to 75° and -45°, outstanding for everyday jobs. Complete with its rigid construction and 300mm x 300mm cutting capacity, the S4240 offers a smooth, controlled cut with hydraulic feed pressure. All these elements combine to create a powerful band saw machine, ideal for regular intensive use on harder metals. Like all our band saw machines, it complies with all the required CE safety standards.

FEATURES

- **ANGLE CUTTING ON BOTH SIDES: 0 to 75° AND 0 to -45°**
- **BLADE SPEED CONTROLLED BY A VARIABLE-FREQUENCY DRIVE**
- **DYNAMOMETRIC SAW TENSION INDICATOR**

- Hydraulic feed control
- Hydraulically tightened vice
- Worm-geared motor
- Hydraulic pump with three-phase motor
- Combined blade guides, hard-metal plates, and roller bearings
- Safety device for band saw blade breakage
- CE compliant

Optional Extra (sold separately)

- Infeed and outfeed roller table

TECHNICAL SPECIFICATIONS

Three-Phase Voltage	Power (hp/kW)	Motor Frequency (Hz)	Blade Speed (m/min.)	Blade Sizes (mm)	Machine Sizes (m)	Net Weight (kg)
400V	3.0 / 2.25	50	20 - 85	3490 x 27	1.50a x 0.80b x 1.60c	600

CAPACITIES (mm)

	d	a x a	a x b
0°	300	300 x 300	220 x 450
45°	300	240 x 240	170 x 240
60°	170	170 x 170	-
75°	80	80 x 80	-
-45°	270	160 x 160	160 x 210

FULL RANGE
HORIZONTAL BAND SAW MACHINES

S3220

S3420NG

S4220

S6330CNC

Band saw machine	Capacities (mm) 0° ●	0° ▬	+ 45° ●	+ 45° ▬	+ 60° ●	+ 60° ▬	+ 75° ●	- 45° ●	- 45° ▬	Vice fixing system	Bow feed	Material feed	Cutting speed (m/min.)	Blade dimensions (mm)
☑ S1101-F1	100	100 x 150	60	60 x 100	-	-	-	-	-	manual	gravity	manual	45	13 x 1470
☑ S1101-B1	100	100 x 150	60	60 x 100	-	-	-	-	-				45	13 x 1470
☑ S3120	170	95 x 210	120	110 x 110	70	60 x 60	-	-	-				35 and 70	19 x 2110
☒ S3220	170	95 x 210	-	-	-	-	-	-	-				35 and 70	19 x 2110
☒ S3420NG	230	150 x 300	180	125 x 170	100	90 x 90	-	-	-				40 and 80	27 x 2535
☑ S3720NG	250	250 x 320	230	145 x 240	110	80 x 130	-	-	-				45 and 90	27 x 2710
☒ S4220	230	230 x 270	180	130 x 180	90	90 x 90	-	160	115 x 200	hydraulic	hydraulic		20 to 85	27 x 2535
☑ S4230	300	250 x 350	235	200 x 225	140	115 x 130	-	220	115 x 220				20 to 85	27 x 3140
☑ S4240	300	220 x 450	300	170 x 240	170	170 x 170	80	270	160 x 210				20 to 85	27 x 3490
☒ S6330CNC	300	300 x 300	-	-	-	-	-	-	-			automatic	20 to 100	34 x 3920

☑ Stock available for immediate delivery.
☒ Machine not held in stock - please call for a delivery quote.

TECHNICAL ASSISTANCE

TECHNICAL SUPPORT

- Troubleshooting, technical information or questions.
- Visit schedule, suggestions, quotes etc

TRAINING

New and modern Starrett Demo Zone

- Equipped with the state-of-the-art equipment for practical and theoretical training in saws and machines.
- Courses and conferences for companies

ON-SITE TECHNICAL SUPPORT

- Free of charge, a team of specialised technicians provides assistance and advice around the UK.
- When visiting a customer plant, our technicians can perform a complete analysis checking saw performance and proper installation and machine adjustments, ensuring better blade performance and minimum cost on cutting operations.

