



A registered trademark of SNA Europe Group

# **BANDSAW & METAL CUTTING TOOLS**

Precision tools you can rely on



## Precision tools you can rely on:

Quality is our number one priority and we also believe that a key factor in both production cutting and general purpose cutting is product consistency. 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 focusing on customers' needs and satisfaction.



# Be Sharp, Use Bahco Bandsaws



## **Welcome to the Bahco Metal Cutting Catalogue:**

In this catalogue we will support you selecting the right bandsaw blade for high production or occasional operational use. Furthermore, this catalogue gives you an overview of our full range of metal cutting tools: holesaws, hacksaws and reciprocating saws, as well as our range of files and rotary burrs.

# We are manufacturers

## FACILITIES



Lidköping / Sweden

Bramley / UK

Minsk / Belarus



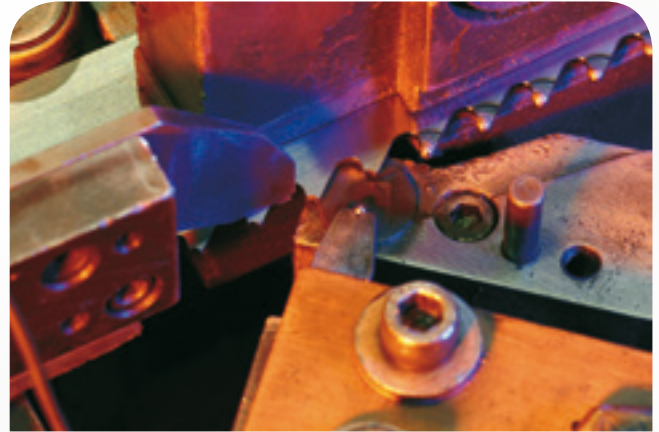


## ■ KEY PRODUCTION PROCESSES



### Tooth Forming

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



### Heat Treatment

The latest technology heat treatment processes ensure:

- High consistency
- Easier welding alignment
- Reduced handling

All finished products are delivered to our highly automated distribution centres.



### Setting

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

- Measures the set against the permissible tolerance, triggering an automatic shut-off in case of deviation
- Ensures a highly consistent set
- Provides a record card for every coil
- Creates a permanent record in our quality data base

# Serving your Business

## ■ QUALITY PRODUCTS

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

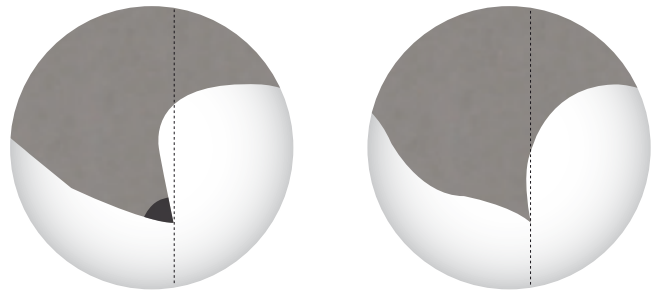
## ■ WELD CENTRES:



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

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

## ■ R&D



### Carbide Blades

### Top Fabricator

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



## ■ TRAINING CENTERS:

To expand and maintain our extensive knowledge and experience on band sawing we have our own Bandsaw Academy with training centers across Europe. In our training centre in the UK, Sweden, Italy, Poland, Belarus and Turkey, colleagues, customers and end users are schooled on the product specification, sawing techniques, problem solving and how to achieve the lowest cost per cut.

## ■ BANDSAW SPECIALIST:

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

## ■ BANDCALC on CD and iPad

**BANDCALC™ ALLOWS BAHCO BANDSAW USERS TO IDENTIFY THE BEST BAHCO BANDSAW BLADE AND MACHINE PARAMETERS TO OPTIMIZE THEIR BANDSAW CUTTING OPERATION IN JUST 3 STEPS:**

- 1 SELECT THE BANDSAW MACHINE**  
Machine condition, band width, thickness and length
- 2 SELECT MATERIAL TO CUT**
- 3 SELECT WORK PIECE DIMENSIONS**  
Type, dimensions, surface and type of bundle



**THE APPLICATION WILL GIVE YOU THE RECOMMENDED BAHCO BLADE AND PARAMETERS**

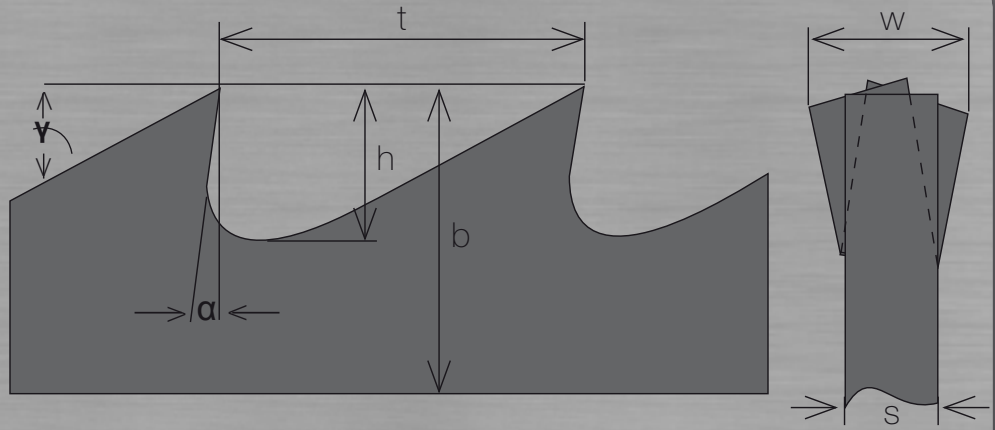
**BANDCALC™ ALSO ALLOWS BAHCO BANDSAW USERS TO:**

- Identify the time per cut
- Calculate the cost of each cut in their machine
- Compare different results between different Bahco blades



## ■ TERMINOLOGY

- b:** width of blade
- s:** thickness of blade
- h:** gullet depth
- t:** tooth pitch
- $\alpha$ :** rake angle
- $\gamma$ :** clearance angle
- w:** width of set



### 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:

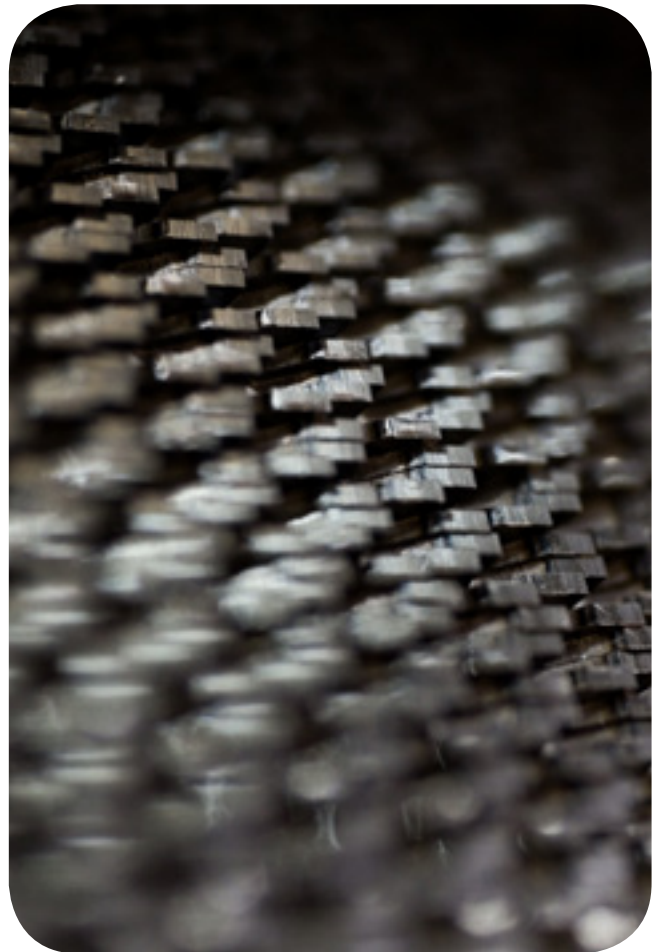
#### Raker Set

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.





# How to select your blade?



1. Analyze application



2. Determine the product



3. Determine TPI



4. Order the blade



5. Install the blade



6. Run the blade



## 1. Analyze Application

### MACHINE

What machine are you using? Brand name, Brand type and machine type. The right blade dimensions depend on the used machine.

### OTHER NEEDS

Besides the machine specifications it is very important to check the condition in which the machine is. Check at least the condition of the wheels, guides, chip brush and cooland.

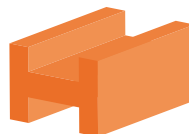
### MATERIAL



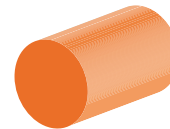
Square bar



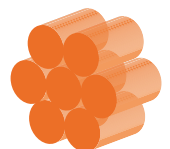
Flat bar



Beams



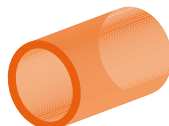
Round bar



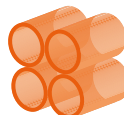
Bundle of round bars



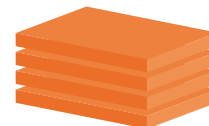
Special profiles



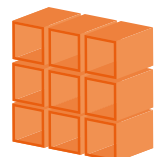
Tube



Bundle of tubes



Multi layer profiles



Bundle multi-layer



## 2. Determine the Product

### Carbide Blades

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

High performance backing steel and optimized carbide grades give premium bandsawing performance. These products will cut faster and last longer than any other bandsaw blade in a wide variety of sawing applications. The 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.

