

*The* BLADE MANUFACTURING CO.



Industrial Saw Blades and Saw Blade Sharpening  
Founded in 1946

# *The* **BLADE MFG. CO.**

915 Distribution Drive – Columbus, OH 43228  
614-294-1649 \* 800-227-4023 \* info@blademfg.com  
[www.blademfg.com](http://www.blademfg.com)

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## **COLD SAW BLADES M-2 (HSS DM05)**

STANDARD PIN HOLE CONFIGURATION TO ACCOMMODATE ALL COLD SAW MACHINES

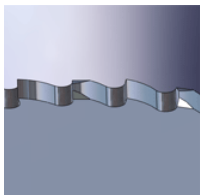
**32mm Bore** have pinhole pattern 2/8/45 and 2/12/63 (On 250mm to 315mm 2/9/50 or 4/9/50)\*

**40mm Bore** have pinhole pattern 2/9/55 and 4/12/64

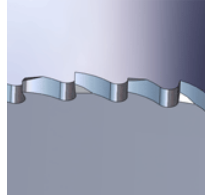
**50mm Bore** have pinhole pattern 4/15/80 and 4/14/85

**Cold Saw Blades are designed to cut ferrous and non-ferrous metals.** Cold Saw blades are made from M-2 HSS steel and M-35 (5% cobalt). Our cold saw blades are heat treated to 64-65 HRc and triple tempered and press quenched to ensure flatness. These blades are specifically suited for use on manual, semi-automatic and fully-automatic cold saws. When cutting ferrous metal, the typical RPM will not exceed 350 SFM. Typical applications include tubes, pipe, extrusions, bars, angle iron, structural shapes, billets, forgings, etc. When ordering please specify the material being cut so the correct tooth geometry is furnished for your job. Cold saw blades are listed in millimeters. If you do not see your size, contact us for availability.

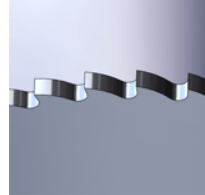
HABERLE™, BROBO™, PEDRAZZOLI™, DAKET™, SOCO™, TOMET™, PHOENIX™, MAXISAW™, DORINGER™, AMER BROWN™, MEC BROWN™, SUPER BROWN SPECIAL™, SUPER BROWN 350™, SCOTCHMAN™, EISELE™, WILTON™, BROWN™, IBPT™, KALAMAZOO™, FONG HO™, BAILEIGH™, THOMAS™, HYDMECH™, KMT™, STARTRITE™, MACC™, ENCO™, BEHRINGER™, TRENNJAEGER™, KALTENBACH™, KASTO™, YLM™, DUTCH™, BEWO™, MARATHON™, ACRA™ (NOT EVERY COLD SAW IS LISTED)



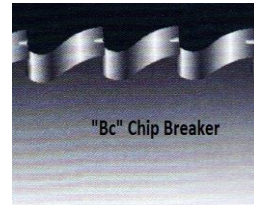
**"C" Tooth**



**"Bw" Tooth**



**"B" Tooth**



**"Bc" Tooth**

Convert mm's to inches divide mm by 25.4 ex. 350mm ÷ 25.4 = 13.78"

Convert inches to mm's multiply inches by 25.4 ex. 14" x 25.4 = 355.6mm

Find the Rim Speed or Surface Feet Per Minute SFPM - Diameter x RPM x .262

Ex. 13.78" x 25rpm x .262=90 SFPM

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## COLD SAW BLADES M-2 (HSS DM05)

**Materials Suggested:** FERROUS AND NON-FERROUS METALS  
TUBES, BARS, PIPE, ANGLE IRON, FORGINGS, BILLITS, STRUCTURAL,

**Machine Types Suggested:** MANUAL, SEMI-AUTOMATIC AND FULLY AUTOMATIC COLD SAWS

**M-35 and PVD Coatings** TiN, TiCN, TiAlN, Red Speed Available Upon Request

Standard blades are steam oxide coated. For TiN coated add a "G" to the end of the part number. For M-35 HSS+Cobalt, add a "M" to the end of the part number. **Contact us if a size you need is not listed.**

### TEETH CUT TO REQUEST

PART #	DIAMETER		KERF		ID
	mm	inch	mm	inch	
C160153	160	6.3"	1.6	.062"	32
C16613	166	6.5"	1.6	.062"	32
C175123	175	7"	1.2	.047"	32
C175163	175	7"	1.6	.062"	32
C200123	200	8"	1.2	.047"	32
C200163	200	8"	1.6	.062"	32
C200203	200	8"	2.0	.078"	32
C225123	225	9"	1.2	.047"	32
C225163	225	9"	1.6	.062"	32
C225203	225	9"	2.0	.078"	32
C225204	225	9"	2.0	.078"	40
C225253	225	9"	2.5	.098"	32
C250123	250	10"	1.2	.047"	32
C250163	250	10"	1.6	.062"	32
C250203	250	10"	2.0	.078"	32
C250204	250	10"	2.0	.078"	40
C250253	250	10"	2.5	.098"	32
C250254	250	10"	2.5	.098"	40
C275203	275	11"	2.0	.078"	32
C275204	275	11"	2.0	.078"	40
C275253	275	11"	2.5	.098"	32
C275254	275	11"	2.5	.098"	40
C300203	300	12"	2.0	.078"	32
C300204	300	12"	2.0	.078"	40
C300253	300	12"	2.5	.098"	32
C3002538	300	12"	2.5	.098"	38
C300254	300	12"	2.5	.098"	40
C300303	300	12"	3.0	.118"	32
C300304	300	12"	3.0	.118"	40
C315203	315	12.5"	2.0	.078"	32
C315204	315	12.5"	2.0	.078"	40

PART #	DIAMETER		KERF		ID
	mm	inch	mm	inch	
C315253	315	12.5"	2.5	.098"	32
C315254	315	12.5"	2.5	.098"	40
C315303	315	12.5"	3.0	.118"	32
C315304	315	12.5"	3.0	.118"	40
C325253	325	13"	2.5	.098"	32
C325254	325	13"	2.5	.098"	40
C350253	350	14"	2.5	.098"	32
C350254	350	14"	2.5	.098"	40
C350255	350	14"	2.5	.098"	50
C350303	350	14"	3.0	.118"	32
C350304	350	14"	3.0	.118"	40
C370303	370	15"	3.0	.118"	32
C370304	370	15"	3.0	.118"	40
C370305	370	15"	3.0	.118"	50
C400304	400	16"	3.0	.118"	40
C400305	400	16"	3.0	.118"	50
C400354	400	16"	3.5	.138"	40
C400355	400	16"	3.5	.138"	50
C425355	425	16.5"	3.5	.138"	50
C450354	450	17.5"	3.5	.138"	40
C450355	450	17.5"	3.5	.138"	50
C450404	450	17.5"	4.0	.157"	40
C450405	450	17.5"	4.0	.157"	50
C45045X	450	17.5"	4.5	.177"	40/50
C50035X	500	20"	3.5	.138"	40/50
C50040X	500	20"	4.0	.157"	40/50

C50045X 500 20" 4.5 .177" 40/50

\*DIAMETERS OVER 500 AVAILABLE  
\*\*ADDITIONAL SIZES AVAILABLE UPON  
REQUEST

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## ***CERMET & CARBIDE (TCT) METAL CUTTING SAW BLADES***

**Machine Types Suggested:** CNC Cold Saws, Nishijima, Tsune, Behringer/Eisele, Amada, Kasto/Wagner, Noritake, Hydmech Kaltenbach etc.

**Materials Suggested:** Mild low carbon steel, stainless steel, high carbon steel, solids and pipe

Carbide and Cermet Tipped Cold Saw Blades can greatly reduce your production cost and provide fast clean cuts in mild and tough steel solids, pipes and tubes. CNC technology and years of experience can benefit your production needs. Disposable and re-sharpenable blades are available. Contact us for feed and speed recommendations. These blades should only be operated on specific CNC saws, and are not intended for use on standard low RPM cold saws ([see our M-2 HSS cold saw blades](#)).

### **Cermet Tipped**

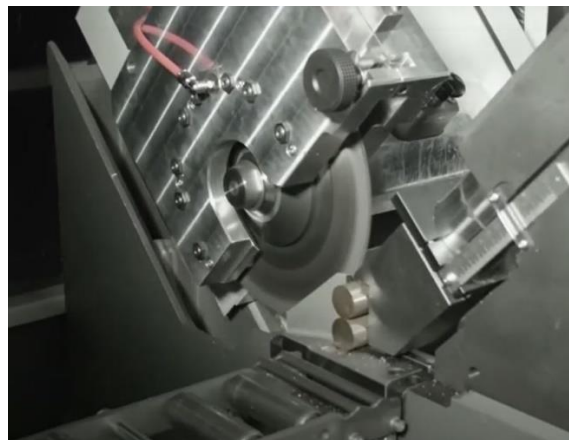
- Carbon steel, alloy steel
- Best for mild solid bar stock, pipe and tube under certain conditions
- Carbon content less than .45%

### **Coated Carbide Tipped**

- Stainless steel, hard alloy with high carbon
- Carbon content greater than .45%
- Reduces heat-wear and distortion

### **Advantages:**

- Three times faster cutting than a band saw or metal saw
- Thin kerf means lower material cost and less disposal
- Lower cost per cut
- Wide variety of tooth counts
- Stiff and extremely flat plates ensure distortion-free accurate cuts
- Increased productivity, less downtime
- Excellent cut quality
- Repeatable performance



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## ***CERMET & CARBIDE-( TCT) METAL CUTTING SAW BLADES***

CERMET AND CARBIDE (TCT) AVAILABLE

Dia.	Kerf	Body	Bore	Teeth
250	2.0	1.70 1.75	32	54
				60
				72
				80
				100
285	2.0	1.70 1.75	32 40	60
				72
				80
				100
				120
315	2.30	2.00	32	54
				60
				72
				80
				100
360	2.6	2.25 2.30	40 50	60
				72
				80
				100
				120
420 425	2.7	2.25 2.30	40 50	50
				60
				72
				80
				100
				120

Dia.	Kerf	Body	Bore	Teeth
460	2.7	2.25 2.30	40 50	40
				50
				60
				72
				80
560	3.0	2.50	50	100
				120
				100
				60
				80
580	3.2	2.70	80	60
				80
				100
				60
				80
630	3.2	2.70	80	60
				80
				100
				110
				120
660	3.7	3.00	80	60
				80
				100
				120

STANDARD PINHOLES

Please call for sizes not listed.



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## M-2 HIGH-SPEED STEEL (HSS DMO5)

**Materials Suggested:** Copper, Aluminum, Brass, Plastic, Extrusions, Tubes, Pipe,  
Roll Form, Bar Stock

### TEETH CUT TO REQUEST

**Machine Type Suggested:** Miter, Double Miter, Tube Cut-Off, In-Line Extrusion Saws, Custom Cut-Off Saws

Bright finish M-2 HSS are recommended to run at 8000 Feet Per Minute and a maximum of 10,000 FPM but must be run on the right saw.