CONTACT TECHNICAL SUPPORT

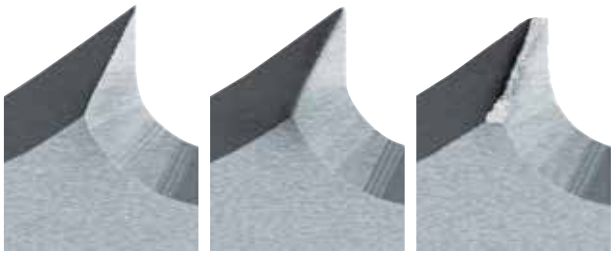
The Starrett Saw Support Team
Tel.: 00 44 (0)1835 866205
Email: sawsupport@starrett.co.uk

RECOMMENDATIONS

USING THE RIGHT BREAK-IN PROCEDURES FOR A NEW BLADE ASSURES LONGER BLADE LIFE

All new saws should be broken-in. This procedure ensures longer blade life, faster cuts and consistent performance.

Attention! Conversely, blade life can be significantly compromised if the proper break-in procedures are not followed.



New blade with razor sharp teeth | Tooth correctly broken in | Tooth incorrectly broken in

HOW TO USE THE RIGHT BREAK-IN AND ENSURE LONGER BLADE LIFE

The teeth of a new band saw blade are razor sharp. To withstand the cutting pressure of band sawing, the tip of each tooth should be honed to create an extremely small radius on its tip.

Easy-to-cut materials (with cutting rate over 38 cm²) e.g. carbon steel

- Adjust the recommended cutting rate for the material to be cut
- Adjust the feed pressure to about one-half the normal cutting rate for the first 30 minutes
- Gradually Increase to the normal cutting rate
- Ensure there is chip removal
- Avoid vibration

Start to cut material at reduced cutting rate

Hard-to-cut materials (with cutting rate below 38 cm²) e.g. nickel-based alloys like inconel, hardened steels, tool steels and stainless steels

- Adjust the recommended cutting rate for the material to be cut
- Adjust the feed pressure to about 30% the normal cutting rate for the first 20-30 minutes
- Gradually Increase to the normal cutting rate
- Ensure there is chip removal
- Avoid vibration

After break-in when the blade has fully entered the work-piece, increase the feed rate over a series of cuts until the recommended cutting rate is achieved

RECOMMENDATIONS

BAND SAW BLADE INSTALLATION GUIDELINES

Always follow the machine manufacturer's instruction and recommendations for blade changes and the safe operation for the band saw machine. The general information contained in the guidelines is intended to assist in the proper installation of band saw blades, however Starrett® nor its employees shall not be held responsible for the accuracy or completeness of these guidelines.
Proper blade installation achieves more efficient blade performance.

- Wear gloves when handling a band saw blade

- Use eye protection, safety shoes, and hearing protection

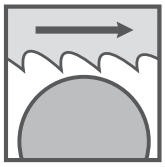


FOLLOW THESE INSTRUCTIONS CAREFULLY

- Follow all the safety instructions shown in the band saw machine operator's manual and on the machine labels. Recognize and read safety and warning signs such as Danger, Warning and Caution
- Follow the saw blade installation instructions on the specific make and model of the band saw machine requiring a blade change

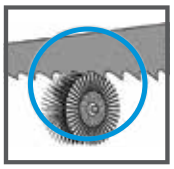
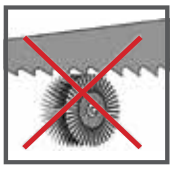
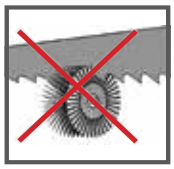
BASIC BLADE CHANGE GUIDELINES

- Remove any chips from saw guides and band wheels
- Position chip brush away from saw
- Relieve saw blade tension and remove blade
- Select appropriate blade for cutting application
- Unfold blade properly. Do not throw. Throwing the blade will result in tooth damage that will reduce saw blade performance
- Install blade with saw teeth pointing in proper direction



- Apply appropriate tension to the blade
- Be aware of pinch points and keep hands and clothing clear of rotating blade

