

BAND SAW BLADES

Eberle CT-flex nano

*Performance
Precision
Quality*

INTELLIGENT SOLUTIONS
MADE BY

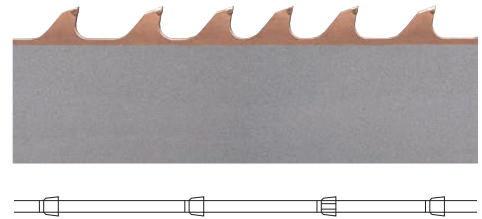
Eberle

CT-flex® nano

Coated
carbide-tipped blade

Features: TiAlN-coating, 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



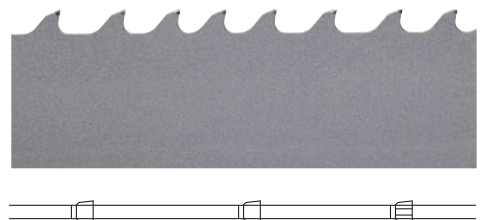
in	teeth per inch (tpi)							mm
	.75/1.25	1/1.3	1.4/2	2	2/3	3	3/4	
1 1/2 x .050			TR ●	TR ○	TR ●	TR ○	TR ○	41 x 1,30
2 x .063		TR ○	TR ●	TR ○	TR ○			54 x 1,60
2 5/8 x .063	TR ○	TR ●	TR ●					67 x 1,60
3 1/8 x .063	TR ●		TR ●					80 x 1,60

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



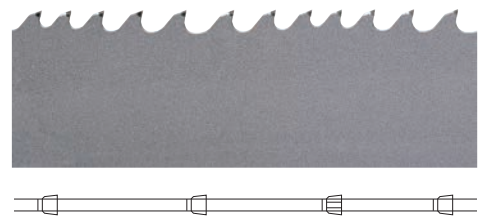
in	teeth per inch (tpi)							mm
	.75/1.25	1/1.3	1.4/2	2	2/3	3		
1 x .035					TR			27 x 0,90
1 1/4 x .042				TR	TR	TR		34 x 1,10
1 1/2 x .050			TR	TR	TR	TR		41 x 1,30
2 x .063	TR	TR	TR	TR				54 x 1,60
2 5/8 x .063	TR	TR	TR					67 x 1,60
3 1/8 x .063	TR		TR					80 x 1,60

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



in	teeth per inch (tpi)							mm
	.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

• standard ○ on request

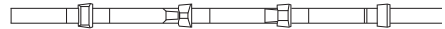
CT-flex® CHM

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 ○ thick-walled tubing ●● bundle single-layer



in	teeth per inch (tpi)						mm
			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

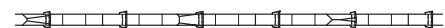
CT-flex® ALU XS

Carbide-tipped blade

Features: Multichip® geometry, reduced feed force, free cutting, resists pinching, optimized for manual feed
 Applications: Aluminum, Aluminum alloys, non-ferrous metals



Work pieces: ● round bar ■ square bar ■ flat bar



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

CT-flex® ALU XL

Carbide-tipped blade

Features: Multichip® geometry, improved chip formation, minor material loss, thin kerf
 Applications: large plates and large blocks of Aluminum



Work pieces: ● round bar ■ square bar ■ flat bar



in	teeth per inch (tpi)						mm
		.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

CT-flex® Pro

Carbide-tipped blade

Features: triple chip tooth geometry, set tooth, vibration resistant
 Applications: corrosion and acid-resistant steels, nickel-based alloys ≤ 65 HRC



Work pieces: ● round bar ○ thick-walled tubing ■ square bar ■ flat bar

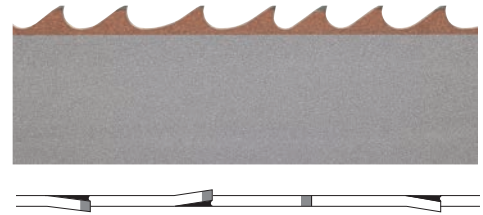


in	teeth per inch (tpi)						mm
		1.4/2	2	2/3	3	3/4	
3/4 x .035					ST		20 x 0,90
1 x .035					ST	ST	27 x 0,90
1 1/4 x .042				ST		ST	34 x 1,10
1 1/2 x .050		ST	ST	ST			41 x 1,30
2 x .063		ST					54 x 1,60

nanoflex® VTX

Coated
bimetal blade

Features: TiAlN-coating, special alloyed micro-resistant cutting edge, increased tooth hardness, variable tooth height with extremely positive rake angle
Applications: corrosion and acid-resistant steel, nickel-based alloys, tempered steel
≤ 50 HRC