Material	Meters per minute at Ø mm					COOLANT	3860-TMC	3881-THQ	3881-THS	3868-TSS	3868-TSX	3869-TS	3860-TCZ	3860-TCT	3860-TCA
	10-65	100-300	400-800	>1000											
1 Structural steel, machining steel	200	160-190	110-150	60-90	12%	+++	++	++	+	+			++		
2 Structural steel, quenched and tempered steel	140	120-140	85-115	50-70	12%	+++	++	++	+	+			++		
3 Case hardened-, spring steel, quenched and tempered steel	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 steel, alloyed	85-95	80-90	60-70	50-60	8%	+++	++	++	+	+			++		
8 Nitriding steel, high alloyed hot working steel	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 steel (light)	80-110	80-100	70-95	65-80	12%	+++	++	+++	+++	+			++		
11 Rust and acid-resistant steel (heavy)	80-90	70-80	60-70	40-50	13%	+++	++	+++	+++	+			++		
12 Duplex and heat resistant steel	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%	+++	++	+++	+	+			+++		
19 Special Application	-	-	-	-	-							+++			

The bigger the size, the lower the speed

Good +

Better ++

Best +++



## Bi-metal Blades

High-speed steel tooth tips, combined with flexible alloy-steel backing material results in the most cost effective bandsaw blades for most metal sawing applications.

Bi-metal bandsaw blades cover most market requirements, including multi-purpose blades and contour cutting, cutting tubes and profiles, foundry cutting and production cutting.

The Sandflex® 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	Meters per minute at Ø mm					COOLANT	3858 PHG P9000	3854-PHG	3854-PQ	3853 Top Fabricator	3857 EASY-CUT	3851-PSG	3851 Cobra
	10-65	100-300	400-800	>1000									
1 Structural steel, machining steel	100	85-95	60-75	40-60	6%		+++	++	++	+	+	+++	++
2 Structural steel, quenched and tempered steel	80	70-80	60-68	40-50	6%		+++	++	++	+	+	+++	++
3 Case hardened-, spring steel, quenched and tempered steel	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 steel, alloyed	45-65	45-60	40-60	20-40	8%		+++	+++	+++	+	+	++	++
8 Nitriding steel, high alloyed hot working steel	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 steel (light)	40-45	40-45	35-40	30-40	10%		+++	+++	+++	+	+	++	++
11 Rust and acid-resistant steel (heavy)	35-40	30-35	20-30	19-22	10%		+++	+++	+++	+	+	++	++
12 Duplex and heat resistant steel	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%		+	++	++	+	+	+++	++
19 Special Application	-	-	-	-	-					+++	+++		

The bigger the size, the lower the speed

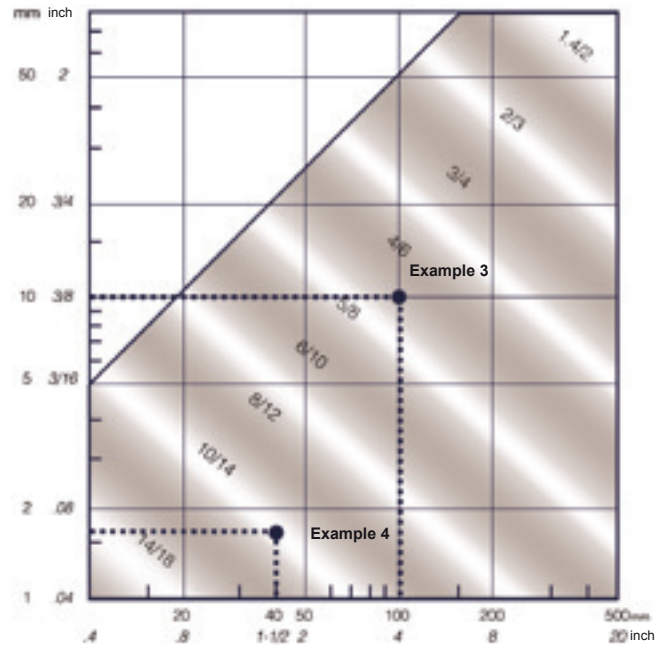
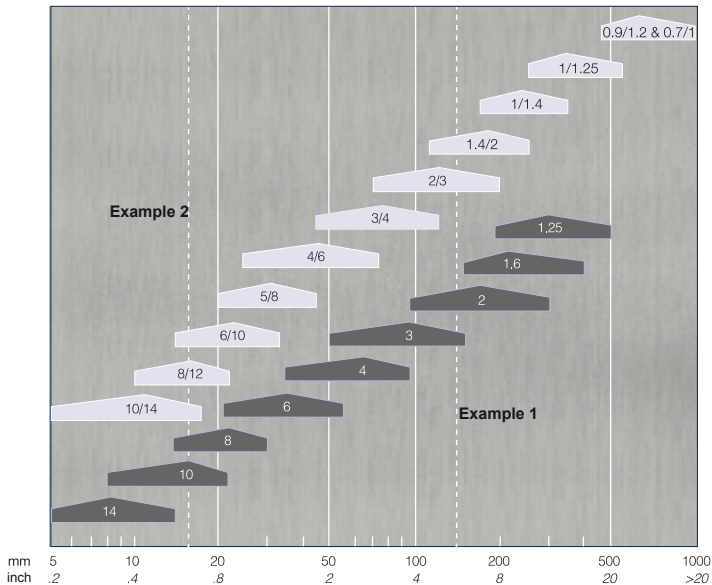
Good +

Better ++

Best +++



# 3. Determine TPI



## Tooth pitch for solid workpieces

The diagram will help you to select the right pitch for cutting solids. The ideal choice is at the widest point of each field.

### Example 1:

When cutting a  $\varnothing$  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 correct 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

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

### 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				
3887-13-0-6-EZ-S	13 x 0.6																	
3887-13-0-6-EZ-M	13 x 0.6																	
3887-13-0-6-EZ-L	13 x 0.6																	
3887-20-0-9-EZ-S	20 x 0.9																	
3887-20-0-9-EZ-M	20 x 0.9																	
3887-20-0-9-EZ-L	20 x 0.9																	
3887-27-0-9-EZ-S	27 x 0.9																	
3887-27-0-9-EZ-M	27 x 0.9																	
3887-27-0-9-EZ-L	27 x 0.9																	
3887-34-1.1-EZ-S	34 x 1.1																	
3887-34-1.1-EZ-M	34 x 1.1																	
3887-34-1.1-EZ-L	34 x 1.1																	

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



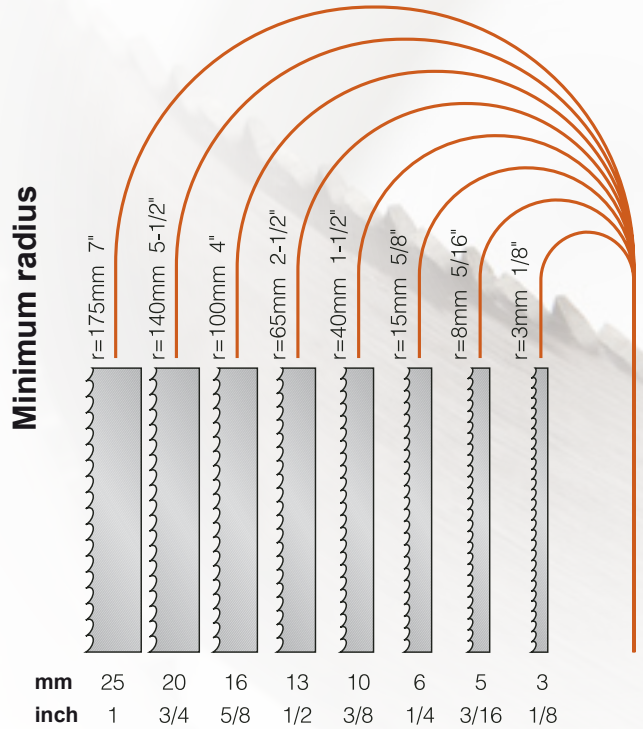
## Table of Radius

### Band Width:

The band width is measured from the tip of the teeth to the back edge of the blade.

On horizontal machines, the band width is dependent upon the bandsaw machine being used. There is, however, some variation possible on vertical machines.

For contour sawing, the blade should be as wide as the machine permits, but still narrow enough so that it can cut the desired shape. Please see diagram below.



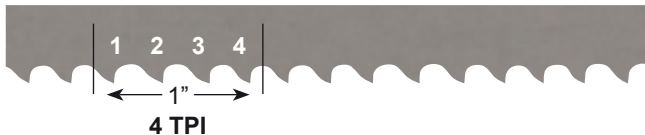
## Teeth Per Inch (TPI)

The number of teeth per inch (TPI) defines the pitch of the blade and can vary from less than 1 to 24.