- Adjust guide arms to appropriate positions to workpiece
- Adjust blade guides for proper blade support
- Adjust chip brush to fully engage saw blade teeth to ensure proper chip removal

- Check hydraulic fluid levels when applicable
- Ensure appropriate cutting fluid placement and mix ratios as applicable per machine, cutting fluid, and blade manufacturer's recommendations

CUTTING TABLE / BI-METAL

CUTTING TABLE FOR BI-METAL BAND SAW BLADES				
Work Material Type	Work piece dimension (mm) 50-125mm		50-125mm	
	Speed/Cutting Rate		Blade Speed m/min.	Cutting Rate cm²/min.
	ABNT/AISI/SAE	Hardness		
Carbon Steels	1005-1012	150HB	79 - 91	77 - 103
	1015-1026	150HB	76 - 88	71 - 97
	1030-1055, A36	175HB	55 - 67	52 - 58
	1060-1095	200HB	49 - 61	39 - 52
Easy-to-machine carbon Steels	1110-1117-1118	150HB	79 - 98	77 - 103
	1137-1151	175HB	67 - 79	52 - 77
	1211-1215	150HB	79 - 98	97 - 120
Manganese steels	1330-1345	200HB	55 - 67	39 - 52
	1513-1527	150HB	79 - 91	77 - 103
	1536-1552	175HB	61 - 79	52 - 65
	1561-1572	200HB	49 - 61	39 - 52
Molybdenum steels	4012-4024	175HB	61 - 73	45 - 58
	4030-4042	175HB	58 - 70	45 - 52
	4047-4068	175HB	55 - 67	39 - 52
Chrome Moly Steels	4130-4140	200HB	55 - 67	39 - 52
	4142-4161	200HB	52 - 64	32 - 45
Nickel Chrome Moly Steels	4320	175HB	61 - 73	45 - 58
	4340	200HB	55 - 67	39 - 52
	8115, 8615-8622, 8145, 8625-8637	175HB	61 - 73	45 - 58
	8640-8660, 8740	200HB	55 - 67	39 - 52
	8720, 8822	200HB	61 - 73	45 - 58
	9310	175HB	49 - 58	19 - 26
	9430-9445	200HB	55 - 67	39 - 52
Nickel Moly Steels	4625-4626, 4815-4820	175HB	61 - 73	45 - 58
Chrome Steels	5040-5060	200HB	55 - 67	39 - 52
	5115-5120	175HB	61 - 73	45 - 58
	5130-5160	200HB	55 - 67	39 - 52
	50100, 51100, 52100	225HB	40 - 49	26 - 32
Chrome Vanadium Steel	6118	175HB	61 - 73	45 - 58
	6150	200HB	55 - 67	39 - 52
Silicon steels	9255-9262	200HB	55 - 67	39 - 52
Tool steels - Cold work	A2-A6, A8-A10	200HB	55 - 67	19 - 26
	D2-D7, A7	250HB	20 - 30	13 - 19
	O1, O2, O6, O7	200HB	55 - 67	26 - 39
Tool steels - Hot work	H10-H19, H21-H42, P20	200HB	40 - 49	19 - 26
	L2, L6	200HB	52 - 64	19 - 26
	S1-S7	200HB	40 - 49	19 - 26
Carbon tool steels	W1-W5	200HB	55 - 67	26 - 39
Ferritic stainless steels	405, 409, 430, 434, 436, 442, 446	175HB	24 - 30	19 - 26