PART #	DIA	KERF	ID
H6116	6"	.062"	5/8"
H7116	7"	.062"	5/8"
H803258	8"	.035"	5/8"
H80321	8"	.035"	1"
H811658	8"	.062"	5/8"
H81161	8"	.062"	1"
H8332	8"	.098"	5/8"
H83321	8"	.098"	1"
H90471	9"	.047"	1"
H9116	9"	.062"	5/8"
H9332	9"	.098"	5/8"
H10047	10"	.047"	5/8"
H100471	10"	.047"	1"
H10116	10"	.062"	5/8" *
H101161	10"	.062"	1"
H1020	10"	.078"	5/8"
H100781	10"	.078"	1"
H10332	10"	.098"	5/8" *
H103321	10"	.098"	1"
H1018	10"	.125"	5/8"
H11332	11"	.098"	5/8"
H12116	12"	.062"	5/8"
H121161	12"	.062"	1"
H12332	12"	.098"	5/8"
H123321	12"	.098"	1"
H12181	12"	.125"	1"
H14116	14"	.062"	1"
H143321	14"	.098"	1"
H1418	14"	.125"	1"
H1618	16"	.125"	1"
H1818	18"	.125"	1"
H2018	20"	.134"	1"

Bright finish M-2 blades are sometimes listed in millimeters

**M-2 High Speed Steel (HSS) Saw Blades** are designed for cutting non-ferrous metal and plastic where maximum cutting life between sharpening is required. Ideal for sawing a wide variety of sizes and shapes such as extrusions, tubes, sheets, plates and some bar stock.

M-2 HSS blades are recommended for production saws equipped with power-feed controls, clamping fixtures and ample cutting fluid. Tight manufacturing tolerances ensure precise cuts. Let our experts recommend the proper blade and tooth configuration for your application. Keep HSS saw blades **SHARP** for optimal results.

### WARNING

Bright finish HSS 58-60 Rc saw blades should not run over 10,000 Surface Feet per Minute (SFPM). DO NOT overfeed M-2 HSS saw blades or operate while dull. Operating M-2 HSS too fast, dull, or overfeeding can result in cracked or even broken blades.

HSS blades are furnished with an "A" tooth. Other tooth styles are available on request.

**THICKNESS AND ARBOR HOLE CAN BE MODIFIED**



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## SPECIAL METAL CUTTING SAW BLADES

**Materials Suggested:** ALUMINUM & PLASTIC, SCREEN FRAME\*, EXTRUSIONS, TUBING, PIPE

**Machines Suggested:** PORTABLE MITER SAWS, RADIAL ARM SAWS, TABLE SAWS, HAND HELD SAWS

**TEETH CUT TO REQUEST AT NO CHARGE; THICKNESS AND ARBOR HOLE CAN BE MODIFIED**

PART #	DIAMETER	KERF	ID	STOCK TOOTH COUNTS
S6116	6"	1/16"	5/8"	150, 200
S7116	7"	1/16"	5/8"	150, 200
S8116	8"	1/16"	5/8"	150, 200, 250
S8332	8"	3/32"	5/8"	120, 150, 200
S9116	9"	1/16"	5/8"	150, 200
S9332	9"	3/32"	5/8"	150
S10116	10"	1/16"	5/8"	120, 150, <b>200*</b> , <b>250*</b> , 300
S10332	10"	3/32"	5/8"	120, 150, 200, 250, 300
S1018	10"	1/8"	5/8"	180, 200
S12116	12"	1/16"	1"	<b>200*</b> , <b>250*</b> , 300
S12332	12"	3/32"	1"	120, 150, 200, 250
S123321	12"	3/32"	1"	120, 150, 200, 250, 300
S14332	14"	3/32"	1"	200, 250, 300
S1418	14"	1/8"	1"	150, 200, 250, 300
S1618	16"	1/8"	1"	150, 200, 250, 300
S1818	18"	1/8"	1"	300
S18532	18"	5/32"	1"	
S20532	20"	5/32"	1"	300, 400
S20316	20"	3/16"	1"	300

SMC blades are furnished with an A tooth. Other tooth shapes are available upon request.



\*Indicates **SCREENPRO** line. 200 teeth are recommended for slider door frame, and 250 teeth are recommended for window screen frame.

### ALUMINUM

Special Metal Cutting (SMC) is a semi-high-speed saw blade that is recommended for cutting aluminum or plastic extrusions, profiles, tubes, etc. SMC saw blades work excellent for cutting screen frame material. SMC blades are stocked with standard tooth counts, but can be toothed to request at no additional charge. The SMC blade has a lower Rockwell (Rc) hardness compared to M-2 High Speed Steel Blades, which makes SMC ideal for high RPM saws such as portable miter, table and radial arm saws. SMC blades can operate at speeds of up to 16,000 SFPM where M-2 HSS should not be used over 10,000 SFPM. SMC blades can withstand severe strains and rougher treatment compared to M-2 HSS which can crack or even break when used improperly. If blade cracking or breaking is a problem, the SMC blade is the answer. It is always recommended that some form of lubrication be used when sawing aluminum. Keep SMC blades **SHARP** for optimal results.

### PLASTIC

Special Metal Cutting blades are an excellent choice for cutting plastics such as thin extrusions, vinyl siding, PVC, Acrylics, Plexiglas, rigid foam, etc. SMC blades are hollow ground and come with finer tooth counts which can make them more effective than carbide tipped blades for achieving smoother finish cuts.

## CIRCULAR KNIVES/HOSE CUT-OFF BLADES

Circular Knives are used in wide variety of applications for their ability to slice through products. Circular knives are offered in: M-2, D-2, STAINLESS, SAW ALLOY (A-2 comparable) and SOLID CARBIDE. Custom made from 1" OD to 36"+OD. Our knives are precision ground and inspected for accuracy.

**Materials Suggested:** - HOSE CUT-OFF – FOOD PROCESSING – CONVERTING FILTERS – TEXTILES –  
- INSULATION - PAPER – TISSUE ROLLS - SLITTERS - CORE CUTTERS

**Standard Bevels:** DOUBLE SMOOTH BEVEL, SINGLE SIDED BEVEL, SCALLOPED EDGE  
**Bevels on Request:** COMPOUND SINGLE/DOUBLE, NOTCHES, TOOTHED, MICRO-SLOTTED

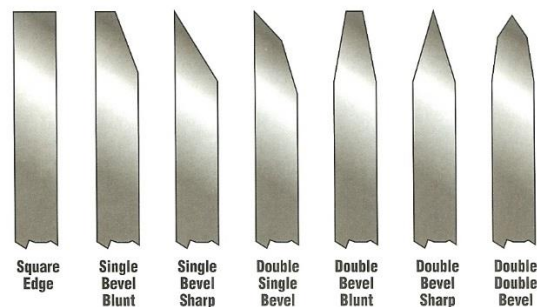
### HOSE CUT-OFF BLADES -

**Hose Cut-Off Blades are designed to cut rubber hose fast and clean.** These circular knife blades are intended for use on hose cut-off machines that are specially designed for cutting rubber hose. Hose cut-off blades are available with a smooth edge, toothed scallop, slotted and a scalloped edge. Custom bevels are ground to request. Sharpening is completed to the same standard as new blades.

Standard sizes are available for cutting single & double-wire braid and 4 or 6 spiral wire-reinforced hose 3/16" to 2" ID.

- Smooth Double Bevel blades are designed to cut single wire braid hose.
- Scalloped edged blades are designed to cut single wire braid, multi-wire braid and 4 or 6 wire-reinforced hose.
- Smooth Bevel, Scalloped and Micro-Slotted can be re-sharpened many times.
- Blades are made from M-2 HSS and CrV Steel.

PART #	DIA	KERF	ID
KN63	6"	.093"	5/8"
KN73	7"	.093"	5/8"
KN73SC	7"	.093"	5/8"
KN83	8"	.093"	5/8"
KN83SC	8"	.093"	5/8"
KN1033	10"	.093"	3/4"
KN1033SC	10"	.093"	3/4"
KN1035	10"	.093"	5/8"
KN1035SC	10"	.093"	5/8"
KN1033240	10"	.093"	40mm
KN1018	10"	.125"	5/8"
KN1018-1	10"	.125"	1"
KN1218	12"	.125"	1"
KN1218SC	12"	.125"	1"
KN1418	14"	.125"	1"
KN1418SC	14"	.125"	1"
KN1618	16"	.125"	1"
KN1818	18"	.125"	1"
KN2018	20"	.125"	1"



Wavy Scalloped Edge  
**METRIC SIZES ALSO AVAILABLE 300mm, 400mm, 520mm, 600mm etc.**

**“SC” on the end of the part number indicates Wavy Scalloped Edge**

## FRICION SAW BLADES

**Materials Suggested:** HOLLOW METAL DOORS, MILD STEEL UNDER .157" WALL, ANGLE

**Machine Types Suggested:** Radial Arm Saws, Miter Saws, "Chop" Saws

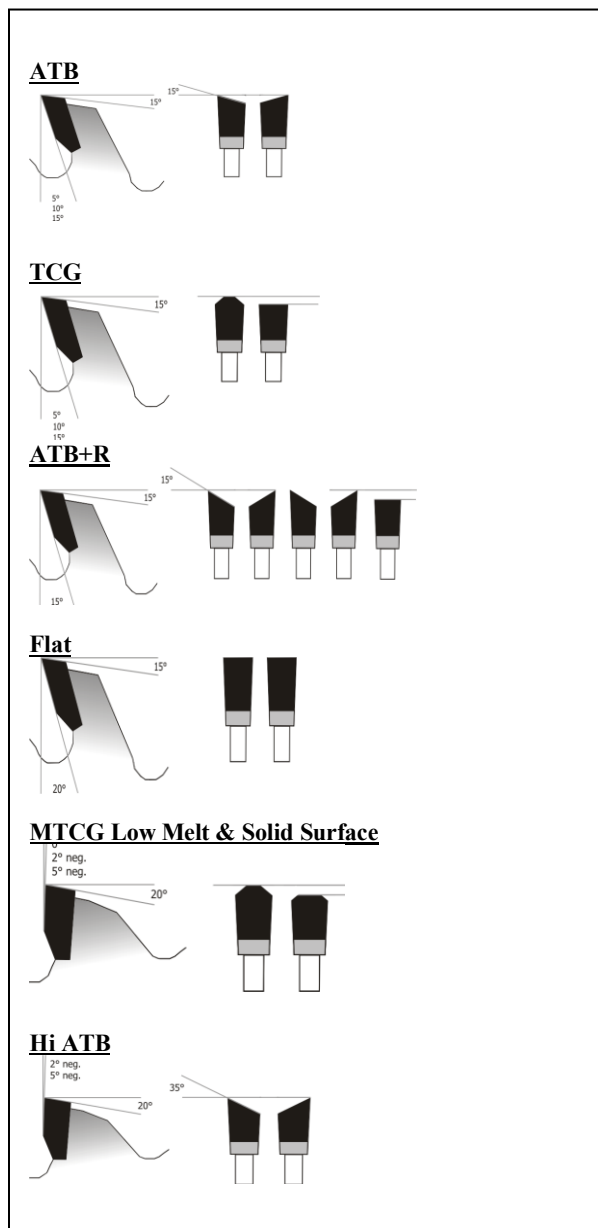
Part #	Dia.	Thickness	Std. Teeth	Arbor Hole
<b>S10332</b>	10"	3/32"	250/300	5/8"
<b>S1218</b>	12"	1/8"	250/300	1"
<b>F1418-250</b>	14"	1/8"	250	1"
<b>F1418-300</b>	14"	1/8"	300	1"
<b>F1618-250</b>	16"	1/8"	250	1"
<b>F1618-300</b>	16"	1/8"	300	1"
<b>F18532-350</b>	18"	5/32"	350	1"
<b>F20532-300</b>	20"	5/32"	300	1"
<b>F20532-400</b>	20"	5/32"	400	1"
<b>F20316-300</b>	20"	3/16"	300	1"
<b>Metric (mm)</b>				
	Dia.	Thickness	Teeth	ID
<b>F300200</b>	300	2.5/3.0	200	30/40
<b>F350-TBD</b>	350	2.5/3.0	200/220	30/40
<b>F400-TBD</b>	400	2.5/3.0/4.0	240/300	40
<b>F450-TBD</b>	450	3.0	240/300	40
<b>F500300-40</b>	500	4.0	300	40
<b>F520300-40</b>	520	4.0	300	40
<b>F550300-40</b>	550	4.0	300	40
<b>F560300</b>	560	3.0/4.0	300	40
<b>F580300</b>	580	4.0/5.0/6.0	300	40
<b>F600300</b>	600	4.0/5.0/6.0	300	40/50
<b>F650300</b>	650	4.0/5.0/6.0	300	40/50
<b>F700300</b>	700	4.0/5.0/6.0/7.0	300	40/50
<b>F750</b>	750	5.0/6.0/7.0	300/350/400	40/50
<b>F850</b>	850	6.0/7.0/8.0	320/350/380	40/50
<b>F900</b>	900	7	320/350/400	50/80/100
<b>F1000</b>	1000	7.0/7.5/8.0/10.0	320/400/450	50/80/100

