

**NEW**

# **BAND SAW BLADES**

INTELLIGENT SOLUTIONS  
MADE BY

***Eberle***

# PREMIUM LINE

NEW

dimensions in	teeth per inch (tpi)							dimensions mm
<b>CT-flex® nano   coated carbide-tipped blades</b>								
	.75/1.25	1/1.3	1.4/2	2	2/3	3	3/4	
1 1/2 x .050			TR ●	TR ○	TR ●	TR ○	TR ○	41 x 1,30
2 x .063		TR ○	TR ●	TR ○	TR ○			54 x 1,60
2 5/8 x .063	TR ○	TR ●	TR ●					67 x 1,60
3 1/8 x .063	TR ●		TR ●					80 x 1,60

<b>CT-flex® 3000   carbide-tipped blades</b>								
	.75/1.25	1/1.3	1.4/2	2	2/3	3		
1 x .035					TR			27 x 0,90
1 1/4 x .042				TR	TR	TR		34 x 1,10
1 1/2 x .050			TR	TR	TR	TR		41 x 1,30
2 x .063	TR	TR	TR	TR				54 x 1,60
2 5/8 x .063	TR	TR	TR					67 x 1,60
3 1/8 x .063	TR		TR					80 x 1,60

<b>CT-flex® 4000   carbide-tipped blades</b>								
	.75/1.25	1/1.3	1.4/2	2	2/3	3	3/4	
3/4 x .035						TR		20 x 0,90
1 x .035					TR	TR	TR	27 x 0,90
1 1/4 x .042				TR	TR	TR	TR	34 x 1,10
1 1/2 x .050			TR	TR	TR	TR	TR	41 x 1,30
2 x .063	TR	TR	TR	TR	TR			54 x 1,60
2 5/8 x .063	TR	TR	TR					67 x 1,60
3 1/8 x .063	TR		TR					80 x 1,60

NEW

<b>CT-flex® Alu XL   carbide-tipped blades</b>								
		.75/1.25	1/1.3	1.4/2	2	2/3		
1 1/2 x .050					TR	TR	TR	41 x 1,30
2 x .063		TR	TR	TR				54 x 1,60
2 5/8 x .063		TR	TR	TR				67 x 1,60
3 1/8 x .063		TR						80 x 1,60

NEW

<b>CT-flex® CHM   carbide-tipped blades</b>								
			3	3/4				
1 x .035			TRN	TRN				27 x 0,90
1 1/4 x .042			TRN	TRN				34 x 1,10
1 1/2 x .050			TRN	TRN				41 x 1,30

<b>nanoflex® Black   coated bimetal blades</b>								
		.75/1.25	1/1.3	1.4/2	2/3	3/4		
1 1/2 x .050				DCS	DCS	DCS		41 x 1,30
2 x .063			DCS	DCS	DCS	DCS		54 x 1,60
2 5/8 x .063		DCS	DCS	DCS				67 x 1,60
3 1/8 x .063		DCS	DCS	DCS				80 x 1,60

<b>duoflex® GT   bimetal blades</b>								
		.75/1.25	1/1.3	1.4/2				
2 x .063		DCS	DCS	DCS				54 x 1,60
2 5/8 x .063		DCS	DCS	DCS				67 x 1,60
3 1/8 x .063		DCS	DCS	DCS				80 x 1,60

Please refer to page 5 for an explanation of DCS, TR and TRN.

● standard ○ on request

## COATED CARBIDE-TIPPED BLADES

### CT-flex® nano

**Features:** special TiAlN coating, heat resistant cutting edge, MultiChip® Geometry  
**Specialty:** for high strength and heat treated materials and nickel based alloys

**Applications:** 

**Material Hardness:** ≤ 65 HRC

**NEW**

## CARBIDE-TIPPED BLADES

### CT-flex® 3000


**Features:** high performance, high productivity, high stability  
**Specialty:** for extra hard-to-cut materials, e.g. Titanium, Inconel

**Applications:** 

**Material Hardness:** ≤ 65 HRC

### CT-flex® 4000


**Features:** high performance, short cutting time, low vibration  
**Specialty:** for heavy duty materials, e.g. Titanium, Inconel and Aluminum

**Applications:** 

**Material Hardness:** ≤ 65 HRC

### CT-flex® ALU XL


**Features:** reduced material loss, improved tooth geometry, less forces  
**Specialty:** designed for Aluminium and Aluminium alloys

**Applications:** 

**NEW**

### CT-flex® CHM

**Features:** highest cutting performance and excellent wear resistance  
**Specialty:** specially designed negative tooth geometry for case hardened materials and chrome rod applications

**Applications:** 

**Material Hardness:** ≤ 65 HRC

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## COATED BIMETAL BLADES

### nanoflex® Black

**Features:** excellent wear resistance, low friction, high degree of red hardness  
**Specialty:** TiAlN Black coating, prehoned edge quality, break-in not required