CUTTING TABLE / BI-METAL

CUTTING TABLE FOR BI-METAL BAND SAW BLADES				
Work Material Type	Work piece dimension (mm) 50-125mm		50-125mm	
	Speed/Cutting Rate		Blade Speed m/min.	Cutting Rate cm²/min.
	ABNT/AISI/SAE	Hardness		
High speed steels	M1, M2, M7, M10	225HB	34 - 40	19 - 26
	M3, M4, M30-M47	225HB	20 - 30	13 - 19
	T1, T2, T6	250HB	34 - 40	19 - 26
	T15	250HB	18 - 27	13 - 19
	T4, T5	250HB	27 - 37	13 - 19
Austenitic stainless steels	201, 202, 301-305, 308, 321, 347	150HB	30 - 37	19 - 26
	A286, 309, 310, 314, 316, 317, 330	175HB	21 - 24	10 - 13
Easy-to-machine Stainless Steels	330	150HB	30 - 43	26 - 32
	416, 420F, 430F	150HB	43 - 55	32 - 39
Martensitic stainless steels	403, 410, 420, 422, 501, 502	175HB	30 - 40	19 - 26
	440A-C, 414, 431	225HB	27 - 30	19 - 26
Hardened Stainless Steel	15-5PH, 17-4PH, 17-7PH	200HB	21 - 27	13 - 19
Cast iron	Class 20	125HB	49 - 61	71 - 97
	Class 40	200HB	37 - 49	52 - 77
	Malleable 60-40-18	150HB	61 - 76	52 - 65
	Malleable 80-55-06	225HB	37 - 49	32 - 45
Nickel alloys	Hastelloy, Rene 41	250HB	15 - 21	6 - 6
	Inconel 600, 601	250HB	18 - 24	13 - 19
	Inconel 625, 718, Waspaloy	250HB	18 - 24	6 - 6
	Monel 400, 401	250HB	21 - 27	13 - 19
	Monel K500	250HB	18 - 24	6 - 13
Titanium alloys	Alpha, Alpha-Beta, Beta	325HB	14 - 18	6 - 6
	Titanium 99%	150HB	21 - 27	6 - 13
Refractory metals	Columbium	-	18 - 24	6 - 6
	Molybdenum	-	24 - 30	6 - 6
	Tantalum	-	15 - 18	6 - 6
Copper alloys	Tempered Aluminium Bronze	30HRC	24 - 30	10 - 14
	Tempered Beryllium Copper	38HRC	12 - 17	3 - 6
	Aluminium Bronze	70HRB	50 - 58	39 - 52
	Phosphor Bronze	70HRB	46 - 58	52 - 65
	Copper 99%	50HRB	43 - 55	45 - 58
	Copper Belirio	70HRB	52 - 58	26 - 39
	Yellow/Red Brass	70HRB	61 - 79	52 - 65
	Easy machining brass	70HRB	67 - 76	65 - 77
Aluminium Alloys	1200	30HB	120 - 135	77 - 110
	2024	120HB		
	5052	50HB		
	6061	110HB		
	7075	160HB		

CUT-OFF CALCULATION

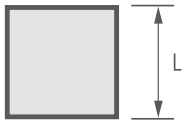
The calculations set out below are intended as guidance for band saw machine operators. There are a number of different opinions that exist as to the correct calculations for different material types, and this guidance does not attempt to disprove other opinions. The guidance is offered as a reference rather than as strict technical instructions.

CUTTING CALCULATION:

Use all the measures in centimetres to get the area in **cm²**.

SQUARE

area = L^2

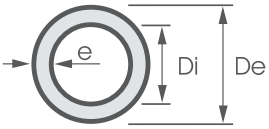


ROUND

area = $D^2 \times 0.7854$

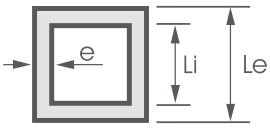
ROUND TUBE

area = $(De^2 - Di^2) \times 0.7854$



SQUARE TUBE

area = $Le^2 - Li^2$



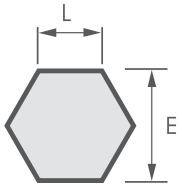
RECTANGLE

area = E x L

HEXAGON

area = $L^2 \times 2.598$

$E^2 \times 0.866$



EXAMPLE OF CUTTING CALCULATION

Material: Austenitic stainless steel (SAE 316)
Format: Round
Dimension: 101.6mm (4")
Speed: 21 to 24 m/min.*
Cutting Rate: 10 to 13cm² min*
*according to the chart on page 55

$CT = \frac{A}{CR}$

CT = Cutting Time
A = Material Area
CR = Cutting Rate

Cutting Time = 81.07cm² ÷ 13cm²/min.
Cutting Time = 6:14 minutes
Band saw machine used: S6330 (page 49)
Blade to be used: Primalloy™ (page 18)
Tooth: Variable Pitch 3-4/P (page 14)
Catalogue No.: 3920 x 34 x3-4 Primalloy

CUTTING OF OTHER DIMENSIONS

Multiply the speed indicated in the tables - pages 54 and 55 by the following factors.

