

*Sterling<sup>®</sup> Saw Blades*





## History

John T. Ronan, a practicing engineer, moved to Buffalo N.Y. during its era of expansion and prosperity. In 1890, he became partners with Joseph Campbell and established Diamond Saw and Stamping Works and incorporated it in 1903. It produced various metal products for industry, and generally specialized in the manufacture of hack sawing machines and blades. John T. Ronan eventually bought all of the company stock and adopted the Sterling® brand. The company continued to prosper for many years. However, in the 1930's the business fell on difficult times with the rest of the country. John's sons, George and Lerner, bought the assets of the company and nursed it back to health. It remained a privately held business, now known as Diamond Saw Works, Inc.

Again the company prospered, now specializing in the manufacture of metal cutting blades exclusively. The company efforts were directed toward updating manufacturing equipment, improving products, and expanding the sales force throughout the U.S. and branching out with sales agents in Canada and Europe. It was during this period, in 1937, that the broach tooth, the first variable pitch tooth design, was developed and patented by Diamond Saw and applied to power and hand hacksaws.

In 1955 - 1956 the decision was made to build a new high efficiency, 20,000 sq. ft., manufacturing facility in Chaffee, N.Y. Additions to the building now have Diamond Saw Works at 50,000 sq. ft. Later Lerner Ronan's sons, L. Don, Thomas, Michael and William, began taking over the day to day operations from their Dad who retired in 1980.

In 1990, Diamond Saw Works decided to make all employees, owners through a leveraged Employee Stock Ownership Plan, (ESOP). Within seven years of its inception, all the employees owned one - third of the company through the ESOP Plan. Currently the Employee Owners own 60%, with the eventual goal of owning 100%.

Today Diamond Saw Works is an industrial supplier of high quality metal and wood cutting saw blades. Band saw blades account for 85% of our business and manufacturing effort. Our world headquarters and sole manufacturing facility is located in Chaffee, N.Y. Our owner employees take pride in their work with customers, suppliers, fellow owners, and the community. For over 130 years the Sterling® name has stood for quality, durability, and reliability. Yesterday, today and tomorrow, Sterling® stands the test of time.

— Jim Ziemer - President of Diamond Saw Works, Inc.

## Safety Warning

Sterling® Saw Blade products are engineered and manufactured with safety in mind. All of the products manufactured by Sterling® Saw Blades are designed to perform without any undue safety issues when caution, common sense and proper safety practices are followed. The use of these tools is safe when proper application and protection guidelines are observed. Even when these proper precautions are taken, it is possible that fragments of a cutting tool, cutting material, or holding device may be thrown at a very high rate of speed and have potential to cause severe bodily harm. It is imperative that general safety precautions and safety glasses be used at all times.

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## Band Saw Blade Ordering Instructions

When ordering band saw blades and coil stock, please include the following information:

- **Quantity**
- **Item Number**
- **Coil or Blade Length** (feet & inches)  
\* Coils 150'/250' \* 1-1/2" and over 150' only
- **Blade Width**
- **Teeth Per Inch/Grit**
- **Set** (Raker, Wavy, E.T.S.)
- **Style** (Skip, Hook, Constant, Broach and Posi tooth)
- **Blade Type** (specific brand name)

## Guaranteed Trial Order Program

Diamond Saw Works offers a Guaranteed Trial Order Program on all Sterling® band saw blade products. Upon review and approval of consumer applications we will provide a product on a paid trial basis. The purpose of this program is to allow all consumers the opportunity to try our products risk-free. Contact your local Sterling® representative with your application information so we may provide you with the right blade that will meet your performance expectations.