**Applications:** 

**Material Hardness:** ≤ 50 HRC

## BIMETAL BLADES

### duoflex® GT

**Features:** excellent finish, extremely clean cutting surface, large applications  
**Specialty:** ground triple chip tooth geometry, tool steels, nickel-based alloys, high alloys, mold steels

**Applications:** 

**Material Hardness:** ≤ 50 HRC

## BIMETAL BLADES

### duoflex® SP

**Features:** large applications, reduces cutting force and heat in cut due to special tooth geometry  
**Specialty:** especially suited for cutting stainless steel, tool steels, 4140, nickel-based alloys

**Applications:** 

**Material Hardness:** ≤ 49 HRC

### duoflex® M51

**Features:** heavy duty applications, M51 heat and wear resistance  
**Specialty:** cutting performance of HSS-teeth is increased by alloying Cobalt and Tungsten

**Applications:** 

**Material Hardness:** ≤ 49 HRC

### duoflex® M42

**Features:** bimetal blade, high speed steel combined with 4% chrome backing material  
**Specialty:** multi-functional, almost all steel grades in workshops and serial production

**Applications:** 

**Material Hardness:** ≤ 44 HRC

### duoflex® PT

**Features:** extreme cutting performance, smooth finish and blade life in interrupted cuts  
**Specialty:** engineered to reduce vibration, resists tooth breakage especially on pipes and tubes

**Applications:** 

**Material Hardness:** ≤ 44 HRC

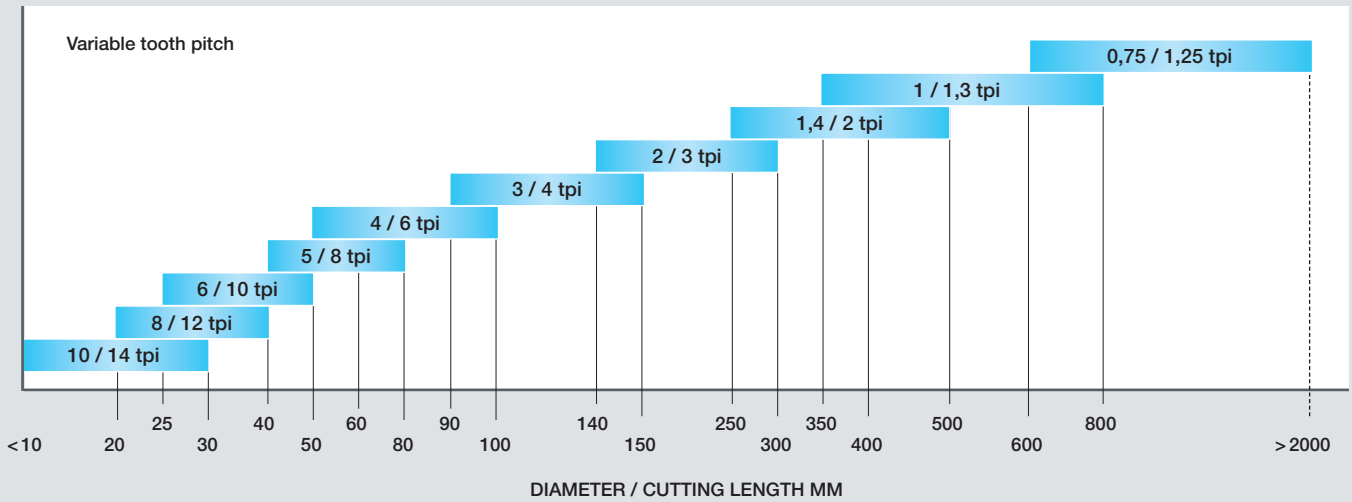
## Product development has highest priority at Eberle.

New materials and highest quality requirements set the benchmarks for our Premium and Professional Line.