Friction Saws are designed for cutting thin sections of mild steel. Sawing of ferrous metal with this type of blade is done by friction which requires a fine tooth blade, operated at high arbor speed, for use on heavy-duty saws equipped with a minimum 5 H.P. motor and clamping fixtures. Since friction blades actually burn through the stock, removing globules of metal rather than chips; some burring of the material may result. However, friction saws are superior to abrasive wheels where finish and cutting life are important. To avoid damaged blades and excessive burring, it is recommended that friction saw blades be changed frequently for sharpening. Friction saw blades are always inspected for flatness, tension, balance and cracks, on both new blades and when sharpened. Custom sizes are made to request. *Due to the abusive nature of steel sawing applications, we cannot guarantee our friction saws against cracking.*

## CARBIDE TIPPED SAW BLADES

- Laser-cut saw plate made from saw alloy steel, hardened and flattened to tight tolerances
- Superior grade Tungsten Carbide tips specifically suited for your application including sub micron grain C-4 when appropriate for extended edge life. Large carbide tips mean more sharpenings per blade.
- Robotic CNC controlled brazing and grinding machinery produce consistent and precise tolerances.
- Thousands of blades in stock as well as **custom-made blades**.
- Quality blades mean greater productivity without downtime.

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# The BLADE MFG. CO.

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## NON-FERROUS METAL CUTTING

**Materials Suggested:** Aluminum, Brass, Copper and other non-ferrous metal extrusions, sheets and bar stock. These blades also perform well on medium-to-hard Plastic, MDF, Single-Sided Laminates, and Particle Board

*\*Carbide Tipped blades are recommended for wall thicknesses greater than .090". For thin wall extrusions and profiles we recommend High Speed Steel HSS blades with fine tooth pitches.*

**Machine Types Suggested:** Miter Saw, Double Miter Saw, Radial Arm Saw, Table Saw, Up-Cut Saws

Non-Ferrous blades are furnished with a TCG or LRTCG grind and positive 5 to negative 5 degrees of hook, depending on the application. Heavier plates help support the rigors of cutting non-ferrous metals. Always use mechanical clamping and lubricant spray when cutting non-ferrous metal. As a general rule, use more teeth for thin material and fewer teeth for thicker material. Contact our technical sales team to assist in choosing the correct blade for your job.

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
AS378203	3-7/8"	20	5	TC2	3/8"	.110"	.135"
AS378245	3-7/8"	24	5	TC2	5/8"	.110"	.135"
AS412T	4"	12	5	TCG	3/4"	.085"	.125"
AS420T	4"	20	5	TCG	3/4"	.075"	.105"
AS4207T	4"	20	0	TC2	7/8"	.095"	.150"
AS424T	4"	24	0	TCG	3/4"	.075"	.105"
AS4247T	4"	24	-2	TC2	7/8"	.085"	.110"
NF74N	7"	40	-5	TCG	5/8"	.085"	.115"
NF71424	7-1/4"	24	0	TCG	5/8" K	.070"	.095"
NF71440	7-1/4"	40	0	TCG	5/8" K	.070"	.110"
NF71460	7-1/4"	60	0	TCG	5/8" K	.070"	.095"
NF840	8"	40	5	TCG	5/8" K	.070"	.095"
NF860C	8"	60	0	TCG	5/8" K	.070"	.095"
NF860	8"	60	0	TCG	5/8"	.085"	.115"
NF86N	8"	60	-5	TCG	5/8"	.085"	.115"
NF88N	8"	80	-2	TCG	5/8"	.085"	.115"
P860T	8-1/4"	60	0	TCG	5/8"	.070"	.095"
P826T	8-1/2"	60	0	TCG	5/8"	.070"	.095"
P86NT	8-1/2"	60	-5	TCG	5/8"	.059"	.090"
NF960	9"	60	0	TCG	5/8"	.085"	.115"
NF1040	10"	40	0	TCG	5/8"	.085"	.115"
P1060T	10"	60	0	TCG	5/8"	.059"	.090"
NF1060	10"	60	0	TCG	5/8"	.085"	.125"
NF106N	10"	60	-5	TCG	5/8"	.085"	.125"
P1080T	10"	80	0	TCG	5/8"	.059"	.090"
P108NT	10"	80	-5	TCG	5/8"	.059"	.090"
NF1080	10"	80	0	TCG	5/8"	.085"	.125"
NF108N	10"	80	-5	TCG	5/8"	.085"	.125"
MN1090	10"	90	-5	LRTC	5/8"	.095"	.125"
P1010T	10"	100	0	TCG	5/8"	.059"	.090"
NF1010	10"	100	0	TCG	5/8"	.095"	.125"

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## *NON-FERROUS METAL CUTTING*

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
NF101N	10"	100	-5	TCG	5/8"	.095"	.125"
NF1020	10"	120	-2	TCG	5/8"	.085"	.115"
P126NT	12"	60	-5	TCG	1"	.085"	.115"
NF1260	12"	60	0	TCG	1"	.095"	.125"
P1272T	12"	72	0	TCG	1"	.085"	.115"
P1280T	12"	80	0	TCG	1"	.059"	.090"
DM1280T	12"	80	0	TCG	5/8"	.095"	.125"
NF1280	12"	80	0	TCG	1"	.095"	.125"
NF128N	12"	80	-5	TCG	1"	.095"	.125"
MN1290	12"	90	-5	LRTC	1"	.110"	.135"
P1210T	12"	100	0	TCG	1"	.059"	.090"
DM1210T	12"	100	0	TCG	5/8"	.095"	.125"
NF1210	12"	100	0	TCG	1"	.095"	.125"
NF121N	12"	100	-5	TCG	1"	.095"	.125"
DM1210M	12"	102	0	LRTC	5/8"	.100"	.125"
DM122N	12"	120	-2	TCG	5/8"	.100"	.125"
NF122N	12"	120	-2	TCG	1"	.095"	.125"
MN1212	12"	120	-2	LRTC	1"	.095"	.125"
NF1440	14"	40	0	TCG	1"	.110"	.160"
NF1460	14"	60	0	TCG	1"	.120"	.150"
P1480T	14"	80	0	TCG	1"	.070"	.102"
P148NT	14"	80	-5	TCG	1"	.085"	.120"
NF1480-30	14"	80	0	TCG	30mm	.098"	.138"
NF1480-138	14"	80	0	TCG	1"	.098"	.138"
NF1480	14"	80	0	TCG	1"	.120"	.150"
NF148N	14"	80	-5	TCG	1"	.120"	.150"
P1410T	14"	100	0	TCG	1"	.070"	.102"
P141NT	14"	100	-5	TCG	1"	.085"	.120"
NF1410-138	14"	100	0	TCG	1"	.098"	.138"
NF1410	14"	100	0	TCG	1"	.120"	.150"
NF141N-138	14"	100	-5	TCG	1"	.098"	.138"
NF141N	14"	100	-5	TCG	1"	.120"	.150"
DM142N	14"	120	-5	TCG	5/8"	.110"	.140"
NF1412	14"	120	0	TCG	1"	.110"	.150"
NF142N	14"	120	-5	TCG	1"	.110"	.140"
MN1412	14"	120	-5	LRTC	1"	.134"	.165"
NF1580	15"	80	0	TCG	1"	.120"	.160"
P151NT	15"	100	-5	TCG	1"	.095"	.125"
NF1510	15"	100	0	TCG	1"	.110"	.150"
NF1512	15"	120	0	TCG	5/8"	.110"	.150"
NF1660	16"	60	0	TCG	1"	.120"	.165"
NF1660-205	16"	60	0	TCG	1"	.150"	.205"
NF166N	16"	60	-5	TCG	1"	.134"	.173"
NF1680	16"	80	0	TCG	1"	.120"	.150"
NF1680-200	16"	80	0	TCG	1"	.150"	.200"
NF168N	16"	80	-5	TCG	1"	.134"	.174"
NF1610	16"	100	0	TCG	1"	.120"	.150"

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## NON-FERROUS METAL CUTTING

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF	
NF161N	16"	100	-5	TCG	1"	.134"	.174"	
NF1620	16"	120	0	TCG	1"	.120"	.150"	
NF162N	16"	120	-5	TCG	1"	.120"	.150"	
NF1630	16"	130	-5	TCG	30mm	.115"	.145"	
NF1836	18"	36	0	TCG	1"	.150"	.205"	
NF1860	18"	60	0	TCG	1"	.150"	.200"	
NF1872	18"	72	0	TCG	1-1/2"	.142"	.176"	ms
NF1880	18"	80	0	TCG	1"	.134"	.174"	
NF188N	18"	80	-5	TCG	1"	.150"	.200"	
NF1810	18"	100	0	TCG	1"	.134"	.174"	
NF1812	18"	120	0	TCG	1"	.134"	.174"	
NF182N	18"	120	-5	TCG	1"	.134"	.174"	
NF1840	18"	140	-5	TCG	1"	.115"	.145"	
NF1840-30	18"	140	-5	TCG	30mm	.115"	.145"	
NF2060	20"	60	5	TCG	1"	.134"	.184"	
NF2080	20"	80	0	TCG	1"	.145"	.195"	
NF2010	20"	100	0	TCG	1"	.134"	.174"	
NF201N	20"	100	-5	TCG	1"	.134"	.174"	
NF2020	20"	120	0	TCG	1"	.134"	.174"	
NF202N	20"	120	-5	TCG	1"	.134"	.174"	
NF2014	20"	140	-5	TCG	1"	.134"	.174"	
NF2015	20"	150	-5	TCG	1"	.134"	.164"	
NF2260	22"	60	5	TCG	1-1/2"	.150"	.180"	ms
NF2210	22"	100	-5	TCG	1"	.150"	.180"	
NF2212	22"	120	-5	TCG	1"	.150"	.180"	
NF2215	22"	150	-5	TCG	1"	.150"	.200"	
NF2460	24"	60	5	TCG	1-1/2"	.165"	.205"	ms
NF2472	24"	72	5	TCG	1"	.165"	.205"	
NF2472M	24"	72	5	TCG	1-1/2"	.165"	.205"	ms
NF2480	24"	80	-5	TCG	1"	.165"	.205"	
NF2410	24"	100	-5	TCG	1"	.165"	.205"	
NF2412	24"	120	-5	TCG	1"	.165"	.205"	
NF2415	24"	150	-5	TCG	1"	.150"	.210"	
NF2416	24"	160	-5	TCG	1"	.150"	.210"	
NF2416-30	24"	160	-5	TCG	30mm	.150"	.210"	

ms-Indicates blades made for Metalsaw plate saws

### METRIC SIZES

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
DM275-80T	275	80	5	TCG	32mm	2.5	3.2
NF28090-32	280	90	5	TCG	32mm	2.4	3.2
NF30072-32	300	72	0	TCG	32mm	2.2	2.9
NF30080-40	300	80	0	TCG	40mm	2.5	3.2

