BAND SAW BLADES

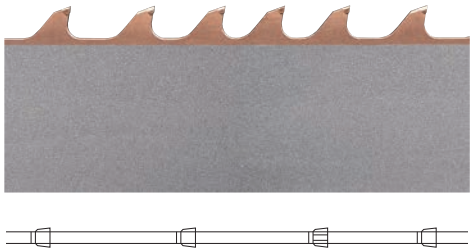
Performance
Precision
Quality

INTELLIGENT SOLUTIONS
MADE BY

Eberle

CT-flex® nano

Coated carbide-tipped blade



Features: TiAlN-coating, MultiChip® geometry, heat and wear resistant cutting edge, pre-honed tooth edges

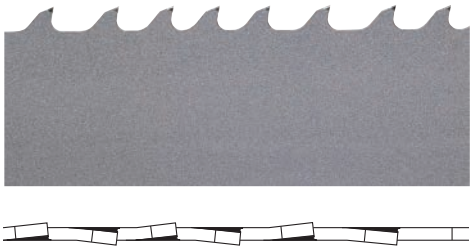
Applications: stainless, acid-resistant, hardening martensitic steel, nickel-based alloys ≤ 65 HRC

Work pieces: round bar | square bar | flat bar

mm	teeth per inch (tpi)							in
	0,75/1,25	1/1,3	1,4/2	2	2/3	3	3/4	
41 x 1,30			TR •	TR ❍	TR •	TR ❍	TR ❍	1 1/2 x .050
54 x 1,60		TR ❍	TR •	TR ❍	TR ❍			2 x .063
67 x 1,60	TR ❍	TR •	TR •					2 5/8 x .063
80 x 1,60	TR •		TR •					3 1/8 x .063

CT-flex® 3000

Carbide-tipped blade



Features: CT3 geometry, excellent performance, short cycle times, high stability

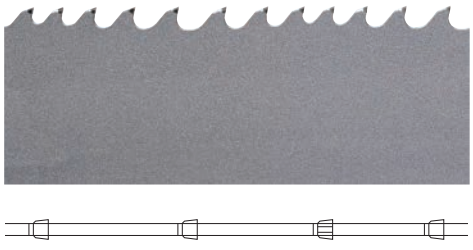
Applications: extremely hard-to-cut materials ≤ 65 HRC

Work pieces: round bar | square bar | flat bar

mm	teeth per inch (tpi)							in
	0,75/1,25	1/1,3	1,4/2	2	2/3	3		
27 x 0,90					TR			1 x .035
34 x 1,10				TR	TR	TR		1 1/4 x .042
41 x 1,30			TR	TR	TR	TR		1 1/2 x .050
54 x 1,60	TR	TR	TR	TR				2 x .063
67 x 1,60	TR	TR	TR					2 5/8 x .063
80 x 1,60	TR		TR					3 1/8 x .063

CT-flex® 4000

Carbide-tipped blade



Features: CT4 geometry, excellent performance, short cycle times, very smooth running blade

Applications: hard-to-cut materials, Aluminum ≤ 65 HRC

Work pieces: round bar | square bar | flat bar

mm	teeth per inch (tpi)							in
	0,75/1,25	1/1,3	1,4/2	2	2/3	3	3/4	
20 x 0,90						TR		3/4 x .035
27 x 0,90					TR	TR	TR	1 x .035
34 x 1,10				TR	TR	TR	TR	1 1/4 x .042
41 x 1,30			TR	TR	TR	TR	TR	1 1/2 x .050
54 x 1,60	TR	TR	TR	TR	TR			2 x .063
67 x 1,60	TR	TR	TR					2 5/8 x .063
80 x 1,60	TR		TR					3 1/8 x .063

• standard ❍ on request

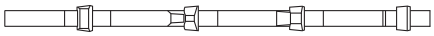
CT-flex® CHM

Carbide-tipped blade

Features: Multichip® geometry, superior performance, negative rake angle, extreme wear resistance