**Thin-walled work pieces like tubes, pipes and sheet** 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 lower 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.

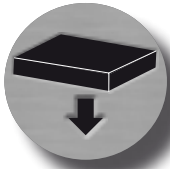
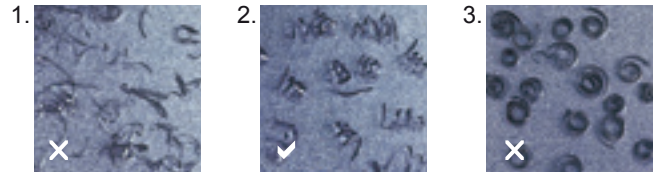


## Feed Rate/Chips

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. 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



## 4. Order the Blade

**Contact your Bahco bandsaw supplier with product code + the loop length recommended for your machine**





## 5. Mount the blade

### Machine

Check frequently:

- The operation of the chip brush
- The wear and alignment of the guides
- The band tension with a tensionmeter (see page 35)
- The band speed with a tachometer (see page 35)
- The coolant concentration with a refractometer (see page 35)

### Coolant / Cutting fluid

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

- Use appropriate 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

### Tooth protector

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



## 6. Run the blade

**For Bi-metal blades:** 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.

**For Carbide blades** another running in procedure is needed. Contact our bandsaw specialist for assistance with this procedure.







# CARBIDE BLADES

## 3860 TMC (MULTI CHIP CARBIDE TIPPED)

Performs extremely well cutting Inconel™ and Titanium solids and blocks, stainless steels and aluminum.

Special tooth geometry designed for Titanium applications. Unset teeth provide a superior surface finish, long life and eliminate secondary operations. Special grade of carbide tooth material provides maximum life and cutting performance. Tooth tips are fine ground to give a sharp edge essential for cutting Titanium. High heat resistance allows high speed cutting even in large solids.

	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



### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors

	GOOD
	BETTER
	BEST

### Shapes



## 3881 CARBIDE THQ (Triple High Quad)

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

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

	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



### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors

	GOOD
	BETTER
	BEST

### Shapes



## 3881 CARBIDE THS (TRIPLE HIGH QUAD - HONED)

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

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

- Patented edge preparation
- Eliminates breaking in
- Reduce tooth strippage on breaghtrough
- Same design as THQ, but wirh an extremely low noise level
- Not suitable for 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



### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors

	GOOD
	BETTER
	BEST

### Shapes





## 3868 CARBIDE TSS (TRIPLE SET STAINLESS - HONED)

Patented edge preparation reduces vibration and provides an extremely low noise level. Designed specifically for production cutting of stainless steel. The teeth of are tipped with a special grade of carbide to cut the most difficult materials. Provides clearance for good chip removal. Perfect for cutting, high nickel alloys, stainless steel, abrasive tool steel, abrasive aerospace alloys.

	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



### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors


	GOOD
	BETTER
	BEST

### Shapes



## 3868 CARBIDE TRIPLE SET® “XTRA”™ TSX

For high efficiency cutting of difficult and abrasive materials. Triple set tooth design and good kerf clearance help eliminate tooth loss. Proven to increase productivity dramatically. Greatly improved blade life. Exact same blade as TSS without being honed, perfect for applications where a sharp blade is needed. Perfect for cutting, Titanium Alloys, Aluminum with high silicon or matrix alloys.

	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	54	1.3	3/4	TSX
3868-54-1.3-TSX-1.4/2			1.4/2	TSX
3868-54-1.6-TSX-1/1.25			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	54	1.6	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



### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors

	GOOD
	BETTER
	BEST

### Shapes



## 3860 TCZ

For high efficiency cutting of difficult and abrasive materials. The Multi-Chip Unset Carbide Tipped bandsaw. Special tooth geometry designed for hard chrome bars. Unset teeth provide a superior finish, long life and eliminate secondary operations.

	Width	Thickness	TPI	Shape
3860-34-1.1-TCZ-2/3	34	1.1	2/3	TCZ
3860-34-1.1-TCZ-3/4	34	1.1	3/4	TCZ
3860-41-1.3-TCZ-2/3	41	1.3	2/3	TCZ
3860-41-1.3-TCZ-3/4	41	1.3	3/4	TCZ



### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors

- GOOD
- BETTER
- BEST

### Shapes





## 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 incorporating 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



### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors


	GOOD
	BETTER
	BEST

### Shapes



## 3860 TCA

The multi-chip unset carbide tipped bandsaw, for high efficiency cutting of difficult and abrasive materials. Special tooth geometry designed for aluminium.

	Width	Thickness	TPI	Shape
3860-27-0.9-TCA-2	27	0.9	2	TCA
3860-27-0.9-TCA-3	27	0.9	3	TCA
3860-34-1.1-TCA-2	34	1.1	2	TCA
3860-34-1.1-TCA-2/3	34	1.1	2/3	TCA
3860-34-1.1-TCA-3	34	1.1	3	TCA
3860-41-1.3-TCA-1.4/2	41	1.3	1.4/2	TCA
3860-41-1.3-TCA-2/3	41	1.3	2/3	TCA
3860-54-1.6-TCA-1/1.25	54	1.6	1/1.25	TCA
3860-54-1.6-TCA-1.4/2	54	1.6	1.4/2	TCA



### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors


	GOOD
	BETTER
	BEST

### Shapes



## 3860 TCT

For high efficiency cutting of difficult and abrasive materials.  
The Multi-Chip Unset Carbide Tipped bandsaw blade.  
Unset teeth provide a superior finish, long life and eliminate additional finishing operations.

	Width	Thickness	TPI	Shape
3860-27-0.9-TCT-3	27	0.9	3	TCT
3860-27-0.9-TCT-3/4	27	0.9	3/4	TCT
3860-34-1.1-TCT-2/3	34	1.1	2/3	TCT
3860-34-1.1-TCT-3/4	34	1.1	3/4	TCT
3860-41-1.3-TCT-1.4/2	41	1.3	1.4/2	TCT
3860-41-1.3-TCT-1.9/2.1	41	1.3	1.9/2.1	TCT
3860-41-1.3-TCT-2/3	41	1.3	2/3	TCT
3860-41-1.3-TCT-3/4	41	1.3	2/3	TCT
3860-54-1.6-TCT-1.4/2	54	1.6	1.4/2	TCT
3860-54-1.6-TCT-2/3	54	1.6	2/3	TCT
3860-54-1.6-TCT-3/4	54	1.6	3/4	TCT



### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors

	GOOD
	BETTER
	BEST

### Shapes










# BI-METAL BLADES

## 3858 SANDFLEX® PHG P9000

For production cutting on various types of materials, especially alloyed and stainless steels.

Specifically designed to cut all difficult materials, in medium and large work pieces with a high performance. The use of powder hss will improve the hardness of the blade, as well the toughness of the 3858-sandflex PHG P9000. This truly leads to an excellent performance of the tooth edges. The 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.

	Width	Thickness	TPI	Shape
3858-41-1.3-PHG-1.4/2	41	1.3	1.4/2	PHG
3858-41-1.3-PHG-2/3			2/3	PHG
3858-41-1.3-PHG-3/4			3/4	PHG
3858-54-1.6-PHG-.7/1	54	1.6	.7/1	PHG
3858-54-1.6-PHG-1.4/2			1.4/2	PHG
3858-54-1.6-PHG-2/3			2/3	PHG



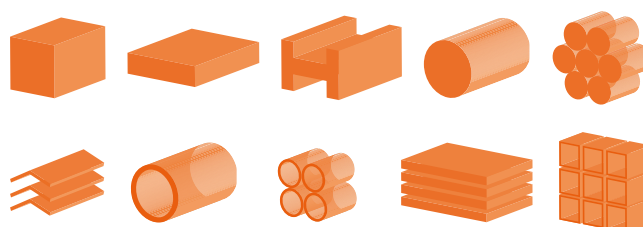
### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors

-  GOOD
-  BETTER
-  BEST

### Shapes




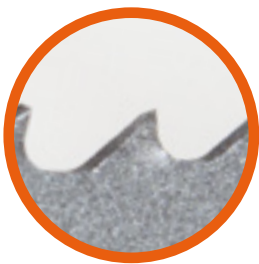
## 3854 SANDFLEX® KING COBRA™ PHG™

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.