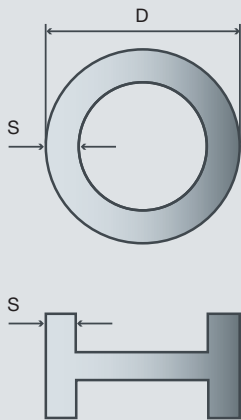
dimensions in	teeth per inch (tpi)														dimensions mm				
<b>duoflex® SP   bimetal blades</b>																			
				.75/1.25	1/1.3	1.4/2	2/3	3/4											
1 x .035								CSP							27 x 0,90				
1 1/4 x .042							CSP	CSP							34 x 1,10				
1 1/2 x .050						CSP	CSP	CSP							41 x 1,30				
2 x .063					CSP	CSP	CSP								54 x 1,60				
2 5/8 x .063			CSP	CSP	CSP	CSP									67 x 1,60				
3 1/8 x .063			CSP	CSP											80 x 1,60				
<b>duoflex® M51   bimetal band saw blades</b>																			
				.75/1.25	1/1.3	1.4/2	2/3	3/4	4/6										
1 x 0.35							DCS	DCS	CS						27 x 0,90				
1 1/4 x 0.42							DCS	DCS	CS						34 x 1,10				
1 1/2 x 0.50							DCS	DCS							41 x 1,30				
2 x 0.63						DCS	DCS	DCS							54 x 1,60				
2 5/8 x 0.63			DCS		DCS	DCS									67 x 1,60				
3 1/8 x 0.63			DCS	DCS	DCS										80 x 1,60				
<b>duoflex® M42   bimetal band saw blades</b>																			
			3	4	6	8	10	14	.75/ 1.25	1/1.3	1.4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14	
1/4 x .035			CW	CW		N	N											N	6 x 0,90
3/8 x .035			CW	CW		N	N											N	10 x 0,90
1/2 x .025			CW	CW		N	N									N	N	N	13 x 0,65
1/2 x .035		CW	CW	CW	N	N	N									N	N	N	13 x 0,90
3/4 x .035						N	N						N/CS	N	N	N	N	N	20 x 0,90
1 x .035		DCS	CS	N							DCS	N/DCS	N/CS DCS	N/CS	N	N	N	N	27 x 0,90
1 1/4 x .042				CS							DCS	N/DCS	N/CS DCS	N/CS	N	N			34 x 1,10
1 1/2 x .050				CS						DCS	DCS	N/DCS	N/CS DCS	N/CS					41 x 1,30
2 x .050											DCS	DCS	CS						54 x 1,30
2 x .063									DCS	DCS	DCS	DCS	DCS	CS					54 x 1,60
2 5/8 x .063									DCS	DCS	DCS	DCS	DCS						67 x 1,60
3 1/8 x .063									DCS	DCS	DCS								80 x 1,60
<b>duoflex® PT   bimetal band saw blades</b>																			
					2/3	3/4	4/6	5/8	8/12										
3/4 x .035													CST						20 x 0,90
1 x .035				CST	CST	CST	CST	CST	CST										27 x 0,90
1 1/4 x .042				CST	CST	CST	CST	CST											34 x 1,10
1 1/2 x .050				CST	CST	CST	CST	CST											41 x 1,30
2 x .063				CST	CST	CST													54 x 1,60
2 5/8 x .063				CST	CST														67 x 1,60

Please refer to page 5 for an explanation of CS, CSP, CST, CW, DCS and N.

## CUTTING RECOMMENDATIONS FOR SOLID MATERIAL



## CUTTING RECOMMENDATIONS FOR TUBES AND PROFILES



D mm	20	40	60	80	100	150	200	300	400	500	> 700
<b>S mm</b>	<b>teeth per inch (tpi)</b>										
<b>2</b>	14	14	14	14	10/14	10/14	10/14	10/14	8/12	8/12	6/10
<b>3</b>	14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	6/10	6/10	6/10
<b>4</b>	14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6
<b>5</b>	14	10/14	10/14	8/12	6/10	6/10	5/8	4/6	4/6	4/6	4/6
<b>6</b>	14	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6	4/6	4/6
<b>8</b>	14	8/12	6/10	6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6
<b>10</b>		6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4
<b>12</b>		6/10	5/8	4/6	4/6	4/6	4/6	3/4	3/4	3/4	3/4
<b>15</b>				4/6	4/6	3/4	3/4	3/4	3/4	2/3	2/3
<b>20</b>				4/6	4/6	3/4	3/4	3/4	3/4	2/3	2/3
<b>30</b>				3/4	3/4	3/4	2/3	2/3	2/3	2/3	1,4/2
<b>50</b>						2/3	2/3	2/3	2/3	1,4/2	1,4/2
<b>80</b>							2/3	1,4/2	1,4/2	1,4/2	1/1,3
<b>100</b>								1,4/2	1,4/2	1/1,3	0,75/1,25
<b>150</b>										0,75/1,25	0,75/1,25
<b>&gt; 250</b>										0,75/1,25	0,75/1,25

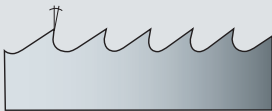
## TOOTH FORMS



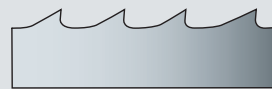
**N-TOOTH** | neutral rake angle  
 > short-chip materials  
 > small work pieces



**CST-TOOTH** | positive rake angle  
 > short-chip materials  
 > profiles, tubes, bundles



**CS-TOOTH** | positive rake angle  
 > long-chip, tough materials  
 > universal application



**CW-TOOTH** | positive rake angle  
 > low-alloy materials, Aluminum  
 > mold construction, contours



**DCS-TOOTH** | positive rake angle  
 > heavy duty, high alloyed work pieces  
 > large cross-sections



**TR/TRN-TOOTH** | variable rake angle  
 > heavy duty work pieces  
 > high cutting performance



**CSP-TOOTH** | positive rake angle  
 > austenitic materials  
 > nickel-based alloys

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A company of the group



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**We look forward to your call!**

# *Eberle*

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Cold Rolling Mill and Saw Factory  
Quality products since 1836