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## NON-FERROUS METAL CUTTING

### METRIC SIZES

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
NF33090	330	90	5	TCG	32mm	2.8	3.7
NF35060-32	350	60	0	TCG	32mm	2.8	3.8
NF35080	350	80	0	TCG	30mm	2.5	3.5
NF35084-32	350	84	-5	TCG	32mm	2.4	3.2
NF35084-40	350	84	-5	TCG	40mm	2.5	3.4
NF350100-32	350	100	-5	TCG	32mm	2.5	3.5
NF350100-40	350	100	-5	TCG	40mm	2.8	3.8
NF350108-40	350	108	-5	TCG	40mm	2.8	3.6
NF350120	350	120	0	TCG	1"	.110"	.140"
NF350120-32	350	120	-5	TCG	32mm	2.4	3.2
NF350120-40	350	120	-5	TCG	40mm	2.4	3.2
NF38011	380	110	-5	TCG	32mm	3.0	3.8
NF40040	400	40	5	TCG	50mm	2.5	3.5
NF40060	400	60	5	TCG	50mm	2.5	3.5
NF40096-30	400	96	0	TCG	30mm	3.2	3.8
NF40096-32	400	96	0	TCG	32mm	3.0	4.0
NF40096-50	400	96	0	TCG	50mm	2.8	3.8
NF400120-32	400	120	0	TCG	32mm	3.0	4.0
NF42096	420	96	0	TCG	30mm	3.2	4.4
NF45010-50	450	100	5	TCG	50mm	3.4	4.4
NF450108-32	450	108	5	TCG	32mm	3.0	4.0
NF420120-30	420	120	0	TCG	30mm	3.4	4.4
NF420120-32	420	120	0	TCG	32mm	3.4	4.4
NF500120-30	500	120	0	TCG	30mm	3.4	4.4
NF500120-30	500	120	0	TCG	30mm	3.4	4.4
NF550120-30	550	120	-5	TCG	30mm	3.8	5.0

40mm bore blades have pinhole pattern: 4/12/64 & 2/8/55

50mm bore blades have pinhole pattern: 4/15/80

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## ***PORTABLE AIR SAWS***

Air saw blades are intended for use on pneumatic air saws such as Dotco ® and Aro ® and are recommended for sawing aluminum, plastics, wood etc. Custom made blades are common due to the various applications associated with air sawing. Not intended to cut steel.

### **PORTABLE AIR SAW BLADES**

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
AS378203	3-7/8"	20	5	TC2	3/8"	.110"	.135"
AS378245	3-7/8"	24	5	TC2	5/8"	.110"	.135"
AS412T	4"	12	5	TCG	3/4"	.085"	.125"
AS420T	4"	20	5	TCG	3/4"	.075"	.105"
AS4207T	4"	20	0	TC2	7/8"	.095"	.150"
AS424T	4"	24	0	TCG	3/4"	.075"	.105"
AS4247T	4"	24	-2	TC2	7/8"	.085"	.110"

## ***CARBIDE TIPPED PORTABLE STEEL DRY CUT***

**Materials Suggested:** Mild Steel, Steel Studs, Profiles, Tubes, Insulating Boards with metal outsides

**Machine Types Suggested:** Low RPM "Dry Cut" Saws, Dewalt®, Porter Cable®, Milwaukee®, etc.

Portable "Dry Cut" steel blades feature carbide tips specifically designed for ferrous metal cutting. Special tooth geometry enables these blades to produce clean, fast cuts in mild steel. Intended for use on low rpm machines only; do not use on woodworking saws.

PART#	DIA	TOOTH	PLATE	KERF	BORE	Max RPM
DC748-20	7"	48	.059"	.075"	20mm	5800
DC736	7-1/4"	36	.063"	.079"	5/8" DK	5800
DC736-20	7-1/4"	36	.063"	.079"	20MM	5800
DC748	7 1/4"	48	.063"	.079"	5/8" KO	5800
DC850	8"	50	.047"	.063"	5/8"	3000
DC948	9"	48	.063"	.080"	1"	2700
DC1050	10"	50	.071"	.094"	5/8"	2800
DC1052E	10"	52	.063"	.079"	5/8"	2800
DC1260	12"	60	.079"	.094"	1"	1800
DC1260E	12"	60	.071"	.087"	1"	1800
DC1276	12"	76	.063"	.080"	1"	1800
DC1280-SS	12"	80	.079"	.087"	1"	1800
DC1472	14"	72	.079"	.094"	1"	1700
DC1472E	14"	72	.075"	.095"	1"	1700
DC1490	14"	90	.079"	.094"	1"	1700
DC1490E	14"	90	.075"	.095"	1"	1700
DC1410-SS	14"	100	.079"	.106"	1"	1700

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## GENERAL PURPOSE CUT-OFF

**Materials Suggested:** Hardwood, Softwood, Plywood, MDF, Particleboard, Single-Sided Laminates,

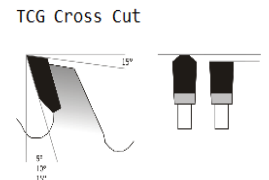
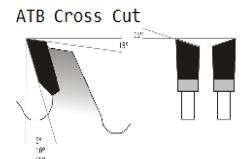
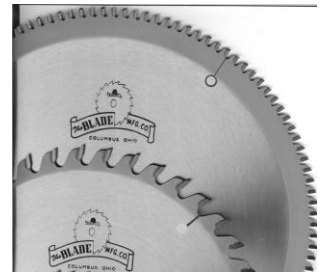
**Machine Types Suggested:** Radial Arm Saw, Miter Saw, Table Saw, Straight Line Rip, Up-Cut saw etc...

Use ATB grind for most hardwoods and TCG for thick hardwood, plywood, particleboard, chipboard and other abrasive materials. **EX** indicates sub-micron grade C-4 carbide tips for corrosion and wear-resistance when sawing abrasive or corrosive material.

The ATB will wear faster than TCG grind, but will provide a nice clean cut when sawing thin or delicate material. As a general rule, use more teeth for thin material and fewer teeth for thicker material.

## ATB GRIND

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
CN71424A	7-1/4"	24	15	ATB	5/8"	.085"	.125"
CN71440A	7-1/4"	40	10	ATB	5/8"	.085"	.125"
CN71460A	7-1/4"	60	0	ATB	5/8KO	.070"	.095"
CN840A	8"	40	10	ATB	5/8"	.085"	.125"
CN860A	8"	60	10	ATB	5/8"	.085"	.125"
CN940A	9"	40	10	ATB	5/8"	.085"	.125"
CN960A	9"	60	5	ATB	5/8"	.085"	.125"
CN1040A	10"	40	10	ATB	5/8"	.085"	.125"
CN1060A	10"	60	10	ATB	5/8"	.085"	.125"
CN1080A	10"	80	5	ATB	5/8"	.085"	.125"
CN1010A	10"	100	0&5	ATB	5/8"	.085"	.125"
CN1240A	12"	40	10	ATB	1"	.095"	.135"
CN1248A	12"	48	10	ATB	1"	.095"	.135"
CN1260A	12"	60	10	ATB	1"	.095"	.135"
CN1280A	12"	80	10	ATB	1"	.095"	.135"
CN1210A	12"	100	5	ATB	1"	.095"	.125"
CN1212A	12"	120	5	ATB	1"	.083"	.118"
CN1448A	14"	48	10	ATB	1"	.098"	.138"
CN1460A-138	14"	60	10	ATB	1"	.098"	.135"
CN1460A	14"	60	10	ATB	1"	.110"	.160"
CN1472A	14"	72	10	ATB	1"	.118"	.173"
CN1480A-138	14"	80	10	ATB	1"	.098"	.138"
CN1480A	14"	80	10	ATB	1"	.120"	.176"
CN1410A-138	14"	100	10	ATB	1"	.098"	.138"
CN1410A	14"	100	5	ATB	1"	.110"	.156"
CN1412A	14"	120	0	ATB	1"	.110"	.150"
CN1560A	15"	60	5	ATB	1"	.110"	.160"
CN1580A	15"	80	5	ATB	1"	.110"	.160"
CN1510A	15"	100	5	ATB	1"	.110"	.160"
CN1640A	16"	40	10	ATB	1"	.120"	.165"
CN1660A-165	16"	60	10	ATB	1"	.120"	.165"
CN1660A	16"	60	10	ATB	1"	.134"	.184"
CN1680A-165	16"	80	10	ATB	1"	.120"	.165"



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## GENERAL PURPOSE CUT-OFF

### ATB GRIND

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
CN1680A	16"	80	10	ATB	1"	.134"	.184"
CN1610A	16"	100	5	ATB	1"	.120"	.165"
CN1612A	16"	120	-5	ATB	1"	.120"	.155"
CN1848A	18"	48	10	ATB	1"	.134"	.184"
CN1860A	18"	60	10	ATB	1"	.134"	.184"
CN1880A	18"	80	5&10	ATB	1"	.134"	.184"
CN1810A	18"	100	5	ATB	1"	.134"	.177"
CN1812A	18"	120	5&-5	ATB	1"	.134"	.177"
CN2060A	20"	60	5	ATB	1"	.134"	.184"
CN2080A	20"	80	10	ATB	1"	.134"	.184"
CN2080A-2	20"	80	10	ATB	1"	.150"	.200"
CN2010A	20"	100	5	ATB	1"	.134"	.177"
CN2012A	20"	120	5	ATB	1"	.134"	.177"
CN2260A	22"	60	15	ATB	1"	.150"	.200"
CN2280A	22"	80	10	ATB	1"	.150"	.210"
CN2210A	22"	100	10	ATB	1"	.150"	.200"
CN2460A	24"	60	15	ATB	1"	.150"	.200"
CN2410A	24"	100	10	ATB	1"	.150"	.200"
CN2610A	26"	100	5	ATB	1"	.165"	.200"

### TCG GRIND thick hardwood, plywood, particleboard, chipboard and other abrasive materials

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
CN71440T	7-1/4"	40	10	TCG	5/8"	.085"	.125"
CN71460T	7-1/4"	60	10	TCG	5/8"	.079"	.110"
CN840T	8"	40	10	TCG	5/8"	.085"	.125"
CN860T	8"	60	10	TCG	5/8"	.085"	.125"
CN940T	9"	40	10	TCG	5/8"	.085"	.125"
CN1040T	10"	40	10	TCG	5/8"	.085"	.125"
CN1060T	10"	60	10	TCG	5/8"	.085"	.125"
CN1080T	10"	80	5	TCG	5/8"	.085"	.125"
CN1010T	10"	100	5	TCG	5/8"	.085"	.125"
CN1240T	12"	40	10	TCG	1"	.095"	.135"
CN1260T	12"	60	10	TCG	1"	.095"	.135"
CN1280T	12"	80	10	TCG	1"	.095"	.135"
CN1280T-30	12"	80	10	TCG	30mm	.095"	.135"
CN1210T	12"	100	5	TCG	1"	.095"	.125"
CN1440T	14"	40	10	TCG	1"	.110"	.160"
CN1460T-138	14"	60	10	TCG	1"	.098"	.135"
CN1460T	14"	60	10	TCG	1"	.110"	.160"
CN1472T	14"	72	10	TCG	1"	.118"	.173"
CN1480T-138	14"	80	10	TCG	1"	.098"	.138"
CN1480T	14"	80	10	TCG	1"	.120"	.165"