	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



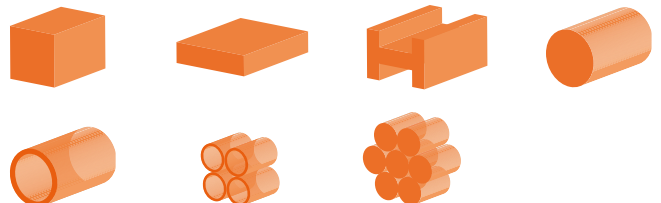
### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors

	GOOD
	BETTER
	BEST

### Shapes





## 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



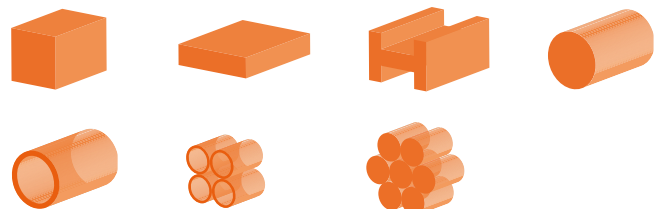
### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors


	GOOD
	BETTER
	BEST

### Shapes



## 3853 SANDFLEX® TOP FABRICATOR

For cutting of structural steels, tubes and profiles in bundles or single pieces.  
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



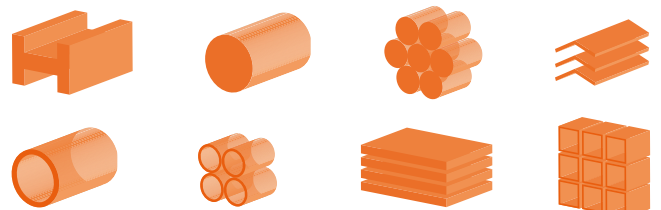
### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors


	GOOD
	BETTER
	BEST

### Shapes



## 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	Size
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



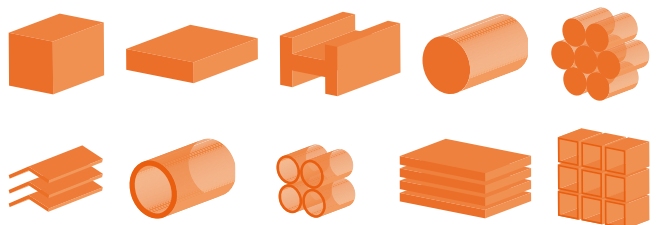
### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors

- GOOD
- BETTER
- BEST

### Shapes





## 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



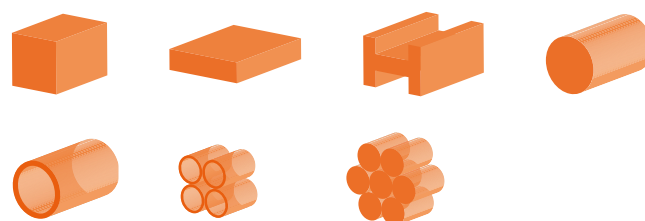
### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors


	GOOD
	BETTER
	BEST


### Shapes



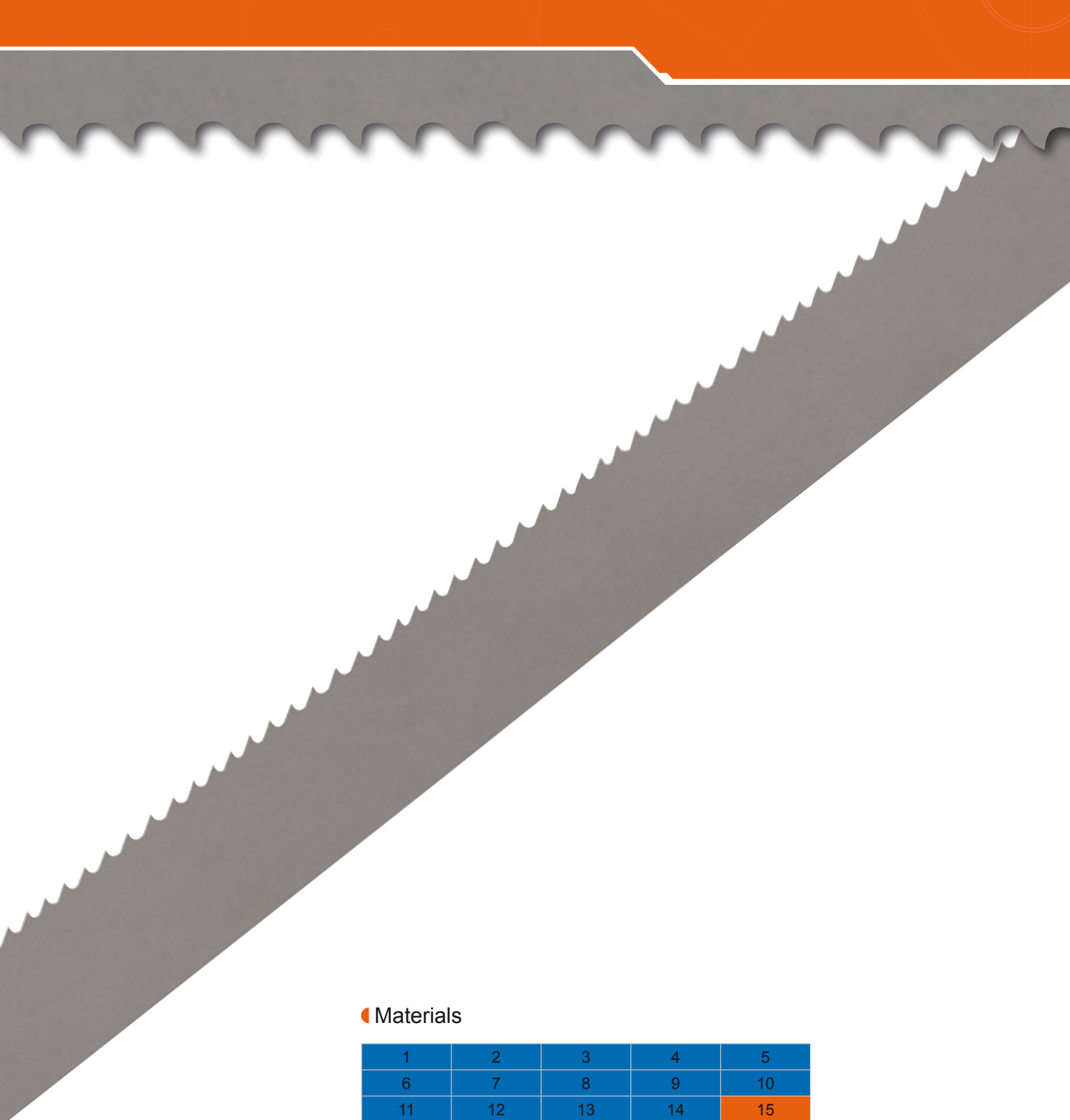
## 3851 COBRA™

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
3851-6-0.6-H-6	6	0.6	6	Hook
3851-6-0.6-10/14			10/14	PRX
3851-6-0.9-H-6	6	0.9	6	Hook
3851-6-0.9-10/14			10/14	PRX
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	0.9	10/14	PRX
3851-10-0.9-H-4			4	Hook
3851-10-0.9-H-6	10	0.9	6	Hook
3851-10-0.9-10/14			10/14	PRX
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	PRX
3851-13-0.6-6/10			6/10	PRX
3851-13-0.6-8/12			8/12	PRX
3851-13-0.6-10/14	13	0.9	10/14	PRX
3851-13-0.9-H-3			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	PRX
3851-13-0.9-10/14			10/14	PRX
3851-20-0.9-4/6	20	0.9	4/6	PRX
3851-20-0.9-5/8			5/8	PRX
3851-20-0.9-6/10			6/10	PRX
3851-20-0.9-8/12			8/12	PRX
3851-20-0.9-10/14			10/14	PRX
3851-27-0.9-2/3			27	0.9
3851-27-0.9-3/4	3/4	PRX		
3851-27-0.9-4/6	4/6	PRX		
3851-27-0.9-5/8	5/8	PRX		
3851-27-0.9-6/10	6/10	PRX		
3851-27-0.9-8/12	8/12	PRX		
3851-27-0.9-10/14	10/14	PRX		
3851-27-0.9-P-3	3	PS		
3851-27-0.9-P-4	4	PS		

	Width	Thickness	TPI	Shape		
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	PRX		
3851-34-1.1-3/4			3/4	PRX		
3851-34-1.1-4/6			4/6	PRX		
3851-34-1.1-5/8			5/8	PRX		
3851-34-1.1-6/10	41	1.3	6/10	PRX		
3851-41-1.3-P-2			2	PS		
3851-41-1.3-2/3			2/3	PRX		
3851-41-1.3-3/4			3/4	PRX		
3851-41-1.3-4/6			4/6	PRX		
3851-41-1.3-5/8			5/8	PRX		
3851-41-1.3-1.4/2	54	1.3	1.4/2	PRX		
3851-54-1.3-2/3			2/3	PRX		
3851-54-1.3-3/4			3/4	PRX		
3851-54-1.3-4/6			4/6	PRX		
3851-54-1.6-2/3			54	1.6	2/3	PRX
3851-54-1.6-3/4					3/4	PRX
3851-54-1.6-1.4/2	1.4/2	PRX				
3851-54-1.6-P-1.25	1.25	PS				
3851-54-1.6-1/1.4	1/1.4	PRX				
3851-67-1.6-1/1.4	67	1.6			1/1.4	PRX
3851-67-1.6-1.4/2			1.4/2	PRX		
3851-67-1.6-7/1			0.7/1	PRX		
3851-80-1.6-1/1.4	80	1.6	1/1.4	PRX		
3851-80-1.6-1.4/2			1.4/2	PRX		
3851-80-1.6-7/1			0.7/1	PRX		