Dimension / mm	Factor
< 13	1.20
13 - 25	1.10
25 - 50	1.07
50 - 125	1
125 - 250	0.92
250 - 600	0.85
> 600	0.75

HARDENED MATERIAL CUTTING

If the material to be cut has hardness above that specified in the tables (pages 54 and 55), multiply the speed and the cutting rate (decreasing speed and increasing cutting time) by the factors below.

Difference between expected and found hardness	Factors	
	Blade Speed	Cutting Rate
Up to 40%	0.75	0.75
From 40% to 75%	0.60	0.54
From 75% to 100% (max. 40HRC)	0.50	0.40

TUBE OR STRUCTURAL MATERIAL CUTTING

Do the same, calculating the material area, choosing the tooth (page 14), speed and cutting rate (pages 54 and 55), however correct the cutting time, by multiplying the time calculated by the correction factor, according to the table below.

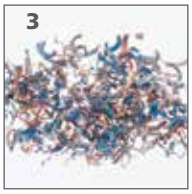
Cutting Time Correction Factor	Thickness (e) mm
2.5	2 to 5
2	6 to 10
1.7	12 to 15
1.4	20 to 25
1.2	30 to 60

Note: when dry cutting, adjust the feed pressure to about 40%-50% of the normal cutting rate (use data on pages 54 and 55).
Note: dry cutting reduces the blade life

For Duratec™ Super FB Carbon Steel Blades: adjust the feed pressure to 50% of the normal cutting pressure and the Cutting Rate to 85%.

CHIP ANALYSIS

1. Thick and heavy chips with normal material colour indicate high cutting feed
2. Thick and blue chips indicate high speed and cutting feed
3. Thin chips with dark coloration indicate low feed and high cutting speed
4. **Flexible chips, spring type, with clear material colour indicate ideal cutting condition.**



ACCESSORIES

POCKET LASER TACHOMETER KIT WITH CASE N° S7793Z

- Powerful tachometer with 32 functions for measurements with or without contact
- Optical range 5 - 200,000 RPM
- Contact range 0.5 - 20,000 RPM
- Measurement with contact 0.050 - 2,000 m/min. (linear speed)
- Different measurement units: RPM, cm, inches, feet, yards etc.

BAND SAW BLADE SERVICE KIT (ITEM NO. AU500)

- For checking and adjusting band saw blades
- Supplied with the key tools needed to maintain a band saw machine at optimum performance:
- Tachometer, Saw tension gauge, stopwatch, square, level, Refractometer, caliper, Band saw blade alignment gauge etc.

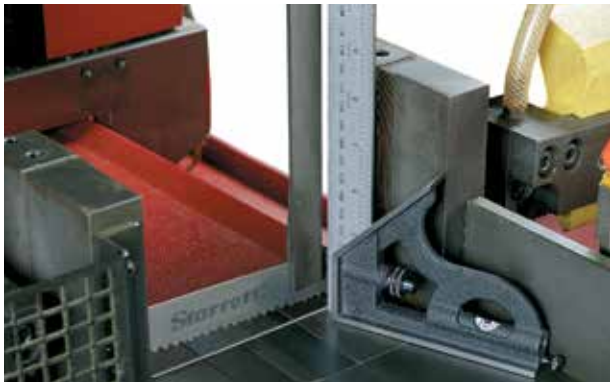
SAW TENSION GAUGE FOR BAND SAW BLADES N° 682EMZ

- Check for proper tension in either English or metric
- Graduated in kg/cm² (0 to 4.000) and in pounds/in² (0 to 60.000)
- Supplied in a case with instructions