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## GENERAL PURPOSE CUT-OFF

**TCG GRIND** thick hardwood, plywood, particleboard, chipboard and other abrasive materials

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
CN1410T-138	14"	100	10	TCG	1"	.098"	.138"
CN1410T	14"	100	5	TCG	1"	.110"	.156"
CN1412T	14"	120	0	TCG	1"	.110"	.150"
CN1510T	15"	100	10	TCG	1"	.110"	.160"
CN1640T	16"	40	10	TCG	1"	.120"	.165"
CN1660T	16"	60	10	TCG	1"	.120"	.165"
CN1680T	16"	80	10	TCG	1"	.120"	.165"
CN1610T	16"	100	5	TCG	1"	.120"	.165"
CN1612T	16"	120	5	TCG	1"	.120"	.150"
CN1860T	18"	60	5	TCG	1"	.134"	.184"
CN1880T	18"	80	10	TCG	1"	.134"	.184"
CN1810T	18"	100	5	TCG	1"	.134"	.177"
CN1812T	18"	120	0	TCG	1"	.134"	.177"
CN2060T	20"	60	5	TCG	1"	.134"	.184"
CN2080T	20"	80	0	TCG	1"	.134"	.184"
CN2010T	20"	100	5	TCG	1"	.134"	.177"
CN2012T	20"	120	10	TCG	1"	.134"	.177"
CN2260T	22"	60	15	TCG	1"	.150"	.200"
CN2280T	22"	80	10	TCG	1"	.150"	.210"
CN2210T	22"	100	10	TCG	1"	.150"	.200"
CN2460T	24"	60	15	TCG	1"	.150"	.200"
CN2410T	24"	100	10	TCG	1"	.150"	.200"
CN2610T	26"	100	5	TCG	1"	.165"	.200"

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## MITER & DOUBLE MITER

**Materials Suggested:** Aluminum, Plastic, Hardwood, Softwood, Plywood, MDF, Particleboard, Single-Sided Laminates, Picture Frames, Windows, Doors, Screen frame

**Machine Types Suggested:** Single Miter Saw, Double Miter Saw, Radial Arm Saw, “Chop Saw”

Miter saw blades are furnished with a neutral hook angle to prevent the blade from grabbing the material and provide a smooth finish when angle cut finish is critical. Use more teeth for thin material in order to maintain cut quality.

The “DM” blade is designed for production miter saws such as Pistorius, CTD, Wegoma, Hoffman, Ritter, etc.

The “PM” blade is designed for portable miter/chop saws such as Dewalt , Delta, Hitachi, Ryobi, Makita, Milwaukee, etc.

\*Carbide Tipped blades for non ferrous metals are recommended for wall thicknesses greater than .090”. For thin wall extrusions and profiles we recommend High Speed Steel HSS blades with fine tooth pitches.

Production Miter Saw Blades							
ATB+R grind for Wood and Composites							
PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
DM1080A	10"	80	0	ATB +R	5/8"	.098"	.116"
DM1280A	12"	80	0	ATB +R	5/8"	.098"	.125"
DM1210A	12"	100	0	ATB +R	5/8"	.098"	.120"
DM1210A-134	12"	100	-2	ATB +R	5/8"	.118"	.134"
DM1210A-1	12"	100	-2	ATB +R	1"	.118"	.134"
DM1210A	12"	100	0	ATB +R	5/8"	.098"	.120"
DM1410A	14"	100	0	ATB +R	5/8"	.110"	.128"
METRIC SIZES							
DM275-80A	275mm	80	5	ATB +R	32mm	2.5	3.2
DM275	275mm	100	0	ATB +R	32mm	2.5	3.2
DM3510A	350mm	100	0	ATB +R	30mm	3.2	4.1
TCG grind for Non Ferrous Metal and Plastic							
PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
NF1080	10"	80	0	TCG	5/8"	.085"	.125"
NF1010	10"	100	0	TCG	5/8"	.095"	.125"
NF1020	10"	120	-2	TCG	5/8"	.085"	.115"
DM1280T	12"	80	0	TCG	5/8"	.095"	.125"
DM1210T	12"	100	0	TCG	5/8"	.095"	.125"
DM1210LRT	12"	102	0	LRTC	5/8"	.100"	.125"
DM122N	12"	120	-2	TCG	5/8"	.100"	.125"
DM142N	14"	120	-5	TCG	5/8"	.110"	.140"

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## PORTABLE MITER BLADES for Wood and Thin Plastic

*ATB grind is not suitable for non ferrous metals.*

PART #	DIA	TEETH	HOOK	GRIND	BORE	PLATE	KERF
PM836A	8. 1/2"	36	0	ATB	5/8"	.070"	.095"
PM86NA	8. 1/2"	60	-5	ATB	5/8"	.070"	.095"
PM860A	8. 1/2"	60	0	ATB	5/8"	.059"	.080"
PM1060A	10"	60	0	ATB	5/8"	.059"	.080"
PM1080A	10"	80	0	ATB	5/8"	.059"	.080"
PM108NA	10"	80	-5	ATB	5/8"	.085"	.120"
PM124NA	12"	40	-5	ATB	1"	.085"	.115"
PM126NA	12"	60	-5	ATB	1"	.085"	.115"
PM1280A	12"	80	0	ATB	1"	.059"	.090"
PM128NA	12"	80	-5	ATB	1"	.085"	.115"
PM128NAR	12"	80	-5	ATB+R	1"	.080"	.110"
PM148NA	14"	80	-5	ATB	1"	.085"	.120"
PM141NA	14"	100	-5	ATB	1"	.085"	.120"
PM1560A	15"	60	0	ATB	1"	.070"	.110"
PM1580A	15"	80	0	ATB	1"	.070"	.110"
PM1510A	15"	100	0	ATB	1"	.095"	.125"

## PORTABLE MITER BLADES for Non Ferrous Metal and Plastic

PART #	DIA	TEETH	HOOK	GRIND	BORE	PLATE	KERF
P860T	8-1/4"	60	0	TCG	5/8"	.070"	.095"
P826T	8-1/2"	60	0	TCG	5/8"	.070"	.095"
P86NT	8-1/2"	60	-5	TCG	5/8"	.059"	.090"
P1060T	10"	60	0	TCG	5/8"	.059"	.090"
P1080T	10"	80	0	TCG	5/8"	.059"	.090"
P108NT	10"	80	-5	TCG	5/8"	.059"	.090"
P1010T	10"	100	0	TCG	5/8"	.059"	.090"
P126NT	12"	60	-5	TCG	1"	.085"	.115"
P1272T	12"	72	0	TCG	1"	.085"	.115"
P1280T	12"	80	0	TCG	1"	.059"	.090"
P1210T	12"	100	0	TCG	1"	.059"	.090"
P1480T	14"	80	0	TCG	1"	.070"	.102"
P148NT	14"	80	-5	TCG	1"	.085"	.120"
P1410T	14"	100	0	TCG	1"	.070"	.102"
P141NT	14"	100	-5	TCG	1"	.085"	.120"

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## LAMINATES & VENEER

Cut double sided laminates and veneers chip free without a scoring saw. A negative hook angle plus a "high" alternate top are featured in this design. LXT carbide is used to prolong edge life between sharpenings.

PART #	DIA	TOO TH	GRIND	PLATE	KERF	BORE
LV860	8"	60	HATB -5	.085"	.115"	5/8"
LV220	220mm	64	HATB -5	2.2mm	2.9mm	30mm
LV250	250mm	80	HATB -5	2.2mm	2.9mm	30mm
LV1060	10"	60	HATB -5	.085"	.125"	5/8"
LV1080	10"	80	HATB -5	.085"	.125"	5/8"
LV1210	12"	100	HATB -5	.095"	.125"	1"
LV3096	300mm	96	HATB -5	2.4mm	3.2mm	30mm
LV1410	14"	100	HATB -5	.098"	.138"	1"
LV1610	16"	120	HATB -5	.125"	.150"	1"

Please see panel sizing for additional chip free cutting blades

## SOLID SURFACE

**Materials Suggested:** Corian®, Avonite®, Surell®, Fountainhead®, etc.

**Machine Types Suggested:** Table Saw, Miter Saw, Double Miter Saw, Radial Arm Saw

Solid Surface blades are made with submicron extended life tips which help extend cutting life and provide clean cuts. When ordering please specify the thickness of the material.

### LXT-CORROSION RESISTENT MICRO GRAIN CARBIDE

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF	
LM1040	10"	40	15	TC2	5/8"	.092"	.127"	
LM1072	10"	72	0	TC2	5/8"	.100"	.125"	LXT
LM1080	10"	80	5	TC2	5/8"	.070"	.100"	
LM10100	10"	100	-5	TC2	5/8"	.085"	.115"	
LM1280	12"	80	5	TC2	1"	.085"	.115"	
LM1284	12"	84	0	TC2	1"	.100"	.125"	LXT
LM1210	12"	100	-2	TC2	1"	.095"	.135"	
LM121258	12"	120	-2	TC2	5/8"	.100"	.125"	
LM1212	12"	120	-2	TC2	1"	.095"	.125"	
LM1410	14"	100	0	TC2	1"	.098"	.138"	
LM142N	14"	120	-5	TCG	5/8"	.110"	.140"	
LM1412	14"	120	-5	TC2	1"	.110"	.140"	
LM1610	16"	100	-5	TC2	1"	.120"	.150"	LXT
LM1612	16"	120	-5	TC2	1"	.120"	.150"	
LM3084	300"	84	0	TC2	30mm	2.5	3.2	
LM3096	300"	96	-5	TC2	30mm	2.4	3.2	

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## ***COMBINATION/PLANER SAW BLADES***

**Materials Suggested:** Hardwood, Softwood, Plywood, Particleboard

**Machine Types Suggested:** Table Saw, Radial Arm Saw, Straight Line Rip, Miter Saw

Combination/Planer Saw Blades are designed for ripping or cross-cutting when only operating one saw blade. A great all around blade for general purpose sawing that features a deep gullet in every cutting section which provides chip removal on deep rip cuts.

PART #	DIA	TOOTH	GRIND	PLATE	KERF	BORE
CM850	8"	50	15CMB	.085"	.125"	5/8"
CM1040	10"	40	15CMB	.085"	.125"	5/8"
CM1050	10"	50	15CMB	.095"	.135"	5/8"
CM1250	12"	50	15CMB	.095"	.135"	1"
CM1260	12"	60	15CMB	.095"	.135"	1"
CM1470	14"	70	15CMB	.120"	.165"	1"
CM1680	16"	80	15CMB	.120"	.165"	1"

## ***RADIAL ARM SAWS***

**Materials Suggested:** Hardwood, Softwood, Plywood, MDF, Particleboard, Single-Sided Laminates

**Machine Types Suggested:** Radial Arm Saws, Miter Saws, Chop Saws

Radial Arm saw blades are furnished with a neutral hook angle to keep the blade from grabbing the material. For non ferrous or plastic blades for radial arm saws refer to the non ferrous and plastics pages.

PART #	DIA	TEETH	GRIND	PLATE	KERF	BORE
RA860	8"	60	0ATB	.085"	.120"	5/8"
RA980	9"	80	0ATB	.085"	.120"	5/8"
RA1060	10"	60	0ATB	.085"	.130"	5/8"
RA1080	10"	80	0ATB	.085"	.130"	5/8"
RA1230	12"	30	N5ATB	.085"	.130"	5/8"
RA1260	12"	60	0ATB	.085"	.130"	5/8"
RA1280-5/8	12"	80	0ATB	.095"	.140"	5/8"
RA1280-1	12"	80	0ATB	.095"	.140"	1"
RA1436	14"	36	N5ATB	.085"	.130"	1"
RA1460	14"	60	0ATB	.120"	.160"	1"
RA1480	14"	80	0ATB	.110"	.160"	1"
RA1411	14"	100	0ATB	.098"	.140"	1"
RA1640	16"	40	0ATB	.134"	.180"	1"
RA1660	16"	60	0ATB	.120"	.170"	1"
RA1680	16"	80	0ATB	.120"	.170"	1"
RA1860	18"	60	0ATB	.134"	.180"	1"
RA2060	20"	60	0ATB	.134"	.180"	1"

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## PLASTIC CUTTING

**Materials Suggested:** Acrylic cast and extruded, PVC, Vinyl, Corian®, Lexan®, Polycarbonate, Polypropylene, Polyethylene, Phenolic, Styrene, Foam Board, Engraving Stock, etc...