Applications: case hardened and chrome plated materials ≤ 65 HRC

Work pieces: round bar | tubing | bundle single-layer



mm	teeth per inch (tpi)						in
			3	3/4			
27 x 0,90			TRN	TRN			1 x .035
34 x 1,10			TRN	TRN			1 1/4 x .042
41 x 1,30			TRN	TRN			1 1/2 x .050

CT-flex® ALU XL

Carbide-tipped blade

Features: Multichip® geometry, improved chip formation, minor material loss, less forces

Applications: large plates and large blocks of Aluminum

Work pieces: round bar | square bar | flat bar

mm	teeth per inch (tpi)						in
	0,75/1,25	1/1,3	1,4/2	2	2/3		
41 x 1,30			TR	TR	TR		1 1/2 x .050
54 x 1,60	TR	TR	TR				2 x .063
67 x 1,60	TR	TR	TR				2 5/8 x .063
80 x 1,60	TR						3 1/8 x .063

CT-flex® Pro

Carbide-tipped blade

Features: set tooth, unique tooth geometry, minor vibration development

Applications: corrosion and acid-resistant steels, nickel-based alloys ≤ 65 HRC

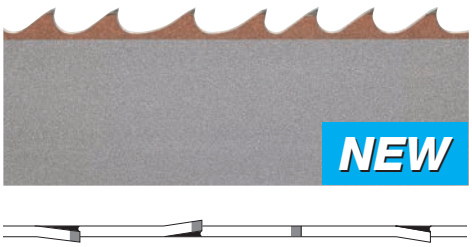
Work pieces: round bar | tubing | square bar | flat bar

mm	teeth per inch (tpi)						in
	1,4/2	2	2/3	3	3/4		
20 x 0,90				ST			3/4 x .035
27 x 0,90				ST	ST		1 x .035
34 x 1,10			ST		ST		1 1/4 x .042
41 x 1,30	ST	ST	ST				1 1/2 x .050
54 x 1,60	ST						2 x .063

ST = set tooth

nanoflex® VTX

Coated bimetal blade



Features: TiAlN-coating, micro-resistant cutting edge, increased tooth hardness, variable tooth height with strongly positive rake angle

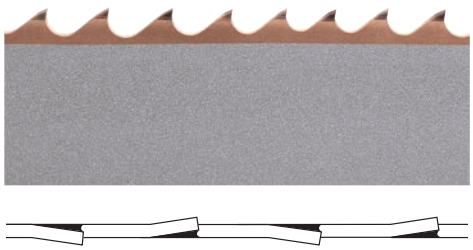
Applications: corrosion and acid-resistant steel, nickel-based alloys, tempered steel
≤ 50 HRC

Work pieces: round bar, tubing, square bar, flat bar

mm	teeth per inch (tpi)					in
	0,65/0,95	0,75/1,25	1,4/2	2/3		
34 x 1,10				CHT		1 1/4 x .042
41 x 1,30			CHT	CHT		1 1/2 x .050
54 x 1,30			CHT	CHT		2 x .050
54 x 1,60			CHT	CHT		2 x .063
67 x 1,60	CHT	CHT	CHT			2 5/8 x .063
80 x 1,60	CHT	CHT	CHT			3 1/8 x .063

nanoflex® Black

Coated bimetal blade



Features: TiAlN-coating, prehoned edges, short cycle times, excellent wear resistance

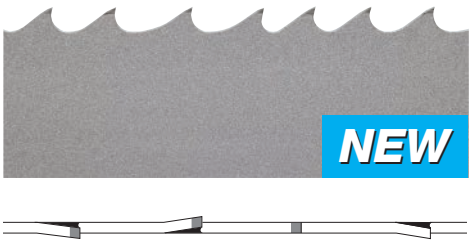
Applications: universally applicable
≤ 50 HRC

Work pieces: round bar, tubing, bundle single-layer, square bar, flat bar, beams, special profiles

mm	teeth per inch (tpi)					in
	0,75/1,25	1/1,3	1,4/2	2/3	3/4	
41 x 1,30			DCS	DCS	DCS	1 1/2 x .050
54 x 1,60		DCS	DCS	DCS	DCS	2 x .063
67 x 1,60	DCS	DCS	DCS			2 5/8 x .063
80 x 1,60	DCS	DCS	DCS			3 1/8 x .063

duoflex® VTX

Bimetal blade



Features: micro-resistant cutting edge, increased tooth hardness, variable tooth height with strongly positive rake angle