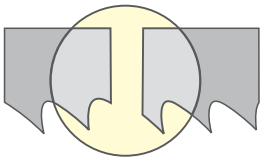
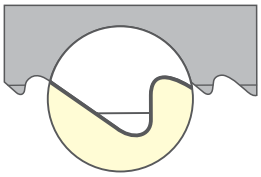
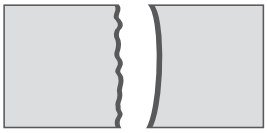
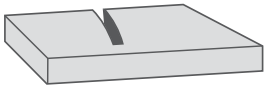
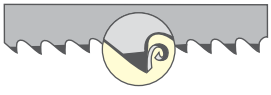
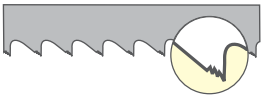
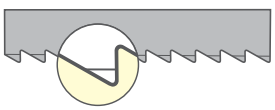
Saw blades	Width (mm)	English System lb/in² (PSI)	Metric System (Kg/cm²)
Primalloy™; Intenss™ PRO-VTH; Intenss™ PRO; Versatix™ MP; Intenss™; Advanz™ MC7, Advanz™ MC5, TS, CS, FS and CG	19, 27 and 34	20.000 - 35.000	1.400 - 2.500
Primalloy™; Intenss™ PRO-VTH; Intenss™ PRO; Versatix™ MP; Intenss™; Advanz™ MC7, MC5, Advanz™ TS, CS and FS	41 or greater	30.000 - 40.000	2.100 - 2.800
Intenss™; Intenss™ PRO-DIE; Univerz™; Duratec™ Super FB; Band Knives High-carbon Steel	Up to 16	20.000 - 25.000	1.400 - 1.800
Duratec™ Super FB; Duratec™ FC; Band Knives High-carbon Steel	19 or greater	20.000 - 30.000	1.400 - 2.100
Machine Saw Blades RS and BS	41 or less	20.000 - 30.000	1.400 - 2.100
Machine Saw Blades RS and BS	45 or greater	25.000 - 35.000	1.800 - 2.500

BAND SAW BLADE ALIGNMENT GAUGE N° PT92925

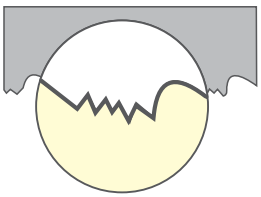
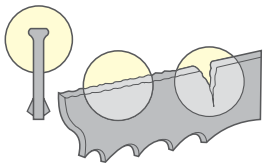
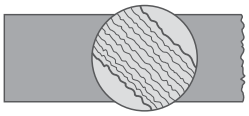
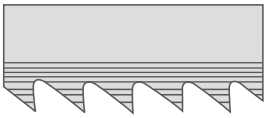
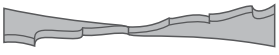
Gauge to ensure that the blade is running square to the cut.