**Machine Types Suggested:** Table Saw, Panel Saw, Miter Saw, Double Miter Saw, Radial Arm Saw, Up-Cut Saws

Our plastic cutting carbide tipped saw blades are available with various tooth geometries, cutting angles and plate thicknesses, depending on the type of plastic and saw being used. In general, plastics can be considered “hard” or “soft”.

### HARD PLASTICS

When sawing hard plastics, a triple chip grind (TCG) with very hard C-4 carbide tips is recommended.

### LOW-MELT PLASTICS

For softer plastics, a “low-melt” TC2 grind is recommended to keep the friction between the part and the saw teeth to a minimum, which helps prevent low melting-point plastics from overheating and melting during the sawing process.

### THIN PLASTIC

Very thin brittle plastics such as extruded profile parts can be cut smooth with an alternate top bevel grind (ATB). For plastic under .093” wall thickness we recommend a HIGH SPEED STEEL (HSS) or SEMI-HIGH SPEED (SMC) blade.

As a general rule, use more teeth for thin material and fewer teeth for thicker material. Due to the many variables involved in plastic cutting, contact our technical sales to assist in choosing the appropriate blade for your application.

## HARD PLASTIC SHEET and COMPOSITE

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
CN71440T	7-1/4"	40	10	TCG	5/8"	.085"	.125"
CN840T	8"	40	10	TCG	5/8"	.085"	.125"
CN940T	9"	40	10	TCG	5/8"	.085"	.125"
CN1060T	10"	60	10	TCG	5/8"	.085"	.125"
CN1080T	10"	80	5	TCG	5/8"	.085"	.125"
CN1080AF	10"	80	10	AT/AF	5/8"	.059"	.090"
CN1010T	10"	100	5	TCG	5/8"	.085"	.125"
CN1240T	12"	40	10	TCG	1"	.095"	.135"
CN1260T	12"	60	10	TCG	1"	.095"	.135"
CN1280T	12"	80	10	TCG	1"	.095"	.135"
CN1280T-30	12"	80	10	TCG	30mm	.095"	.135"
CN1210T	12"	100	5	TCG	1"	.095"	.125"
CN1440T	14"	40	10	TCG	1"	.110"	.160"
CN1460T-138	14"	60	10	TCG	1"	.098"	.135"
CN1460T	14"	60	10	TCG	1"	.110"	.160"

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## HARD PLASTIC SHEET and COMPOSITE

<b>CN1472T</b>	14"	72	10	TCG	1"	.118"	.173"
<b>CN1480T-138</b>	14"	80	10	TCG	1"	.098"	.138"
<b>CN1480T</b>	14"	80	10	TCG	1"	.120"	.165"
<b>CN1410T-138</b>	14"	100	10	TCG	1"	.098"	.138"
<b>CN1410T</b>	14"	100	5	TCG	1"	.110"	.156"
<b>CN1412T</b>	14"	120	0	TCG	1"	.110"	.150"
<b>CN1510T</b>	15"	100	10	TCG	1"	.110"	.160"
<b>CN1640T</b>	16"	40	10	TCG	1"	.120"	.165"
<b>CN1660T</b>	16"	60	10	TCG	1"	.120"	.165"
<b>CN1680T</b>	16"	80	10	TCG	1"	.120"	.165"
<b>CN1610T</b>	16"	100	5	TCG	1"	.120"	.165"
<b>CN1612T</b>	16"	120	5	TCG	1"	.120"	.150"
<b>CN1860T</b>	18"	60	5	TCG	1"	.134"	.184"
<b>CN1880T</b>	18"	80	10	TCG	1"	.134"	.184"
<b>CN1810T</b>	18"	100	5	TCG	1"	.134"	.177"
<b>CN1812T</b>	18"	120	0	TCG	1"	.134"	.177"
<b>CN2060T</b>	20"	60	5	TCG	1"	.134"	.184"
<b>CN2080T</b>	20"	80	0	TCG	1"	.134"	.184"
<b>CN2010T</b>	20"	100	5	TCG	1"	.134"	.177"
<b>CN2012T</b>	20"	120	10	TCG	1"	.134"	.177"

## PLASTIC EXTRUSIONS

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
<b>NF71460</b>	7-1/4"	60	0	TCG	5/8" K	.070"	.095"
<b>NF86N</b>	8"	60	-5	TCG	5/8"	.085"	.115"
<b>NF108NT</b>	10"	80	-5	TCG	5/8"	.059"	.090"
<b>NF108N</b>	10"	80	-5	TCG	5/8"	.085"	.125"
<b>MN1090</b>	10"	90	-5	LRTC	5/8"	.095"	.125"
<b>NF101N</b>	10"	100	-5	TCG	5/8"	.095"	.125"
<b>NF1020</b>	10"	120	-2	TCG	5/8"	.085"	.115"
<b>NF121N</b>	12"	100	-5	TCG	1"	.095"	.125"
<b>DM122N</b>	12"	120	-2	TCG	5/8"	.100"	.125"
<b>NF122N</b>	12"	120	-2	TCG	1"	.095"	.125"
<b>MN1212</b>	12"	120	-2	LRTC	1"	.095"	.125"
<b>P141NT</b>	14"	100	-5	TCG	1"	.085"	.120"
<b>NF141N-138</b>	14"	100	-5	TCG	1"	.098"	.138"
<b>NF141N</b>	14"	100	-5	TCG	1"	.120"	.150"
<b>DM142N</b>	14"	120	-5	TCG	5/8"	.110"	.140"
<b>MN1412</b>	14"	120	-5	LRTC	1"	.134"	.165"
<b>P151NT</b>	15"	100	-5	TCG	1"	.095"	.125"
<b>NF1512</b>	15"	120	0	TCG	5/8"	.110"	.150"
<b>NF161N</b>	16"	100	-5	TCG	1"	.134"	.174"
<b>NF162N</b>	16"	120	-5	TCG	1"	.120"	.150"
<b>NF1630</b>	16"	130	-5	TCG	30mm	.115"	.145"
<b>NF182N</b>	18"	120	-5	TCG	1"	.134"	.174"
<b>NF1840</b>	18"	140	-5	TCG	1"	.115"	.145"
<b>NF1840-30</b>	18"	140	-5	TCG	30mm	.115"	.145"
<b>NF202N</b>	20"	120	-5	TCG	1"	.134"	.174"

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## PLASTIC EXTRUSIONS *Cont'd*

NF2014	20"	140	-5	TCG	1"	.134"	.174"
NF2015	20"	150	-5	TCG	1"	.134"	.164"
NF2212	22"	120	-5	TCG	1"	.150"	.180"
NF2215	22"	150	-5	TCG	1"	.150"	.200"
NF2415	24"	150	-5	TCG	1"	.150"	.210"
NF2416	24"	160	-5	TCG	1"	.150"	.210"
NF2416-30	24"	160	-5	TCG	30mm	.150"	.210"

IF YOU DON'T SEE THE EXACT BLADE YOU NEED CALL US FOR AVAILABILITY.

## LOW MELT PLASTIC /SOLID SURFACE CUTTING

### LXT-CORROSION RESISTENT MICRO GRAIN CARBIDE

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
LM1040	10"	40	15	TC2	5/8"	.092"	.127"
LM1072	10"	72	0	TC2	5/8"	.100"	.125"
LM1080	10"	80	5	TC2	5/8"	.070"	.100"
LM10100	10"	100	-5	TC2	5/8"	.085"	.115"
LM1280	12"	80	5	TC2	1"	.085"	.115"
LM1284	12"	84	0	TC2	1"	.100"	.125"
LM1210	12"	100	-2	TC2	1"	.095"	.135"
LM121258	12"	120	-2	TC2	5/8"	.100"	.125"
LM1212	12"	120	-2	TC2	1"	.095"	.125"
LM1410	14"	100	0	TC2	1"	.098"	.138"
LM142N	14"	120	-5	TCG	5/8"	.110"	.140"
LM1412	14"	120	-5	TC2	1"	.110"	.140"
LM1610	16"	100	-5	TC2	1"	.120"	.150"
LM1612	16"	120	-5	TC2	1"	.120"	.150"
LM3084	300"	84	0	TC2	30mm	2.5	3.2
LM3096	300"	96	-5	TC2	30mm	2.4	3.2

LXT

LXT

LXT

\* OUR EXTRUSION BLADES CAN BE MODIFIED TO LOW MELT BLADES.

### THIN RIM BLADES 2" RIM

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
TR860	8"	60	0	TC2	5/8"	.060"	.090"
TR1080	10"	80	0	TCG	5/8"	.059"	.078"
TR1210	12"	100	0	TCG	1"	.063"	.087"

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## PANEL SAW BLADES

**Materials Suggested:** MDF, Particle Board, Laminates, bonded sheets, Plywood, Acrylic Sheets (cast and extruded)

**Machine Types Suggested:** Panel sizing saws (Beam Saws) ® Holzma, Altendorf, Shelling, Selco, Gabbiani, Giben, Mayer, Scheer, SCM, SCMI, etc...

Panel Saw Blades are manufactured to extremely strict tolerances to accommodate optimum performance when used on European panel sizing saws. C-4 micro-grain carbide tips are used to prevent corrosion, which is associated with cutting press board material. The ATB grind is recommended for veneered particle board, raw MDF panels, fiberboard and high density plywood sheets or stacks. The TCG grind is recommended for plastic laminated panels and plywood single sheets and stacks. Keep panel saw blades sharp to prevent blade wear, machine wear and poor cut performance.

PART #	DIA	TEETH	GRIND	PLATE	KERF	BORE	MACHINE
M2264T	220	64T	5TCG	.083"	.120"	30mm	Holzher
M2264NA	220	64T	N5ATB	.083"	.120"	30mm	Holzher
M2264NT	220	64T	N5TCG	.083"	.120"	30mm	Holzher
LR220	220	64T	N5LRCR	2.1	3.1	30mm	Holzher
M2560T	250	60T	5TCG	2.2	3.2	30mm	Striebeg Compact
M2580T	250	80T	5TCG	2.2	3.2	30mm	Striebeg Compact
LR250	250	80T	N5LRCR	2.2	2.9	30mm	Striebeg Compact
M3060A	300	60T	5ATB	2.2	3.2	30mm	
M3060T	300	60T	10TCG	3.2	4.4	30mm	Mayer, SCM
M3072A	300	72T	10ATB	2.2	3.2	30mm	Altendorf/Sliding table..LXT
M3072T	300	72T	10TCG	2.2	3.2	30mm	Altendorf/Sliding table..LXT
LX3072	300	72T	10TCG	2.2	3.2	30mm	Altendorf/Sliding table..LXT
M3072T-65	300	72T	10TCG	3.2	4.4	65mm	Selco EB70
M3072T-75	300	72T	10TCG	3.2	4.4	75mm	Giben
M3072T-80	300	72T	10TCG	3.2	4.4	80mm	SCM Sigma 65
M3072NT	300	72T	N5TCG	2.2	3.2	30mm	Striebeg / Vertical Panel Saws
M3080-114	300	80T	10TCG	3.2	4.4	1.1/4"	
LR3072	300	72T	N5LRCR	2.2	3.2	30mm	
M3096NT	300	96T	N5TCG	2.5	3.3	30mm	Striebeg
LR3096	300	96T	N5LRCR	2.4	3.2	30mm	Striebeg
M3272T-50	320	72T	12TCG	3.2	4.4	50mm	Giben
M3560T	350	60T	10TCG	3.2	4.4	80mm	Gabbiani, SCM
M3572T-30	350	72T	10TCG	3.2	4.4	30mm	
M3572T-14	350	72T	12TCG	3.2	4.4	1.25"	SCM
M3596T	350	96T	5TCG	3.4	4.4	30mm	
M35560T	350	60T	12TCG	3.2	4.4	75mm	Giben
M35572T	350	72T	12TCG	3.2	4.4	75mm	Giben
M3772T	370	72T	12TCG	3.2	4.4	30mm	Schelling
M3872T	380	72T	10TCG	3.2	4.8	60mm	Holzma
M4060T-80	400	60T	10TCG	3.2	4.4	80mm	Gabbiani, SCM
M4072T-60	400	72T	10TCG	3.2	4.4	60mm	Holzma