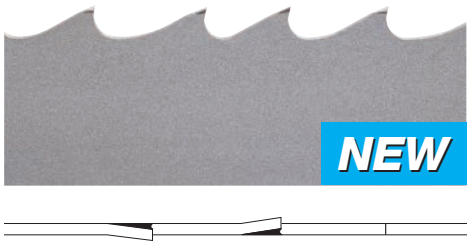
Applications: corrosion and acid-resistant steel, nickel-based alloys, tempered steel
≤ 50 HRC

Work pieces: round bar, tubing, square bar, flat bar

mm	teeth per inch (tpi)					in
	0,65/0,95	0,75/1,25	1,4/2	2/3		
34 x 1,10				CHT		1 1/4 x .042
41 x 1,30			CHT	CHT		1 1/2 x .050
54 x 1,30			CHT	CHT		2 x .050
54 x 1,60			CHT	CHT		2 x .063
67 x 1,60	CHT	CHT	CHT			2 5/8 x .063
80 x 1,60	CHT	CHT	CHT			3 1/8 x .063

duoflex® GTX

Bimetal blade



Features: ground triple chip tooth geometry, micro-resistant cutting edge, excellent surface finish

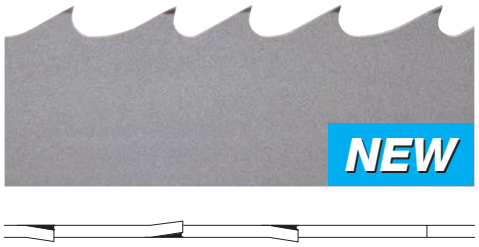
Applications: large applications
≤ 50 HRC

Work pieces: round bar, square bar, flat bar, beams

mm	teeth per inch (tpi)						in
	0,75/1,25	1/1,3	1,4/2				
54 x 1,60	DCS	DCS	DCS				2 x .063
67 x 1,60	DCS	DCS	DCS				2 5/8 x .063
80 x 1,60	DCS	DCS	DCS				3 1/8 x .063

duoflex® SPX

Bimetal blade



Features: special tooth geometry, micro-resistant cutting edge, reduced cutting force

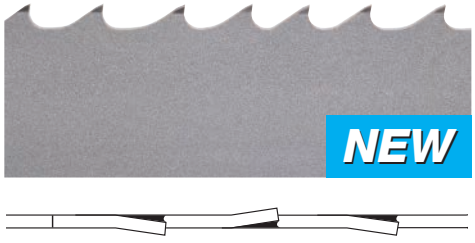
Applications: austenitic steels, nickel-based alloys
≤ 49 HRC

Work pieces: round bar, thick-walled tubes, square bar, flat bar, beams

mm	teeth per inch (tpi)							in
	0,75/1,25	1/1,3	1,4/2	2/3	3/4			
27 x 0,90					CSP			1 x .035
34 x 1,10				CSP	CSP			1 1/4 x .042
41 x 1,30			CSP	CSP	CSP			1 1/2 x .050
54 x 1,60		CSP	CSP	CSP				2 x .063
67 x 1,60	CSP	CSP	CSP	CSP				2 5/8 x .063
80 x 1,60	CSP	CSP						3 1/8 x .063

duoflex® MX55

Bimetal blade



Features: micro-resistant cutting edge, resistant against interrupted cuts,

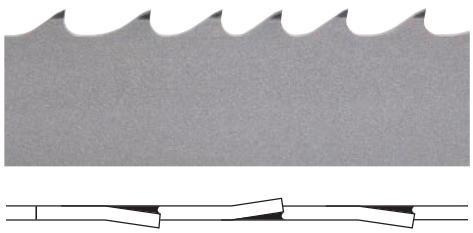
Applications: hard-to-cut materials, e.g. Duplex- and heat resistant steel, Titanium and Titanium alloys, Aluminum bronze, tempered steel
≤ 49 HRC