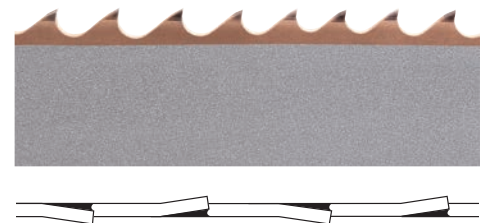
Work pieces: round bar thick-walled tubing square bar flat bar

in	teeth per inch (tpi)							mm
	.65/.95	.75/1.25	1.1/1.5	1.4/2	2/3	3/4		
1 x .035						CHT	27 x 0,90	
1 1/4 x .042					CHT	CHT	34 x 1,10	
1 1/2 x .050				CHT	CHT	CHT	41 x 1,30	
2 x .050				CHT	CHT		54 x 1,30	
2 x .063			CHT ○	CHT	CHT		54 x 1,60	
2 5/8 x .063	CHT	CHT	CHT ○	CHT			67 x 1,60	
3 1/8 x .063	CHT	CHT	CHT ○	CHT			80 x 1,60	

nanoflex® Black

Coated
bimetal blade

Features: TiAlN-coating, prehoned edges, short cycle times, excellent wear resistance
Applications: Aluminum, mild steels, alloys, stainless steels
≤ 50 HRC



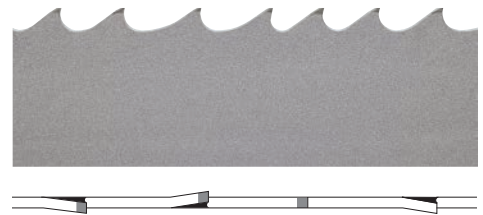
Work pieces: round bar tubing bundle single-layer
 square bar flat bar beams special profiles

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

duoflex® VTX

Bimetal blade

Features: special alloyed micro-resistant cutting edge, increased tooth hardness, variable tooth height with extremely positive rake angle
Applications: mold steels, stainless steels, nickel-based and heat-treated alloys
≤ 50 HRC



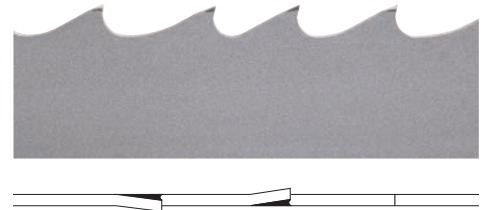
Work pieces: round bar thick-walled tubing square bar flat bar

in	teeth per inch (tpi)							mm
	.65/.95	.75/1.25	1.1/1.5	1.4/2	2/3	3/4		
1 x .035						CHT	27 x 0,90	
1 1/4 x .042					CHT	CHT	34 x 1,10	
1 1/2 x .050				CHT	CHT	CHT	41 x 1,30	
2 x .050				CHT	CHT		54 x 1,30	
2 x .063			CHT ○	CHT	CHT		54 x 1,60	
2 5/8 x .063	CHT	CHT	CHT ○	CHT			67 x 1,60	
3 1/8 x .063	CHT	CHT	CHT ○	CHT			80 x 1,60	

duoflex® GTX

Bimetal blade

Features: special alloyed micro-resistant cutting edge,
ground triple chip geometry, excellent finish
Applications: large applications of mold steels, alloys
≤ 50 HRC



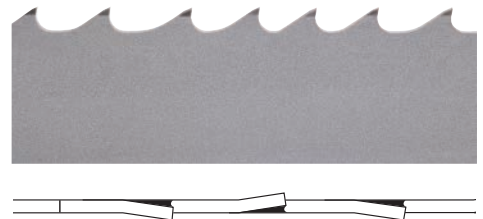
Work pieces: round bar square bar flat bar beams

in	teeth per inch (tpi)							mm
		.75/1.25	1/1.3	1.4/2				
2 x .063		DCS	CSP	DCS				54 x 1,60
2 5/8 x .063		DCS	CSP	DCS				67 x 1,60
3 1/8 x .063		DCS	CSP	DCS				80 x 1,60

duoflex® MX55

Bimetal blade

Features: special alloyed micro-resistant cutting edge,
positive rake angle, general purpose capability
Applications: mild steels, alloyed, stainless and heat resistant steels
≤ 49 HRC