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## *PANEL SAW BLADES*

<b>M4072T-30</b>	400	72T	12TCG	3.2	4.4	30mm	Schelling
<b>M4072T-75</b>	400	72T	12TCG	3.2	4.4	75mm	Giben
<b>M4072T-80S</b>	400	72T	12TCG	3.2	4.4	80mm	Selco
<b>M4072T-80G</b>	400	72T	12TCG	3.2	4.4	80mm	Gabbiani, SCM
<b>M4372T-80</b>	430	72T	10TCG	3.2	4.4	80mm	Selco
<b>M4396T</b>	430	96T	10CG	3.2	4.4	75mm	Giben
<b>M4572T-60</b>	450	72T	12TCG	3.2	4.4	60mm	Holzma
<b>M4572T-75</b>	450	72T	12TCG	3.2	4.4	75mm	Giben
<b>M4572T-80</b>	450	72T	12TCG	3.2	4.4	80mm	Selco
<b>M5060T-75</b>	500	60T	12TCG	3.4	4.8	75mm	Giben
<b>M5060T-60</b>	500	60T	12TCG	3.4	4.8	60mm	Holzma
<b>M5072T-75</b>	500	72T	12TCG	3.4	4.8	75mm	Giben
<b>M5072T-60</b>	500	72T	12TCG	3.4	4.8	60mm	Holzma
<b>M5772T-60</b>	520	72T	12TCG	3.4	4.8	60mm	Holzma
<b>M5760A</b>	570	60T	19ATB	3.5	4.5	60mm	Holzma

## *PALLET RECYCLING*

PART #	DIAM.	TEETH	ID	PLATE	KERF
<b>PH724</b>	7-1/4"	24 ATB	5/8"	.060"	.090"
<b>PH740</b>	7-1/4"	40 ATB	5/8"	.060"	.090"
<b>PH1024</b>	10"	24 MTC	5/8"	.095"	.145"
<b>PH1224</b>	12"	24 MTC	1"	.109"	.160"
<b>PH1424</b>	14"	24 MTC	1"	.120"	.180"
<b>PH1630</b>	16"	30 MTC	1"	.134"	.194"
<b>PH1824</b>	18"	24 MTC	1"	.134"	.194"
<b>PH1836</b>	18"	36 MTC	1"	.134"	.194"

## *RESCUE/DEMOLITION*

PART #	DIAM.	TEETH	ID	PLATE	KERF
<b>RD1024</b>	10"	24	5/8"	.085"	.125"
<b>RD1212</b>	12"	12	1"	.085"	.125"
<b>RD1414</b>	14"	14	1"	.098"	.138"
<b>RD1424</b>	14"	24	1"	.120"	.165"
<b>RD1424</b>	14"	24	20mm	.063"	.087"
<b>RD1616</b>	16"	16	1"	.120"	.165"

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## ***RIP BLADES***

**Materials Suggested:** Hardwood, Softwood

**Machine Types Suggested:** Table Saw, Straight Line Rip, Gang Rip Saw

Rip saw blades are designed to cut with the grain of hardwoods and softwoods. A STRAIGHT GRIND (STR) is the fastest way to rip boards and a TCG is best when a “Glue Joint” is required. An ATB grind is recommended for boards with a strong grain pattern. Strong Grain can cause the blade to drift and follow the grain. Our entire line of rip saw blades can be bored and have pin holes added to accommodate many different saws.

Blades with a 2” arbor hole come with a 9/16” pin hole to accommodate Deihl Rip Saws.

Gang rip blades are made with arbor holes, keyways and pin holes to accommodate the Lauderdale Hamilton and Raimann Rip Saws.

### **STANDARD RIP BLADES**

PART #	DIA	TOOTH	GRIND	PLATE	KERF	BORE	PINHOLE
<b>R824</b>	8"	24	20ST	.085"	.125"	5/8"	
<b>R924</b>	9"	24	20ST	.085"	.125"	5/8"	
<b>R1024</b>	10"	24	20ST	.085"	.125"	5/8"	
<b>R3030</b>	300	30	20ST	2.2mm	3.2mm	30mm	
<b>R1224</b>	12"	24	20ST	.085"	.125"	1"	
<b>R1230</b>	12"	30	20ST	.085"	.125"	1"	
<b>R1236</b>	12"	36	20ST	.085"	.125"	1"	
<b>R1640</b>	16"	40	20ST	.120"	.165"	1"	
<b>R1836</b>	18"	36	20ST	.134"	.184"	1"	
<b>R1836-2</b>	18"	36	20ST	.134"	.184"	2"	9/16"
<b>R2040</b>	20"	40	20ST	.134"	.184"	1"	

### **PRODUCTION RIP**

PART#	DIA	TOOTH	GRIND	PLATE	KERF	BORE
<b>RHP1224</b>	12"	24	20ST	.110"	.160"	1"
<b>RHP1230</b>	12"	30	20ST	.134"	.184"	1"
<b>RHP1430</b>	14"	30	20ST	.134"	.184"	1"
<b>RHP1640</b>	16"	40	20ST	.134"	.184"	1"

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## *RIP BLADES cont'd*

### HEAVY DUTY RIP BLADES

Ripping of hard and soft woods. Suitable for both hand and power feed applications.  
Can be modified for gang ripping applications.

PART #	DIA	TOOTH	GRIND	PLATE	KERF	BORE
<b>RHD1010</b>	10"	10	20ST	.095"	.145"	5/8"
<b>RHD1024</b>	10"	24	20ST	.095"	.145"	5/8"
<b>RHD1212</b>	12"	12	20ST	.110"	.160"	1"
<b>RHD1224</b>	12"	24	20ST	.095"	.145"	1"
<b>RHD1236</b>	12"	36	20ST	.095"	.145"	1"
<b>RHD1420</b>	14"	20	20ST	.120"	.160"	1"
<b>RHD1430</b>	14"	30	20ST	.110"	.160"	1"
<b>RHD1440</b>	14"	40	20ST	.110"	.160"	1"
<b>RHD1630</b>	16"	30	20ST	.120"	.165"	1"

All blades with 2" bore come standard with 9/16" pinhole

### GLUE LINE RIP

These are the cleanest cutting rip blades to be used where a "glue joint" is required. Triple Chip Grind (TCG) is recommended for hardwoods and composite boards and will produce a "glue joint". Other rip blades can be modified to fit your machine.

PART #	DIA	TOOTH	GRIND	PLATE	KERF	BORE	PINHOLE
<b>RG1024A-125</b>	10"	24	20ATB	.085"	.125"	5/8"	
<b>RG1024A-145</b>	10"	24	20ATB	.095"	.145"	5/8"	
<b>RG1224A</b>	12"	24	20ATB	.095"	.145"	1"	
<b>RG1440A</b>	14"	40	20ATB	.110"	.160"	1"	
<b>RG1030T</b>	10"	30	20TCG	.095"	.145"	5/8"	
<b>RG1230T</b>	12"	30	20TCG	.110"	.160"	1"	
<b>RG1236T-160</b>	12"	36	20TCG	.110"	.160"	1"	
<b>RG1236T-170</b>	12"	36	20TCG	.120"	.170"	1"	
<b>RG1436T</b>	14"	36	20TCG	.120"	.165"	1"	
<b>RG1436T-112</b>	14"	36	20TCG	.120"	.165"	1.1/2"	
<b>RG1436T-2</b>	14"	36	20TCG	.120"	.165"	2"	9/16"
<b>RG1440T</b>	14"	40	20TCG	.110"	.165"	1"	
<b>RG1636T</b>	16"	36	20TCG	.120"	.170"	1"	
<b>RG1636T-2</b>	16"	36	20TCG	.120"	.170"	2"	9/16"
<b>RG1836T</b>	18"	36	20TCG	.134"	.184"	1"	
<b>RG1836T-2</b>	18"	36	20TCG	.134"	.184"	2"	9/16"

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## RIP BLADES cont'd

### ULTRA THIN RIP

Ideal for ripping on under powered saws or molders. A thinner kerf allows for less feed effort and saves wood! For maximum performance use with saw stabilizers.

PART#	DIA	TOOTH	GRIND	PLATE	KERF	BORE
<b>RU824</b>	8"	24	20ST	.060"	.090"	5/8"
<b>RU1024</b>	10"	24	20ATB	.060"	.090"	5/8"
<b>RU1224</b>	12"	24	20ST	.060"	.090"	1"

### GANG RIP BLADES

Blades are designed for Domestic and European multi-rip machines. Offered in a variety of kerfs and tooth counts to suit many unique requirements.

PART #	DI A	TOOT H	GRIND	PLATE	KERF	BORE	KEYWAYS
<b>RGR1030</b>	10"	30	20ST	.095"	.135"	70mm	20x10
<b>RGR1040T-3</b>	10"	40	15TCG	.085"	.125"	3"	3 pins
<b>RGR1040T-4</b>	10"	40	15TCG	.085"	.125"	4 3/16"	3 pins
<b>RGR1224-125</b>	12"	24	20ST	.085"	.125"	70mm	20x10
<b>RGR1224-145</b>	12"	24	20ST	.095"	.145"	70mm	20x10
<b>RGR1224-134</b>	12"	24	20ST	.095"	.145"	1 3/4"	none
<b>RGR1224-318</b>	12"	24	20TCG	.095"	.135"	3.1/8"	none
<b>RGR1228</b>	12"	28	20ST	.110"	.160"	80mm	20x 5
<b>RGR1230-134</b>	12"	30	20ST	.134"	.184"	1 3/4"	none
<b>RGR1236</b>	12"	36	20ST	.095"	.135"	3.1/8"	none
<b>RGR3070</b>	300	30	20ST	2.8mm	4.3mm	70mm	20x10

### GANG RIP BLADES - GLUE LINE

Blades are designed for Domestic European multi -rip machines. Triple Chip Grind (TCG) is

recommended for hard woods and composite boards and will produce a "glue joint" cut.

Offered in a variety of kerfs and tooth counts to suit many unique requirements. Other rip blades can be modified to suit your machine.