Work pieces: round bar, tubing, bundle single-layer, bundle round bars, bundle thick-walled tubes, square bar, flat bar, beams

mm	teeth per inch (tpi)						in
	0,75/1,25	1,4/2	2/3	3/4	4/6		
27 x 0,90			DCS	DCS	CS		1 x .035
34 x 1,10			DCS	DCS	CS		1 1/4 x .042
41 x 1,30			DCS	DCS			1 1/2 x .050
54 x 1,60		DCS	DCS	DCS			2 x .063
67 x 1,60	DCS	DCS	DCS				2 5/8 x .063
80 x 1,60	DCS	DCS					3 1/8 x .063

duoflex® M42

Bimetal blade



Features: efficient and powerful saw blade with vibration resistant tooth edge
Applications: universally applicable
≤ 44 HRC

Work pieces: round bar · thick-walled tubes · bundle single-layer · bundle multiple-layer · bundle round bars · square bar · flat bar · bundle thick-walled tubes · beams · special profiles

mm	teeth per inch (tpi)															in
	3	4	6	8	10	14	0,75 / 1,25	1,4 / 2	2 / 3	3 / 4	4 / 6	5 / 8	6 / 10	8 / 12	10 / 14	
6 x 0,90		CW	CW		N	N									N	1/4 x .035
10 x 0,90		CW	CW		N	N									N	3/8 x .035
13 x 0,65		CW	CW		N	N							N	N	N	1/2 x .025
13 x 0,90	CW	CW	CW	N	N	N							N	N	N	1/2 x .035
20 x 0,90					N	N					N/CS	N	N	N	N	3/4 x .035
27 x 0,90	DCS	CS	N						DCS	N/DCS	N/CS DCS	N/CS	N	N	N	1 x .035
34 x 1,10			CS						DCS	N/DCS	N/CS	N	N	N		1 1/4 x .042
41 x 1,30			CS					DCS	DCS	DCS	N/CS	N				1 1/2 x .050
54 x 1,30									DCS	DCS	CS					2 x .050
54 x 1,60							DCS	DCS	DCS	DCS	CS					2 x .063
67 x 1,60							DCS	DCS	DCS	DCS						2 5/8 x .063
80 x 1,60							DCS	DCS								3 1/8 x .063

duoflex® PT

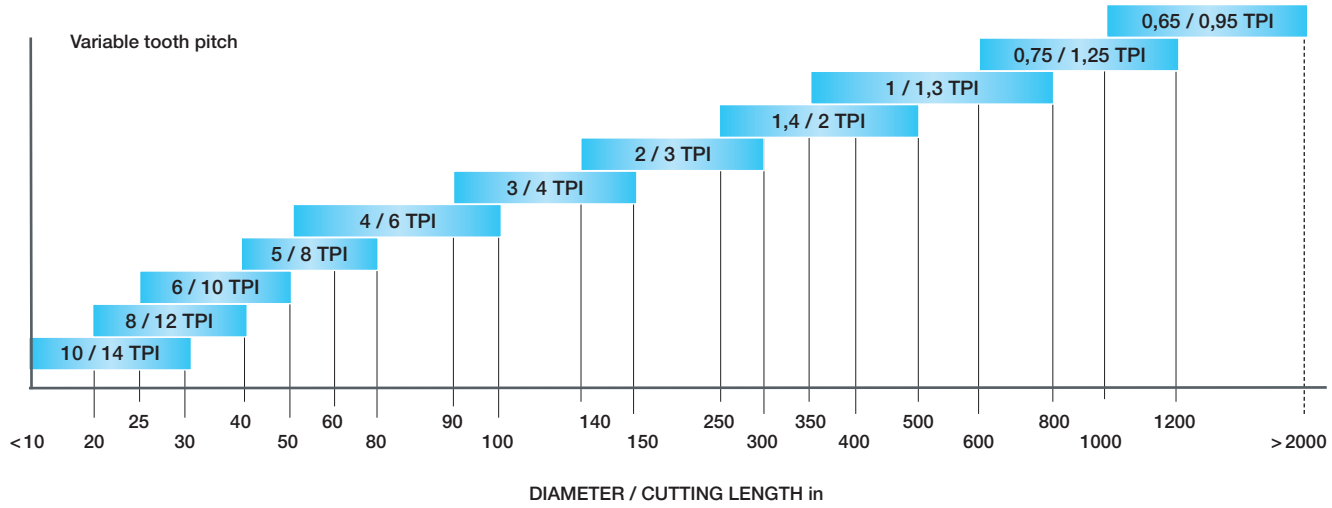
Bimetal blade

Features: highest cutting performance in interrupted cuts, reduced vibration, resistant to tooth breakage
Applications: pipes and tubes
≤ 44 HRC