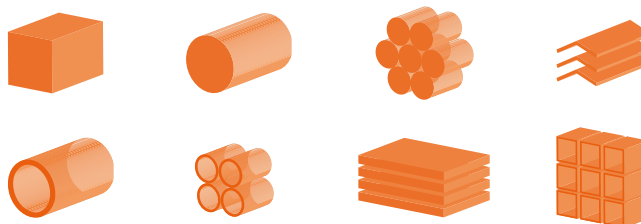
### Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

### Colors

- GOOD
- BETTER
- BEST

### Shapes





# Trouble Shooting Chart


	Important Facts	Band breakage	Crooked sawing	Tooth breakage	Rough surface	Rapid tooth wear	Vibration	Band slips on wheel
<b>MACHINE</b>	<b>Guides and Guidearms</b> 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	
	<b>Band Wheels</b> 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
	<b>Chip Brush</b> Check that the chip brush is properly adjusted and change it regularly.			Chip brush does not work; gullets filled		Chip brush does not work		
	<b>Band Tension</b> 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
	<b>Coolant / Cutting Fluid</b> 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		
<b>CUTTING DATA</b>	<b>Band Speed</b> 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	
	<b>Feed Rate</b> 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
<b>BANDSAW BLADE</b>	<b>Tooth Pitch</b> 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		
	<b>Tooth Shape</b> Every tooth shape has its ideal application.			Tooth shape too weak		Wrong tooth shape selection	Use combo	
	<b>Running In</b> 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	
	<b>Blade Life</b> All blades wear out eventually. Look for signs of wear.		Blade worn out		Blade worn out			Blade worn out
<b>WORKPIECE</b>	<b>Surface</b> 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		
	<b>Clamping</b> 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 of the bandsaw blade and are vital for optimum performance. Made out of strong nylon and available in 6 sizes. Code gives outer and bore diameter in mm.



	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-BRUSH-100-HEX	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 - 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 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

### GL008 - GLOVE

A thin PU material gives user better touch and feel.



	Pack Qty.	Weight g
GL008-10	6	72
GL008-8	6	69

### GL010 - GLOVE

Anti-vibration pads on fingers and palms.



	Pack Qty.	Weight g
GL010-10	6	72
GL010-8	6	69

### 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

## Packaging Information

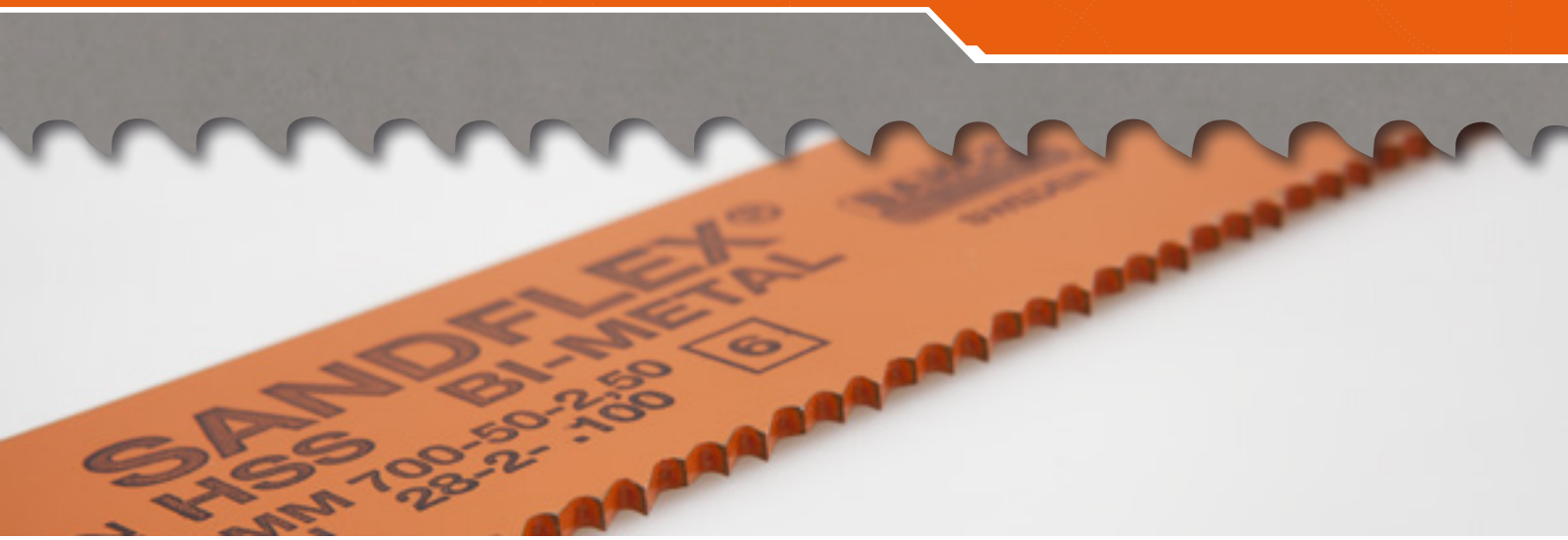
#### Minimum number of loops per packaging / Bi-metal and Carbide 3866, 3868, 3869, 3881, 3860

WIDTH		LENGTH, MM/FT				
MM	INCHES	≤3000 ≤9' - 10"	3001 - 3660 9'10" - 12'0"	3661 - 4120 12'1" - 13'6"	4121 - 5334 13'7" - 17'5"	≥5335 ≥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	76 250'	50 164'	30 100'	15 50'
≤20	≤3/4	X	-	X	X
27-34	1 - 1-1/4	X	-	-	-
≥41	≥1-1/2	-	X	-	-





# POWER HACKSAWS

## HINTS FOR POWER HACKSAWING WITH SANDFLEX® HACKSAW BLADES

- Tension the blade more than conventional HSS blades. Re-tensioning may be necessary
- Run in a new blade for a few minutes at reduced feed
- Set the right feed by checking the chips. They should be round, fine and spiral shaped. Burned or blued chips mean that the feed is too high
- Thin chips mean that the feed is too low
- Use the recommended coolant
- Make sure that the workpiece is securely clamped
- Choose a wider and thicker blade for steel grades with poor machinability. The material wastage will be higher, but the risk of crooked kerfs will be reduced
- Never use a new blade to saw in an existing kerf
- Avoid sawing into sharp edges and corners
- Always start the saw with the blade clear of the workpiece. The teeth should not be touching the workpiece when the machine is started
- Keep the machine in good condition

## BLADE TENSIONING

Correct blade tension is essential for ensuring a straight kerf and a long useful life of the blade. If the tension is too low, the blade will bend upwards or twist, giving rise to high stresses, heavy wear of the blade and uneven, crooked kerfs. Excessive tension causes high stresses in the blade and saw frame. In such cases, the blade will generally break, but the frame may also be damaged, particularly if a heavy blade is used.

The only reliable way of tensioning the blade is to use the Bahco blade tensionmeter. This is an instrument mounted on the saw blade that measures its elongation when tension is applied.

There is a recommended value for every blade.

- Fix the blade in the saw frame with the tooth points facing in the direction of sawing but do not tension the blade
- Check that the blade lies absolutely flat against the blade holder
- Secure the blade-tension gauge to the saw blade
- Turn the tensioning nut until the scale on the blade-tension gauge shows the recommended tension
- If you do not have a blade-tension gauge, follow the blade tensioning recommendations of the manufacturer

## ■ STROKE RATE

The correct stroke rate for a given job depends on the machinability of the material. For maximum blade life the stroke rate should be low and the feed pressure moderate. As a general rule, harder materials call for a lower stroke rate and higher feed pressure.

## ■ FEED

The cutting capacity of a hacksaw depends – among other things – on a combination of feed pressure and stroke rate. Maximizing feed pressure and stroke rate certainly increases capacity, but it also increases the danger of a crooked cut and leads to faster blade wear. Our recommendation is to use a high feed pressure but to reduce the stroke rate.

It is not possible to provide exact feed pressures since conditions vary on different machines. Excessive feed pressure may give rise to tooth stripping, skew cutting and even blade breakage. Insufficient feed pressure may cause the saw teeth to slide on the workpiece without cutting properly, resulting in overheating, softening and abnormally rapid wear.

By studying the workpiece, the blade and the chips, you can often tell whether you have chosen a suitable pressure. Here are some clues: If machine vibration is abnormal, feed pressure is too high.

If the chips are burnt, feed pressure is too high.  
If tooth cracks appear, feed pressure is too high.  
Fine, powdery chips indicate that feed pressure is too low.

The teeth may also show signs of overheating and dulling.

Fine curled chips indicate the optimal feed pressure.

**A new blade should always be “run in” by sawing with reduced feed pressure for a few minutes to ensure a longer blade life.**

## ■ MATERIALS AND TOOTHING

Standard Bahco power hacksaw blades are supplied with 4, 6, 8, 10 and 14 teeth per inch (blades for Kasto® machines are also available with 2 and 3 teeth per inch). For power sawing it is particularly important to select the right number of teeth per inch. A useful rule of thumb is that at least three teeth should be engaged at any one time.