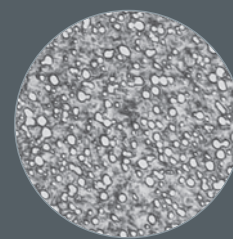


Work pieces: round bar thick-walled tubes bundle single-layer
 bundle thick-walled tubes bundle round bars square bar flat bar beams

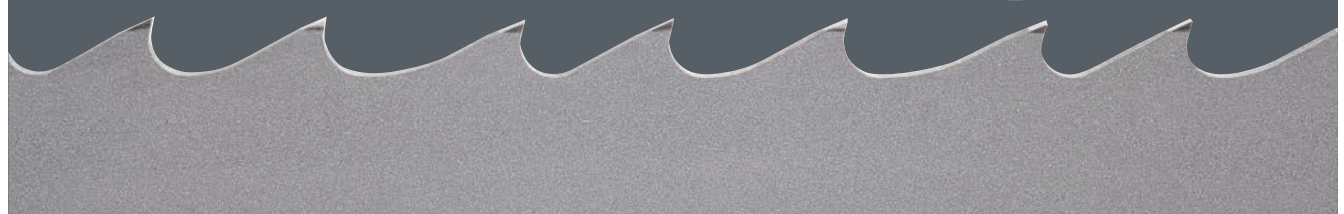
in	teeth per inch (tpi)							mm
		.75/1.25	1/1.3	1.4/2	2/3	3/4	4/6	
1 x .035					DCS	DCS	CS	27 x 0,90
1 1/4 x .042					DCS	DCS	CS	34 x 1,10
1 1/2 x .050					DCS	DCS		41 x 1,30
2 x .063			CSP	DCS	DCS	DCS		54 x 1,60
2 5/8 x .063		DCS	CSP	DCS	DCS			67 x 1,60
3 1/8 x .063		DCS	CSP	DCS				80 x 1,60

Experience more performance and precision with the X-Series:

- advanced uniform microstructure
- constant hardness and toughness values
- micro-resistant, stable cutting edge
- top cutting accuracy
- reduced machine load
- greatly extended blade life



Eberle X-Series
Microstructure



duoflex® M42

Bimetal blade

Features: vibration resistant tooth edge, zero and positive rake angles
 Applications: variable and constant tooth pitches for universal applications, mild steels, structural steels, alloys ≤ 44 HRC



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

in	teeth per inch (tpi)														mm	
	3	4	6	8	10	14	.75/ 1.25	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		20 x 0,90
1 x .035	DCS	CS	N						DCS	N/DCS	N/CS DCS	N/CS	N	N	N	27 x 0,90
1 1/4 x .042			CS						DCS	N/DCS	N/CS	N	N	N		34 x 1,10
1 1/2 x .050			CS					DCS	DCS	DCS	N/CS	N				41 x 1,30
2 x .050								DCS	DCS	DCS	CS					54 x 1,30
2 x .063							DCS	DCS	DCS	DCS	CS					54 x 1,60
2 5/8 x .063							DCS	DCS	DCS	DCS						67 x 1,60
3 1/8 x .063							DCS	DCS								80 x 1,60