TROUBLESHOOTING

Blade Effect	Probable Cause	Solution
BLADE BREAKAGE  (straight break indicates fatigue)	Incorrect blade.	Check tooth selection.
	Incorrect blade tension.	Adjust the blade tension, refer to operator's manual.
	Excessive feed.	Reduce feed pressure.
	Incorrect cutting fluid.	Check coolant recommendations.
	Pressure blocks too tight.	Adjust the guides.
	Blade rubbing on wheel flange.	Adjust wheel alignment.
	Guide arms too far apart.	Adjust guide arms closer to material.
	Side guides too tight.	Adjust guides.
PREMATURE TOOTH WEAR 	Blade on machine backwards.	Install blade correctly.
	Improper blade break-in procedure.	Refer to recommended procedures.
	Hard Material or heavy surface scale.	Check material hardness and surface conditions.
	Hard Material.	Increase feed pressure.
	Improper cutting fluid or mix ratio.	Follow coolant mixing procedures.
	Speed or feed too high.	Check cutting recommendations.
INACCURATE CUT 	Guide arms too far apart.	Adjust guide arms closer to material.
	Blade worn out.	Replace blade.
	Over or under feeding.	Check cutting recommendations.
	Improper tooth pitch.	Use proper tooth selection.
	Cutting fluid not applied properly.	Adjust coolant nozzles.
	Guides worn or loose.	Tighten or replace guides.
CUTTING DEVIATION 	Over feeding.	Check cutting recommendations.
	Low band tension.	Refer to operator's manual.
	Tooth set damaged.	Check material hardness, replace blade.
	Guide arms loose or space too wide.	Adjust guides and guide arms.
CHIPS RESIDUES IN THE TEETH 	Worn or missing chip brush.	Replace or adjust chip brush.
	Improper or lack of cutting fluid.	Check coolant flow and fluid type.
	Wrong coolant rate.	Check coolant type and ratio.
	Excessive feed or speed.	Reduce speed or feed.
	Incorrect blade pitch.	Use proper tooth selection.
TOOTH - BREAKING AWAY 	Saw guides not properly adjusted.	Align or adjust saw guides.
	Incorrect feed or speed.	Refer to cutting recommendations.
	Incorrect blade.	Use proper blade type and pitch.
	Material moved in vise.	Inspect and adjust vise.
WEAR ON ONLY ONE SIDE OF THE TEETH 	Material with impurities.	Replace material.
	Wheel with worn flange and band rising out of the track.	Align or replace wheel.
	Guide rubbing on set.	Adjust and align guide.
	Chipping teeth and embedding within the material.	Replace blade and apply correct break-in.

TROUBLESHOOTING

Blade Effect	Probable Cause	Solution
BREAKS OF THE TEETH 	Improper blade break-in procedure.	Follow proper break-in procedure.
	Speed too slow.	Refer to cutting recommendations.
	Feed pressure too high.	Reduce feed pressure.
	Tooth jammed in cut.	Low speed and high cutting pressure.
	Poor cutting fluid application or ratio.	Adjust coolant flow and ratio.
	Hard material or heavy scale.	Check material or surface hardness.
	Wrong blade pitch.	Use proper tooth selection.
	Work spinning or loose nested bundles.	Tighten vise or use nesting clamps.
	Cut beginning over the corner of the material.	Start the cut slowly.
WEAR ON THE BACK OF THE BLADE 	Excessive back-up guide preload.	Adjust pressure block.
	Low blade tension.	Refer to operator's manual.
	Blade worn out.	Replace blade.
	Excessive feed rate or pressure.	Reduce feed rate or pressure.
	Damaged or worn pressure block.	Replace pressure block.
	Guide arms spaced too far apart or too tight.	Adjust guides.
	Blade rubbing band wheel flanges.	Adjust wheel alignment.
	Incorrect guide alignment.	Align guides.
WAVY CUT  (cardboard surface, vibration and/or risks)	Dull or damaged blade.	Install new blade.
	Incorrect feed or speed.	Refer to cutting recommendations.
	Blade not supported properly.	Adjust or tighten guide arms.
	Low blade tension.	Refer to operator's manual.
	Incorrect tooth pitch.	Use proper tooth selection.
	Guide arms too far apart.	Adjust guide arms closer to material.
FRAYED LINES - LOSS OF SET 	Saw side guides too tight.	Adjust guides properly.
	Blade riding too high in guide.	Adjust rollers or pressure blocks.
	Blade teeth riding on band wheel surface.	Adjusting tracking or replace wheel.
	Wrong blade width for machine.	Refer to operator's manual.
	Chips being carried back into cut.	Replace or adjust chip brush.
	Worn or damaged guides.	Replace guides.
	Insufficient cooling flow.	Adjust coolant flow.
BLADE TWISTED 	Blade binding in cut.	Adjust feed.
	Guides misaligned.	Adjust and align guides.
	Side guides are too tight.	Adjust guides.
	Work loose in vice.	Adjust vice.
	Feed too heavy.	Reduce feed pressure.
	High blade tension.	Refer to operator's manual.
	Worn wheels.	Machine or replace wheels.
	Guides arms too far apart.	Adjust guide arms closer to material.

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BAND SAW BLADES

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