Tooth choice will depend on the properties and dimensions of the material to be sawn. Thin stock requires more teeth per inch to prevent them from digging in and being broken off. Soft materials such as aluminium call for large chip spaces, i.e. a large pitch, to prevent the chips from clogging the teeth of the blade and interfering with sawing.



## 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 by inexperienced operators. Suitable for use on any material.



			L x W x T mm		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
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

			L x W x T mm		Weight g
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

## 3809 KA BI-METAL FOR KASTO MACHINES

Designed with holes for KASTO machines.



			L x W x T mm		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
3809-550-50-2.50-6-KA	10		550 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

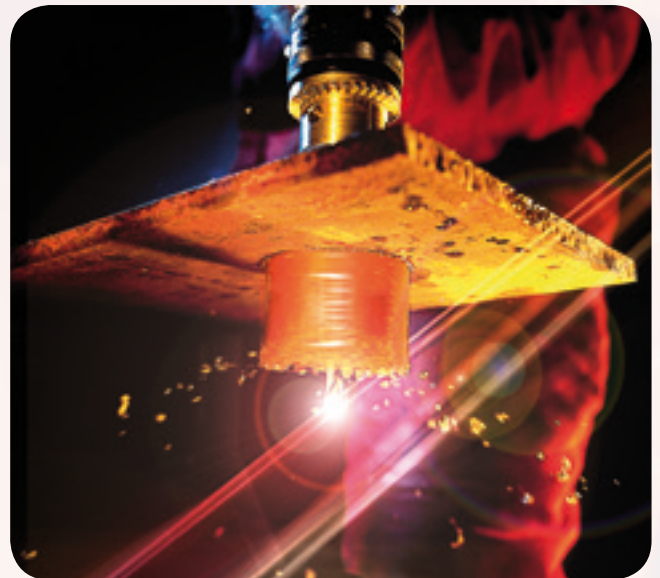


# HOLESAWS DESIGNED FOR PROFESSIONAL USE

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

Every aspect of the holesaws is engineered to improve productivity and craftsmanship from the design of the cutting edges to the technologies used to produce the holesaws.

The holesaws fit standard portable drills and drill presses.



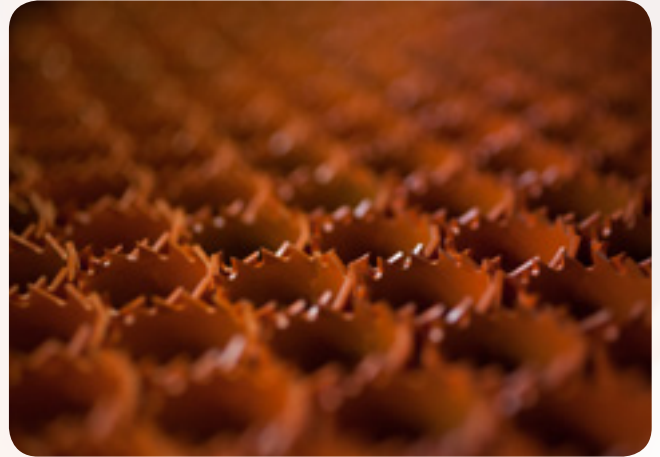
Power Driver™ arbors stabilise the sawing operation and distribute efficiently the cutting forces on the saw.



## ■ LONG LIFE, FAST CUTS AND REDUCED EFFORT

The true quality of a holesaw is not found in its colour or its packaging, but in the choice of material, the design, the tooth profile and last but not least, the construction of the arbor. On the surface many holesaws may look identical but put them to the test and you will quickly realise that the differences are considerable.

In Bahco's saw laboratory we test every holesaw in the market place. We know where the differences and similarities lie. There is a clear performance difference between professional quality tools and other alternatives that are used in a non-professional environment.



## ■ SANDFLEX® HOLESAWS

Bahco Sandflex® holesaws have a 4/6 tooth pitch. By varying the distance between the teeth (vari-pitch) a smoother cut is achieved with less vibration, even in difficult-to-cut materials.

The aggressive tooth shape cuts fast, whilst the large tooth gullets and large tooth set make removal more efficient.

All VIP holesaws are manufactured from Sandflex® bi-metal steel with hardened teeth of high-alloyed, high-speed steel (HSS). Bi-metal gives increased safety

as it will not shatter even if overloaded. It enables the optimum cutting performance in all machinable materials from wood to stainless steel, and it gives increased resistance to wear.

- 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" (14 mm to 210 mm)
- Cutting depth for all diameters is 1 1/2" (38 mm)

## ■ CARBIDE HOLESAWS

On carbide-tipped (CT) holesaws tooth tips consist of a carbide "round rod" which is fusion welded to the back material. The tip is then ground to its final shape with 5° positive cutting angle.

CT holesaws offer the new capability to cut holes in light concrete, brick, tile, reinforced plastics and other abrasive, non-ferrous materials.

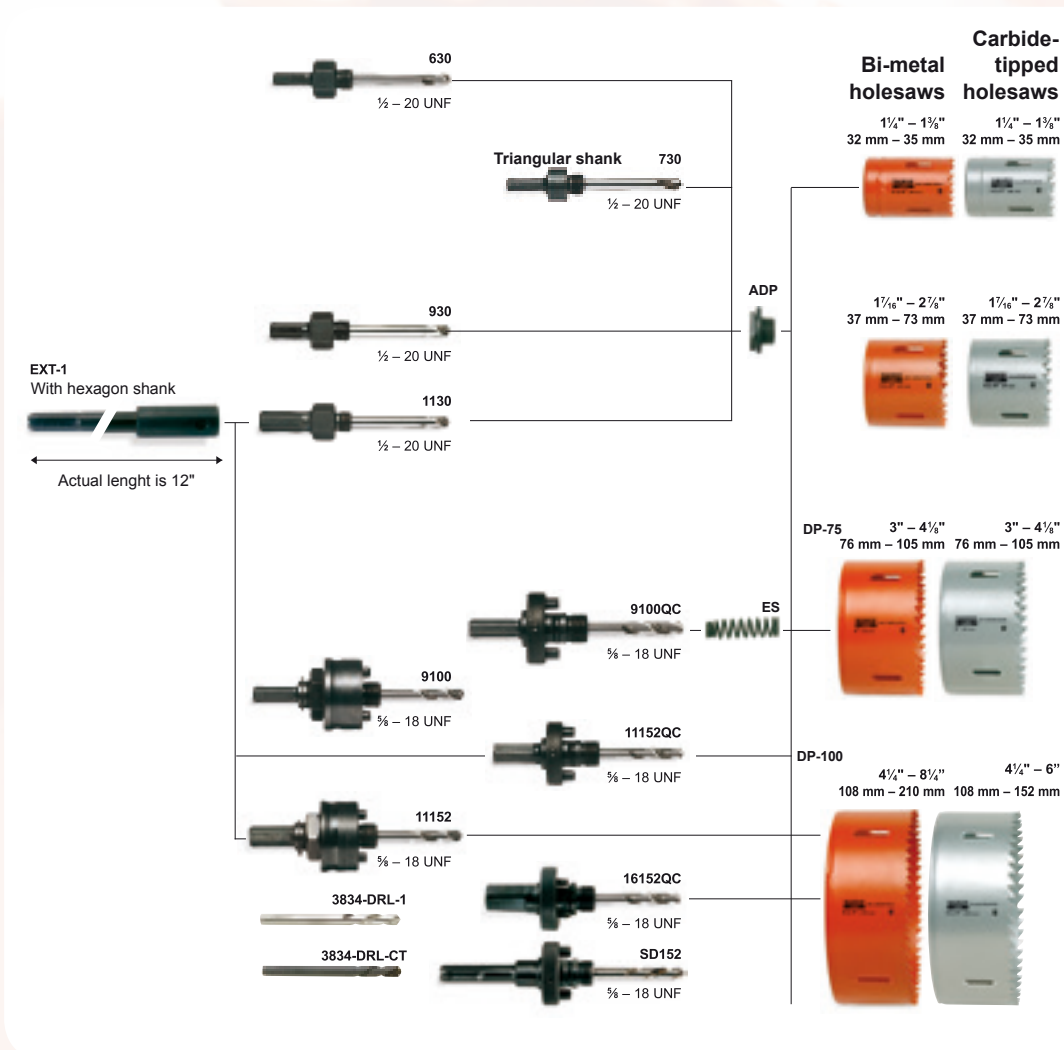
Carbide saws cut clean holes in ceramics, brick, slate, laminate, fibreglass, hardwood...

Knockout holes allow easy core removal  
Diameters from 9/16" to 8.1/4" (14 mm to 152 mm)  
Cutting depth for all diameters is 1 1/2" (38 mm)

# HOLESAW SYSTEM

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.



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 workload in static machines.

QC arbors have a quick-change mechanism so that tools are not required when changing holesaws.

All arbors are hardened for maximum strength.

Large arbors, for holesaws 32-210 mm, have drive pins to transfer larger cutting force from power unit to the holesaw. We recommend not using 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 abrasive materials we recommend the use of carbide-tipped pilot drill, 3834-DRL-CT.