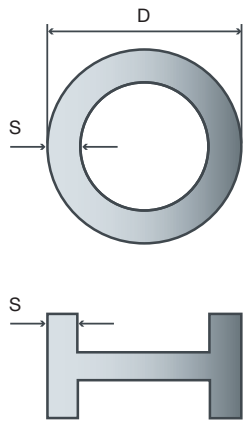
Work pieces: Tubes · bundle single-layer · bundle multiple-layer · bundle round bars · bundle thick-walled tubes · beams · special profiles

mm	teeth per inch (tpi)						in
	2 / 3	3 / 4	4 / 6	5 / 8	8 / 12		
20 x 0,90					CST		3/4 x .035
27 x 0,90	CST	CST	CST	CST	CST		1 x .035
34 x 1,10	CST	CST	CST	CST			1 1/4 x .042
41 x 1,30	CST	CST	CST	CST			1 1/2 x .050
54 x 1,60	CST	CST	CST				2 x .063
67 x 1,60	CST	CST					2 5/8 x .063

CUTTING RECOMMENDATIONS FOR SOLID MATERIAL

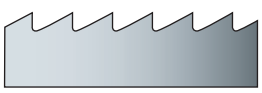


CUTTING RECOMMENDATIONS FOR TUBES AND PROFILES

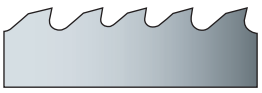


D mm	20	40	60	80	100	150	200	300	400	500	> 700
S mm	teeth per inch (tpi)										
2	14	14	14	14	10/14	10/14	10/14	10/14	8/12	8/12	6/10
3	14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	6/10	6/10	6/10
4	14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6
5	14	10/14	10/14	8/12	6/10	6/10	5/8	4/6	4/6	4/6	4/6
6	14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

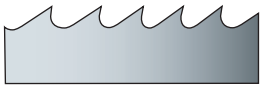
TOOTH FORMS



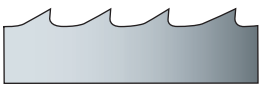
N–TOOTH | neutral rake angle
> short-chip materials
> small work pieces



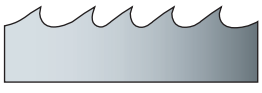
CST–TOOTH | positive rake angle
> short-chip materials
> profiles, tubes, bundles



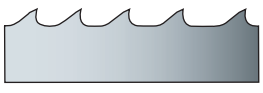
CS-TOOTH | positive rake angle
> long-chip, tough materials
> universal application



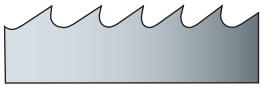
CW–TOOTH | positive rake angle
> low-alloy materials, Aluminum
> mold construction, contours



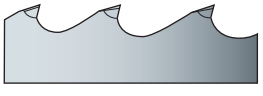
DCS–TOOTH | positive rake angle
> heavy duty, high alloyed work pieces
> large cross-sections



CHT–TOOTH | variable, extremely positive rake angle
> hard-to-cut materials, heat-treated steels
> large to very large work pieces



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



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

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Eberle Cutting Data App
The Eberle Cutting Data App provides you immediately and precisely with the cutting parameters for individual bimetal and carbide tipped band saw cutting. It can be downloaded from our homepage or www.eberleslidechart.com or from:

Training
We offer band saw blade training to your company upon request. Just contact our distribution network or get in touch with our headquarter.

Technical advice
Should you have any questions about band saw applications or ways to optimize sawing processes, Eberle's expert team will provide competent support:

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We look forward to your call.

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