PART #	DIA	TOOTH	GRIND	PLATE	KERF	BORE	KEYWAYS
<b>RGR1040T-318</b>	10"	40	15TCG	.085"	.125"	3 1/8"	1/4"x1/4"
<b>RGR1236T-70</b>	12"	36	20TCG	.095"	.135"	70mm	20x10
<b>RGR1236T-80</b>	12"	36	20TCG	.110"	.160"	80mm	20x5 + pins
<b>RGR1236T-125</b>	12"	36	20TCG	.085"	.125"	3.1/8"	1/4"x1/4"
<b>RGR1236T-160</b>	12"	36	20TCG	.110"	.160"	3.1/8"	1/4"x1/4"
<b>RGR1236T-170</b>	12"	36	20TCG	.120"	.170"	3.1/8"	1/4"x1/4"
<b>RGR1248T-80</b>	12"	48	20TCG	.110"	.160"	80mm	20x5 + pins
<b>RGR1436T</b>	14"	36	20TCG	.120"	.176"	3.1/8"	1/4"x1/4"
<b>RGR3060</b>	300	36	20TCG	2.8mm	4mm	60mm	20x10
<b>RGR3570</b>	350	36	20TCG	3.2mm	4.3mm	70mm	20x10

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## ***PRINTERS SAWS***

**Materials Suggested:** Lead, Copper, Wood, Die Blocks, Linotype, Stereotype, Engraving Metal

**Machine Types Suggested:** Hammond Glider Saw, Richards Saw, Morrison Saw, C & G Saw, Miller Saw

Printers saw blades are made for specific saws and require a unique arbor fixture with countersunk mounting holes. Please specify the type of material being cut when ordering.

								HOLES		
PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF	MACHINE	Mount	Trim
PR630	6"	30	5	TCG	7/8"	.065"	.100"	Morrison	3	3
PR748H	7"	48	5	TCG	13/16"	.065"	.100"	Hammond	3	3
PR748R	7"	48	10	ATB	1-1/8"	.085"	.125"	Richards	3	0
PR860R	8"	60	10	ATB	1-1/8"	.085"	.125"	Richards	3	0

## ***TRUSS & COMPONENT SAWS***

Made to fit the following saws:

- Clary
- Mitek
- Timber Mill
- Idaco
- Razer
- Auto-Omni
- Monet
- Mangotech
- Triad
- Alpine Linear

Truss saw blades come with countersunk mounting holes that fit 5/16" bolt with 82 degree tapering with the exception being TS16404 which has a 1/4" bolt hole. Extra heavy saw plates are used to make sure the blades run straight and true. Truss blades are furnished with a 10 degree hook angle.

## ***TREE TRIMMING***

**Materials Suggested:** Tree Trimming and Clearing

**Machine Types Suggested:** Tree Trimming Saws

These blades are made for specific saws used to clear limbs near power lines and railroads. Please call with exact specifications prior to ordering.

PART #	DIAM.	TEETH	HOOK	GRIND	ID	PLATE	KERF
TT2460	24"	60	10	ATB	1"	.165"	.245"
TT2460-112	24"	60	10	ATB	1-1/2"	.165"	.245"
TT2472	24"	72	5	ATB	1-1/2"	.180"	.268"

\*These blades do not have expansion slots and are specially made for tree trimming.

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## ***HARDIPLANK® POLYCRYSTALLINE DIAMOND***

This polycrystalline diamond blade is made for cutting fiber cement board. These blades can last 125-200 times longer than carbide tipped saw blades when cutting fiber cement board such as Hardiplank®. They are not intended to be used to cut through nails or staples.

PART #	DIAM.	TEETH	ID	PLATE	KERF
<b>PD74</b>	7-1/4"	4	5/8"	.063"	.087"
<b>PD86</b>	8"	6	5/8"	.063"	.087"
<b>PD106</b>	10"	6	5/8"	.063"	.087"
<b>PD128</b>	12"	8	5/8"	.063"	.087"
<b>PD1212</b>	12"	12	5/8"	.063"	.087"

## ***EDGE BANDING***

Edge banding blades are stocked for the most common machines. "Left and Right" hand blades have teeth that are beveled in one direction.

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## DADO SETS

These stack dado sets have built their own reputation for reliability and accuracy. Extra large carbide tips are used on the outside blades and chipper teeth. Precision grinding ensures a perfect flat bottom dado, with slight scribes on both sides of the dado. We can accommodate a true flat bottom cut as well.

Each set consists of 2 outside blades and the following 2 wing chippers: (1) 1/4" thickness; (2) 1/8" thickness; (1) 1/16" thickness. The standard set #3 will cut up to 13/16" wide to accommodate nominal 3/4" lumber. Extra chippers can be added to accommodate wider cuts.

### INDUSTRIAL DADO SETS

PART #	DIA	TOOTH	BORE	MAX CUT
DH630	6"	30t	5/8"	13/16"
DH8245	8"	24t	5/8"	13/16"
DH8241	8"	24t	1"	13/16"
DH8405	8"	40t	5/8"	13/16"
DH8401	8"	40t	1"	13/16"
DH10245	10"	24t	5/8"	13/16"
DH10241	10"	24t	1"	13/16"
DH10405	10"	40t	5/8"	13/16"
DH10401	10"	40t	1"	13/16"
DH12241	12"	24t	1"	13/16"
DH12401	12"	40t	1"	13/16"
DH14241	14"	24t	1"	13/16"

\*\*14" can be made with 40 outside teeth

### MULTI TOOTH DADO SETS

Multi-tooth chippers make these sets well suited for high production grooving in composite materials. Recommended for heavy duty machinery only. Packed in a wooden storage case. Set consists of 2 outside blades, 4- 1/8" chippers, 1-1/16" chipper.

PART #	DIA	TOOTH	BORE	MAX CUT
MDH8405	8"	40t	13/16"	5/8"
MDH10601	10"	60t	13/16"	1"

### EXTRA WIDE DADO SETS

SET #	WIDTH	NUMBER OF CHIPPERS		
		1/4"	1/8"	1/16"
4	1-1/16"	2	2	1
5	1-9/16"	4	2	1
6	2-1/16"	6	2	1
7	2-9/16"	8	2	1
8	3-1/16"	10	2	1

When ordering add the set # to the end of the above part number

## GROOVERS

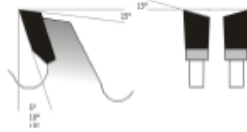
Carbide Tipped Groovers are designed for production groove cutting in hard and soft woods. Our standard blades feature a shear face design which helps chip removal. Use more teeth for cutting across the grain and for composites and fewer teeth for cutting with the grain. In addition to standard blades we custom make many different sized grooving blades.

# The BLADE MFG. CO.

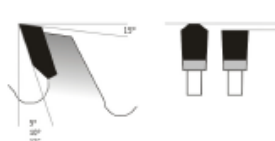
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## Carbide Tipped Tooth Profiles

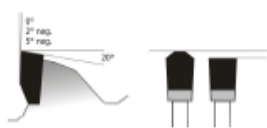
ATB Cross Cut



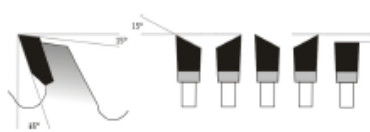
TCG Cross Cut



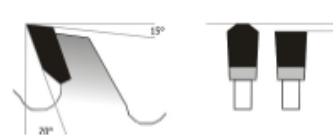
TCG Non Ferrous



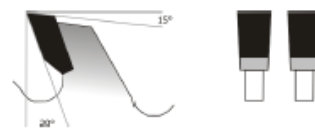
Combination 4 & 1



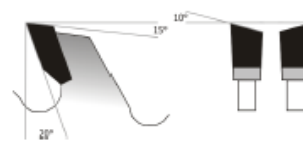
Rip TCG



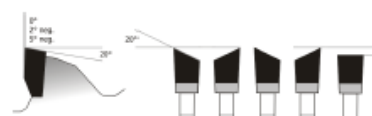
Rip - Straight



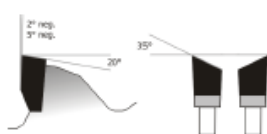
Rip - ATB



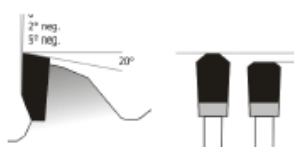
Miter - 4 & 1



HATB -Double Side Laminate



MTCG - Double Sided Melamine; Solid Surface; LOW Melt Plastic



Steel Cutting 45 Degree Bevel



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## STEEL WOOD CUTTING SAW BLADES

**Materials Suggested:** Pruning, Hardwood, Softwood, Plywood, MDF, Single-Sided Laminates,

**Machine Types Suggested:** Radial Arm Saw, Miter Saw, Table Saw, Straight Line Rip, Up-Cut saw etc...

RIP SAWS		
Dia.	Gauge	Teeth
10"	15	36A
12"	14	36A
14"	12	36A
16"	10	30A
16"	12	36A
18"	11	36A
20"	10	36A

CUT-OFF SAWS		
Dia.	Gauge	Teeth
10"	15	100L-150L
12"	14	100N-150L
14"	13	100N-150L
16"	13	100N-150L
18"	11	100N-150L
20"	10	100N

COMBINATION SAWS		
Dia.	Gauge	Teeth
10"	15	44W-70S
12"	14	44W-60U-80S
14"	13	44W-66U-90S
16"	13	44W-72U-100S
18"	11	44W-78U-110S
20"	10	44W-84U-120S

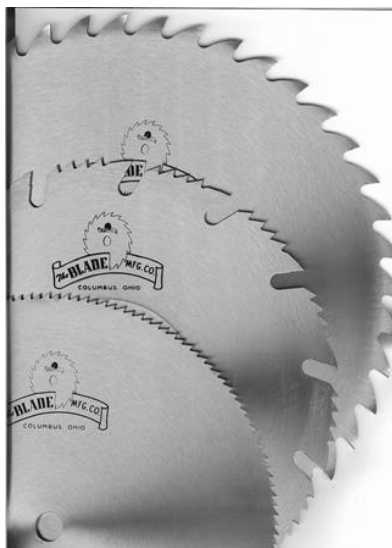
Cut-Off Saws are designed for cutting only across the grain of the lumber. Steel cut-off blades are commonly used for pruning groves and tree or brush clearing. Pruning saw blades can be custom made up to 36" in diameter.

Rip Saws are designed for sawing only with the grain of the lumbers.

Combination Saws are designed to be used either across or with the grain of the lumber. They are especially recommended for applications where it is impractical to change blades frequently.

### STANDARD ARBOR HOLES

7" to 10" dia..... 5/8"  
12" to 20" dia..... 1"



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## NOTES

### **Custom Saw Blades**

#### **Product List:**

1" up to 80"  
Carbide Tipped  
High Speed Steel  
Circular Knives  
Steel Woodcutting (Rip, Combination, Cut-Off)  
Made to Spec  
Technical Support Available

Custom made saw blades are one of our specialties. All of our product lines can be custom made to order. Contact our technical experts for your custom blades and we'll be happy to quote a drawing, sample blade or spec sheet. Depending on the type of blade, deliveries can range from 1 week to 10 weeks.

The best way to alleviate long lead times is to consider blanket orders. We inventory your custom blades and ship on scheduled release dates or over a blanket period.

### **Saw Blade Sharpening**

Saw Blades, knives and cutting tools are sharpened to the same quality standards as when they were new. Precision sharpening is completed on CNC grinders by skilled operators.

- |                             |                              |
|-----------------------------|------------------------------|
| * Carbide Tipped Saw Blades | * High Speed Saw Blades      |
| * Cold Saw Blades           | * Circular Knives            |
| * Router Bits & Drill Bits  | * Straight Knives & Chippers |
| * Planer & Jointer Knives   | * Machining Cutting Tools    |

### **Band Saw Blades**

Industrial quality band saw blades are stocked and welded to length. We will keep your blades in stock for immediate delivery. We have partnered with the finest manufacturers to provide the highest quality blades available. Technical support is available to assist in blade selection.

### **Industrial Saws**

- \* Band Saws
- \* Hose Cut-Off Saws
- \* Production Cut-Off Saws
- \* Industrial Cutting Tools



**OUR FULL CATALOG CAN BE FOUND ON OUR WEBSITE AT [WWW.BLADEMFG.COM](http://WWW.BLADEMFG.COM)**

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