# BI-METAL

## 3830 SANDFLEX® BI-METAL HOLESAWS

Bahco Sandflex® bi-metal holesaws perform well 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. Every holesaw is 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

	Pack Qty.	mm	inch	Weight g
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







# CARBIDE

## 3832 CARBIDE HOLESAWS

Bahco carbide tipped holesaws are capable of cutting through brick and ceramic tiles, laminate, fibreglass and hardwood. 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

	Pack Qty.	mm	inch	Weight g
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



# HOLESAW SET

Sets of holesaws and accessories for tradesmen, 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-930 (14-30 mm)
	3834-ARBR-9100 (32-100 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"
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 accessories:	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



### Kit 9 Piece 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)



### Kit 14 Piece 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 accessories:	3834-DRL 3834-ES Hexagonal key Chip brush



### Kit 9 Piece 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)



### Kit 11 Piece 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)



### Kit 10 Piece 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-1130 (14-30 mm) 3834-ARBR-11152 (32-210 mm)
Pilot drill:	3834-DRL



### Kit 13 Piece 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)
Accessories:	Hexagonal key Chip brush



### Kit 12 Piece 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 accessories:	3834-DRL Hexagonal key
Adapter:	3834-ADP



### Kit 13 Piece 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 accessories:	3834-DRL Hexagonal key Chip brush





# ACCESSORIES

## ARBORS FOR HOLES SAWS 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. pilote en carbure 3834-DRL-CT.

	Pack Qty.	 mm	 inch	 mm	 inch	Weight g
<b>Fits Holesaws 9/16"-1 3/16", 14-30 mm, Industrial Box</b>						
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
<b>Fits Holesaws 9/16"-1 3/16", 14-30 mm, Individually Carded</b>						
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
<b>Fits Holesaws 1 1/4"-8 1/4", 32-210 mm, Industrial Box</b>						
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
<b>Fits Holesaws 1 1/4"-8 1/4", 32-210 mm, Individually Carded</b>						
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
<b>Fits Holesaws 1 1/4"-4", 32-100 mm, Industrial Box</b>						
3834-ARBR-9100	1	8.5	11/32	10	3/8	250
3834-ARBR-9100QC	1	8.5	11/32	10	3/8	160
<b>Fits Holesaws 1 1/4"-4", 32-100 mm, Individually Carded</b>						
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



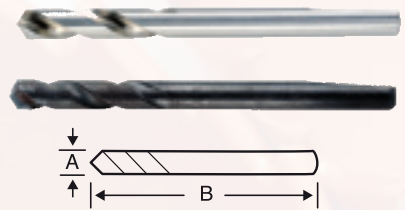
## OTHER PARTS

**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		
3834-ES	1	10





# RECIPROCATING SAWS

## ■ 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





How to select the perfect blade for the job from Bahco's 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 tothing 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" 4/6			3*
20-50	5/8	5/8 6 8 10	5/8 6 8 10	7" 5/8 8 10	5/8 6 8 10		6**
10-20	8/12 14	8/12 14	8/12 14	8/12 14	8/12 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).

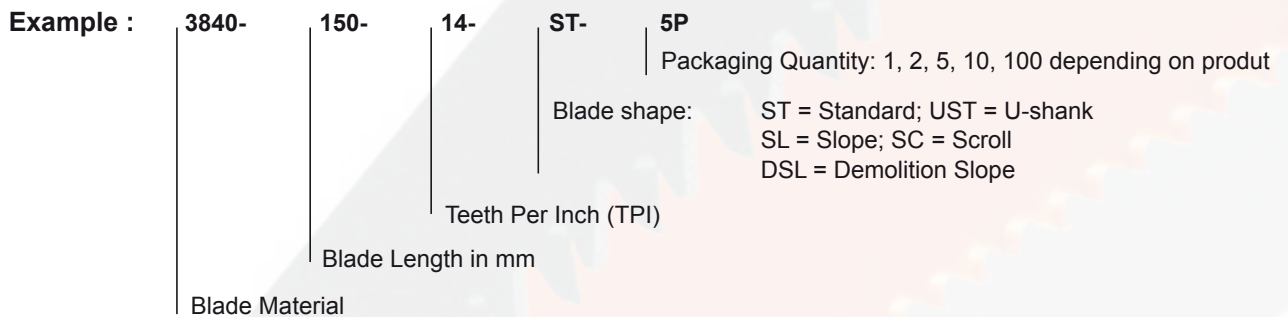
\* Wood-cutting blades. Special blades for pure wood cutting

\*\* 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 SAW BLADE

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





# BI-METAL

## 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/*
<b>5-PACK</b>			
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
<b>10-PACK</b>			
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
<b>100-PACK</b>			
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/*
<b>5-PACK</b>			
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
<b>10-PACK</b>			
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
<b>100-PACK</b>			
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/*
<b>5-PACK</b>			
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
<b>10-PACK</b>			
3840-150-4/6-SC-10P	150	1.3	4/6



# CARBIDE



## 3846 CARBURE

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	
<b>1-PACK</b>			
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
<b>2-PACK</b>		
3846-100-G-ST-2P	100	0.9
3846-150-G-ST-2P	150	0.9





# HAND HACKSAW BLADES




## 3906 SANDFLEX® BI-METAL BLADES

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



Our new way of painting is more environmentally friendly as we are using thin paint, non solvent borne, giving zero VOC emission. Besides taking care of our environment the new paint is better resistant to moisture. The blades remain orange even if they are used or stocked in damp environments. In addition to the new paint we gave the blades a white backing for anti-counterfeit purposes.

## 325 HAND HACKSAW FRAME



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 the reliable and shatterproof Sandflex® bi-metal blade 24 TPI with excellent cutting performance.



		Length mm	Weight g
319	5	300	510

## 320 HAND HACKSAW FRAME

Traditional hacksaw frame with comfortable handles and extra depth allowing for cutting materials of big dimensions. Supplied with the reliable and shatterproof Sandflex® bi-metal blade 24 TPI with excellent cutting performance.



		Length mm	Weight g
320	10	300	820



# FILES

## ■ ERGONOMIC HANDLES

Our file handles are ergonomically designed, following the Bahco ERGO™ Process, to reduce muscle tension and the risk of injury. The hard polypropylene core, covered with a thermoplastic elastomer, provides a comfortable non-slip grip, and the handle's smooth contours fit into the hand naturally.

As a safety feature, the handle covers the tang and shoulder completely. This prevents the hand from slipping off the handle onto the file blade. Bahco supplies most popular files complete with a symmetric handle to allow the user to grip it comfortably regardless of which side of the file is used.



THREE DIFFERENT SHAPES & SIZES WITH 12 DIFFERENT INSERTS

## ■ PATENTED DESIGN IMPROVES SAFETY AND COMFORT



## ENGINEERING FILES

Bahco's current file assortment represents the accumulated knowledge of file production since 1850.

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 fulfil 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.

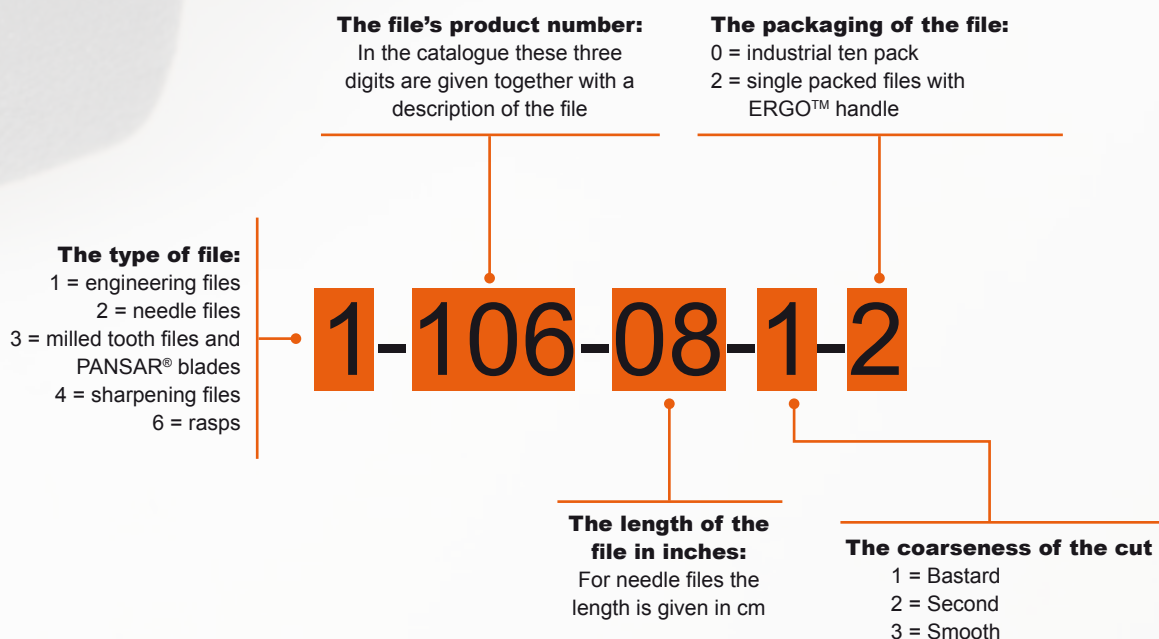
Bahco has established its reputation on the world market by investing substantial resources in research and development over the years. With a dedicated commitment to remain at the forefront of file development in the future, the company is determined to continue meeting professional customer needs.

