



Bi-metal Blades

Bi-metal bandsaw blades cover most metalsawing applications, including contour cutting, cutting tubes and profiles, and foundry and production cutting. High-speed steel tooth tips combined with flexible alloy-steel backing material result in the most cost-effective bandsaw blades for many metal sawing applications. Bahco bandsaw blades cut different types of steel (structural, machining, quenched, tempered, high speed, nitriding) as well as brass, copper, nickel, cast iron, titanium and many other materials.

Material	Feet per minute at Ø in					3854-PHG	3854-PQ	3853 Top Fabricator	3857 EASY-CUT	3851-PSG	3851 Cobra	M42
	3/8" - 2"	4" - 12"	16" - 31"	>39"	COOLANT							
1 Structural steel, machining steel	328	279-312	197-246	131-197	6%		++	+++	++		++	++
2 Structural steel, quenched and tempered steel	262	230-262	197-223	131-164	6%		++	+++	++		++	++
3 Case hardened-, spring steel, quenched and tempered steel	246-328	197-262	148-213	98-131	8%		++	+++	++		++	++
4 Unalloyed tool steel, ball and roller bearing steel	197-213	180-197	115-148	82-115	8%		+++	+	+	++	++	++
5 High speed steel	148-164	131-148	98-115	66-82	8%	+++	+++	+	+	++	++	++
6 Cold work tool steel	98-115	82-98	66-82	49-66	DRY	+++	+++	+	+	++	++	++
7 Tool steel, alloyed	148-213	148-197	131-197	66-131	8%	+++	+++	+	+	++	++	++
8 Nitriding steel, high alloyed hot working steel	131-148	115-131	82-98	66-82	8%	+++	+++	+	+	++	++	++
9 Cast iron	164-197	148-164	98-131	82-98	DRY	+++	+++	+	+	++	++	++
10 Rust and acid-resistant steel (light)	131-148	131-148	115-131	98-131	10%	++	+++	+	+	++	++	++
11 Rust and acid-resistant steel (heavy)	115-131	98-115	66-98	62-72	10%	++	+++	+	+	++	++	++
12 Duplex and heat resistant steel	82-98	66-82	49-66	46-52	10%	++	+++	+	+	++	++	++
13 Nickel and nickel-cobalt alloys	49-66	43-49	33-39	33	10%	++	+++	+	+	++	++	++
14 Titanium, titanium alloys; aluminium bronze	98-115	82-98	66-82	52-59	10%	++	+++	+	+	++	++	++
15 Horizontal machines, aluminium, aluminium alloys	394	394	394	394	10%		++	+	+	+	+++	+++
16 Vertical machines, aluminium, aluminium alloys	9843	6890-8203	4101-6562	1641-3937	10%		++	+	+	+	+++	+++
17 Brass	394	394	295-394	262-328	4%	++	++	+	+	+++	++	++
18 Copper	394	361	262-328	197-262	15%	++	++	+	+	+++	++	++
19 Special Application	-	-	-	-	-			+++	+++			

Good + Better ++ Best +++

The above recommendations fit most, but not every circumstance. Contact customer service for more information.



Carbide Blades

Bahco produces a comprehensive range of set and unset carbide bandsaw blades engineered to meet the most demanding production cutting challenges. Bahco blades are designed and produced for high efficiency cutting of difficult and abrasive materials as well as high performance cutting of large and difficult to cut work pieces. High performance backing steel and optimized carbide grades provide premium bandsawing performance. The result? Bahco carbide-tipped blades cut faster and last longer than any other bandsaw blade in a wide variety of sawing applications.

Material	Feet per minute at Ø in					COOLANT	3860-TMC	3881-THQ	3881-THS	3868-TSS	3868-TSX	3869-TS	3860-TCZ
	3/8" - 2"	4" - 12"	16" - 31"	>39"									
1 Structural steel, machining steel	656	525-623	361-492	197-295	12%		++	++	+++	+++			
2 Structural steel, quenched and tempered steel	459	394-459	279-377	164-230	12%		++	++	+++	+++			
3 Case hardened-, spring steel, quenched and tempered steel	394-427	361-394	246-361	131-197	10%		++	++	+++	+++			
4 Unalloyed tool steel, ball and roller bearing steel	328-394	295-328	197-295	131-164	10%		++	++	+++	+++			
5 High speed steel	328-361	262-295	197-246	164-197	10%		++	++	+++	+++			
6 Cold work tool steel	262-328	197-295	197-246	148-213	DRY		++	++	+++	+++			
7 Tool steel, alloyed	279-312	262-295	197-230	164-197	8%		++	++	+++	+++			
8 Nitriding steel, high alloyed hot working steel	246-279	230-262	197-230	148-197	8%		++	++	+++	+++			
9 Cast iron	295-345	295-312	197-246	131-180	12%		++	++	+++	+++			
10 Rust and acid-resistant steel (light)	262-361	262-328	230-312	213-262	12%		++	+++	+++	+++			
11 Rust and acid-resistant steel (heavy)	262-295	230-262	197-230	131-164	13%		++	+++	+++	+++			
12 Duplex and heat resistant steel	328-377	262-328	213-262	164-197	12%		++	+++	+++	+++			
13 Nickel and nickel-cobalt alloys	98-131	82-98	66-92	49-66	12%	+++	++				+		
14 Titanium, titanium alloys; aluminium bronze	164-197	131-164	115-148	52-59	12%	+++	++				+		
15 Horizontal machines, aluminium, aluminium alloys	820	820	820	820	10%	++	++	++		+	+		
16 Vertical machines, aluminium, aluminium alloys	16405	13124-16405	9843-13124	6562-9843	10%	++	++	++		+	+	+++	
17 Brass	820	820	591-787	459-525	4%	+++	++	++		+	+		
18 Copper	787	722	427-623	328-33	15%	+++	++	++		+	+		
19 Special Application	-	-	-	-	-								+++

Good + Better ++ Best +++

The above recommendations fit most, but not every circumstance. Contact customer service for more information.