duoflex® PT

Bimetal blade

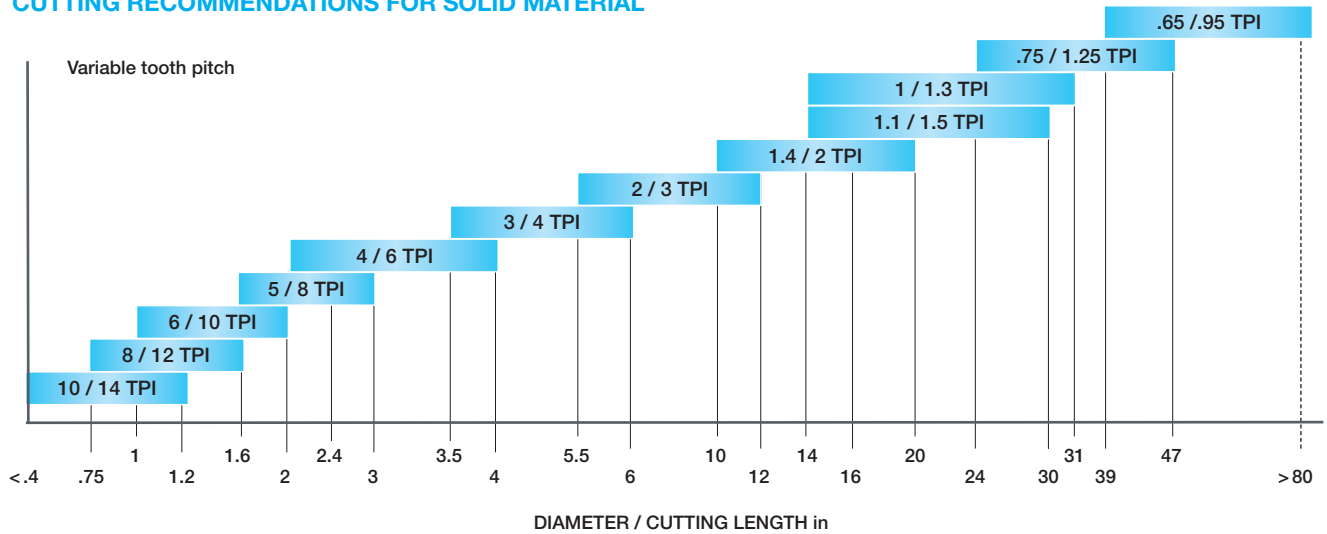
Features: strong positive tooth geometry, variable setting widths, reduced vibration and tooth breakage
 Applications: profiles and tubes ≤ 44 HRC



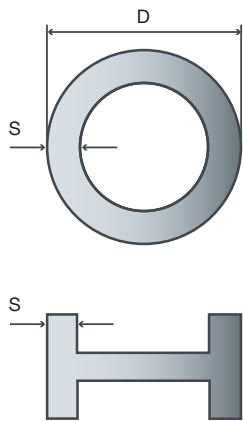
- Work pieces:
- Tubes
 - bundle single-layer
 - bundle multiple-layer
 - bundle round bars
 - bundle tubes
 - beams
 - special profiles

in	teeth per inch (tpi)						mm
	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	27 x 0,90
1 1/4 x .042		CST	CST	CST	CST		34 x 1,10
1 1/2 x .050		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

CUTTING RECOMMENDATIONS FOR SOLID MATERIAL

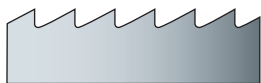


CUTTING RECOMMENDATIONS FOR TUBES AND PROFILES



D in	.75	1.5	2.4	3	4	6	8	12	16	20	> 28
S in	teeth per inch (tpi)										
.08	14	14	14	14	10/14	10/14	10/14	10/14	8/12	8/12	6/10
.12	14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	6/10	6/10	6/10
.15	14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6
.20	14	10/14	10/14	8/12	6/10	6/10	5/8	4/6	4/6	4/6	4/6
.25	14	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6	4/6	4/6
.3	14	8/12	6/10	6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6
.4		6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4
.5		6/10	5/8	4/6	4/6	4/6	4/6	3/4	3/4	3/4	3/4
.6				4/6	4/6	3/4	3/4	3/4	3/4	2/3	2/3
.75				4/6	4/6	3/4	3/4	3/4	3/4	2/3	2/3
1.2				3/4	3/4	3/4	2/3	2/3	2/3	2/3	1.4/2
2						2/3	2/3	2/3	2/3	1.4/2	1.4/2
3							2/3	1.4/2	1.4/2	1.4/2	1/1.3
4								1.4/2	1.4/2	1/1.3	.75/1.25
6										.75/1.25	.75/1.25
> 10										.75/1.25	.75/1.25

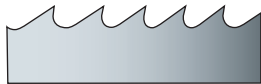
TOOTH FORMS



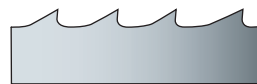
N-TOOTH | neutral rake angle
 > short-chip materials
 > small work pieces



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



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



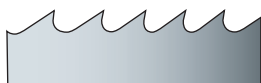
CW-TOOTH | positive rake angle
 > low-alloy materials, Aluminum
 > mold construction, contours



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 for bimetal and carbide band saws can be downloaded from our homepage www.eberleslidechart.com or from:

**Training**

We offer band saw blade training to your company upon request. Just contact your Authorized Eberle Distributor 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.

Eberle

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 Cold Rolling Mill and Saw Factory
 Quality products since 1836