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



## ARTICLE CODE STRUCTURE



The product codes of Bahco files have been chosen logically with each digit carrying an identifying piece of information. Most codes follow the code structure explained below.

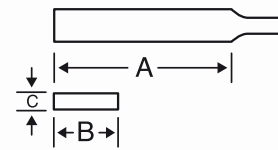


## HAND FILE / 1-100...-2

**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		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

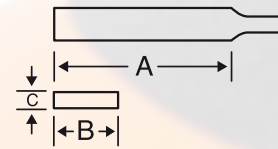


## HAND FILE "OBERG CUT" / 1-106...-2

**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		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

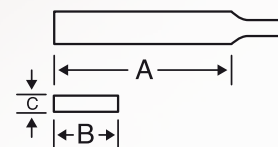


## FLAT FILE / 1-110...-2

**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		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



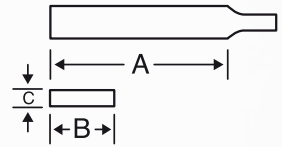
**Type of cut:** 1 = Bastard, 2 = Second, 3 = Smooth.





## 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.



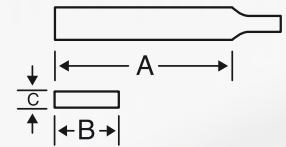
	Pack Qty.	A mm	B mm	C mm		Cut Type	Weight g
1-111-06-2-2	5	150	15	1.9	18	2	65



## 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.

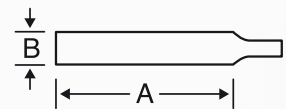




	Pack Qty.	A mm	B mm	C mm		Cut Type	Weight g
1-143-06-1-2	5	150	16	2.7	20	1	90
1-143-08-1-2	5	200	20	3.3	18	1	140
1-143-10-1-2	5	250	25	4.0	16	1	222
1-143-12-1-2	5	300	30	5.0	14	1	431

## 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.



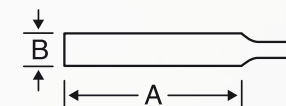
	Pack Qty.	A mm	B mm		Cut Type	Weight g
1-160-04-1-2	5	100	4.5	17	1	42
1-160-04-2-2	5	100	4.5	22	2	42
1-160-06-1-2	5	150	6.0	13	1	79
1-160-06-2-2	5	150	6.0	18	2	79
1-160-06-3-2	5	150	6.0	22	3	79
1-160-08-1-2	5	200	8.0	10	1	132
1-160-08-2-2	5	200	8.0	14	2	132
1-160-08-3-2	5	200	8.0	18	3	132
1-160-10-1-2	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		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

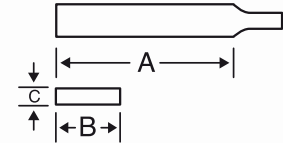
Type of cut: 1 = Bastard, 2 = Second, 3 = Smooth.

## 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		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

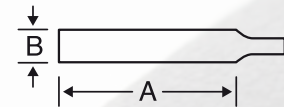


## ROUND FILE / 1-230...-2

**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		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



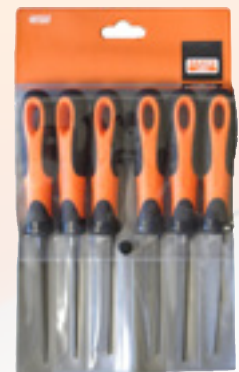
## FILE SETS / 1-473

Sets of three handled files. 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 lengths: 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



1-473



1-476

## 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



1-478

## FILE SETS / 1-478

Sets of five 5" files with handle. Contains one each of: hand bastard, hand second, square bastard, half round bastard, round bastard.

	Pack Qty.	mm	Cut Type	Weight g
1-478-08-1-2	5	200	1	935
1-478-10-1-2	5	250	1	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 made of either tungsten carbide or high speed steel. It all depends on the application, as to which burr you should choose.

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





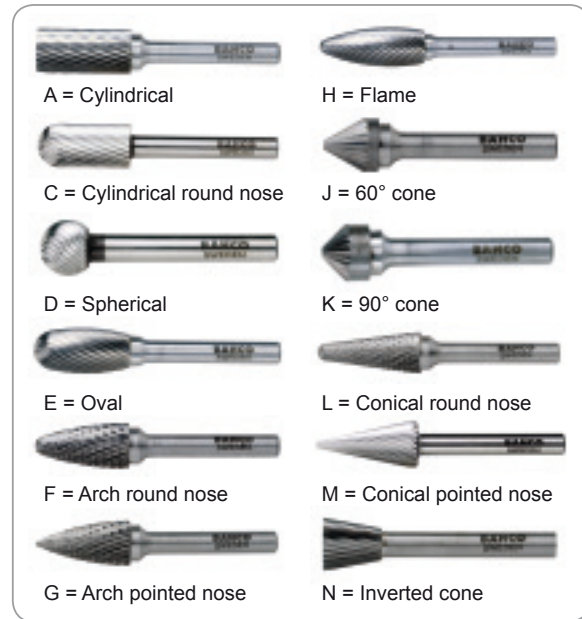
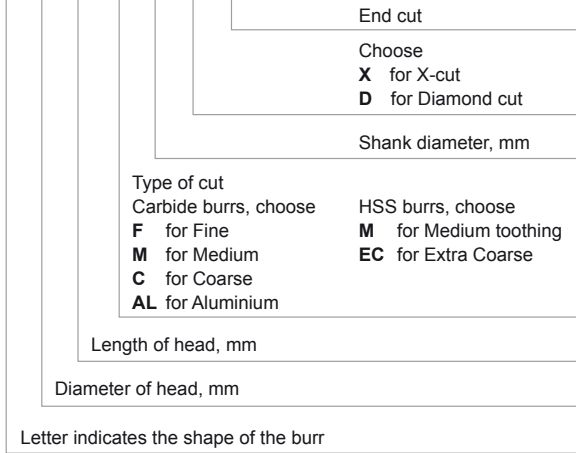
## IDENTIFICATION SYSTEM

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**



## CHOOSE THE RIGHT ROTARY BURR

TOOTHING		TUNGSTEN CARBIDE BURRS	HIGH-SPEED STEEL (HSS) BURRS
Fine		For hard and/or tough materials where a smooth surface finish is required and 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. Prevents 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.	

**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 has 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. 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.

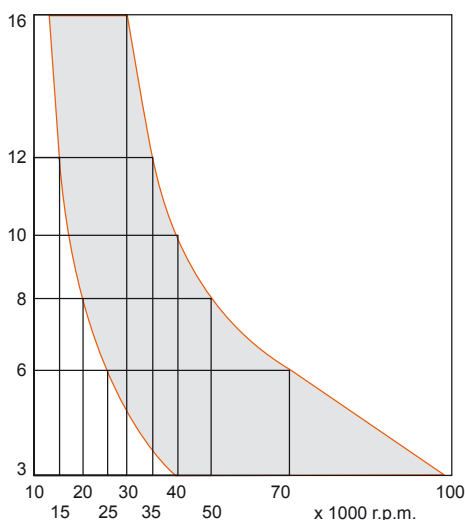
### Tungsten Carbide

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

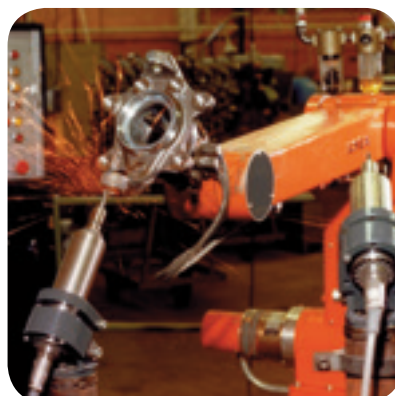
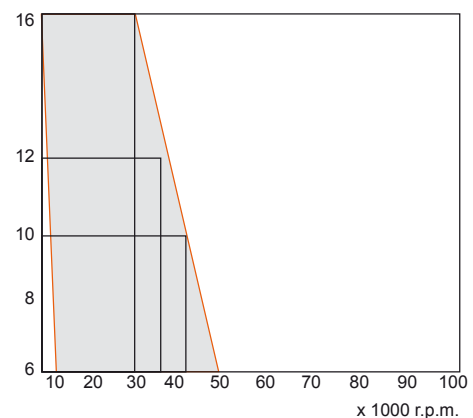
Head Ø mm	Unhardened steels, softer materials and cast iron.	Soft materials, aluminium, thermoplastics, brass.
	R.P.M x 1000	R.P.M x 1000
6	5 - 20	20 - 40
10	3 - 10	10 - 30
12	1 - 10	10 - 30
16	1 - 8	10 - 25

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



## 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	





## 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 = 60° 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 = 90° 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





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