Width & Thickness Inches		MM		T.P.I.	Grind	Item No.
1/2"	.025	12.7	.64	3	** Set	943059
				4	Triple Chip	943060
3/4"	.035	19	.90	3	Triple Chip	943075
				3	** Set	943076
3/4"	.035	19	.90	3	Hvy Set	943080
3/4"	.042	19	1.07	3	Triple Chip	943085
1"	.035	27	.90	3	Triple Chip	943095
				3	** Set	943096
				4/3	Triple Chip	943105
				4/3	Negative	943106
1"	.042	27	1.07	3	Triple Chip	943108
				1.7/1	Triple Chip	943121
				2/1.4	Triple Chip	943122
				3/2	Triple Chip	943123
				3	Triple Chip	943116
				4/3	Triple Chip	943127
4/3	Negative	943128				
1-1/2"	.050	41	1.27	1.7/1	Triple Chip	943133
				2/1.4	Triple Chip	943134
				3/2	Triple Chip	943143
				3/2	Negative	943144
				4/3	Triple Chip	943147
				4/3	Negative	943148
				4/3	Coated	943150
				4/3	Coated	943150
2"	.062	54	1.60	1.7/1	Triple Chip	943172
				2/1.4	Triple Chip	943175
				2/1.4	Special	943176
				3/2	Triple Chip	943180
				4/3	Triple Chip	943185
2-5/8"	.062	67	1.60	1.7/1	Triple Chip	943213
				2/1.4	Triple Chip	943215
				3/2	Triple Chip	943214
3"	.062	76	1.60	1/8	Triple Chip	943217
				2/1.4	Triple Chip	943219

## NXT-CT™ Carbide Tipped



For difficult machining materials such as inconel, hasteloy, titanium, nickel alloys, stainless steel, chrome alloys, tool steels and specialty steels.



### Applications

- Triple chip pattern for difficult machining materials
- \*\* Set tooth for aluminum castings and foundry applications

### Features & Benefits

- Newest grade of carbide for higher cutting speed, longer blade life, and high heat and abrasion resistance
- Unique ground tooth form improves cutting accuracy and offers a high quality, smoother finish
- Improved, tempered steel backer offers greater beam strength and extended blade fatigue life

## Excel™ Bi-Metal M42



Ideal for cutting a variety of moderate to difficult machining materials with abrasive characteristics.



### Applications

- Production cutting
- Stainless steels
- Carbon steels
- Hardened materials
- Solid rods
- Medium to heavy production machines

### Features & Benefits

- High tooth hardness Rc 68-69
- 8% Cobalt M42 tool steel cutting edge
- Cuts high alloy, heat treated and stainless steels
- Available in broach, posi and hook tooth designs.

Width & Thickness		T.P.I.	Set	Style	Item No.						
Inches	MM										
3/4"	.035	19	.90	6/4	Raker	Broach	925002				
				8/5	Raker	Broach	925003				
				10/6	Raker	Broach	925006				
				12/8	Raker	Broach	925007				
				14/10	Raker	Broach	925008				
1"	.035	27	.90	3	Raker	Hook	924997				
				3/2	Raker	Posi	925010				
				4/3	Raker	Posi	925013				
				6/4	Raker	Broach	925017				
				6/4	Raker	Posi	925015				
				8/5	Raker	Broach	925022				
				8/5	Raker	Posi	925020				
				10/6	Raker	Broach	925025				
				12/8	Raker	Broach	925026				
				14/10	Raker	Broach	925027				
				1-1/4"	.042	34	1.07	1	Raker	Hook	925310
3/2	Raker	Posi	925035								
4/3	Raker	Posi	925037								
6/4	Raker	Posi	925040								
8/5	Raker	Posi	925045								
10/6	Raker	Broach	925046								
12/8	Raker	Broach	925047								
1-1/2"	.050	41	1.27					1	Raker	Hook	925320
				1.5/1	Raker	Posi	925053				
				2/1.4	Raker	Posi	925054				
				3/2	Raker	Posi	925055				
				4/3	Raker	Posi	925057				
				6/4	Raker	Posi	925060				
				8/5	Raker	Broach	925061				
				10/6	Raker	Broach	925063				
				2"	.050	54	1.27	1	Raker	Hook	925329
								3/2	Raker	Posi	925066
4/3	Raker	Posi	925068								
6/4	Raker	Posi	925069								
2"	.063	54	1.60					1	Raker	Hook	925330
				1.5/1	Raker	Posi	925086				
				2/1.4	Raker	Posi	925085				
				3/2	Raker	Posi	925087				
				4/3	Raker	Posi	925088				
				6/4	Raker	Posi	925089				
				8/5	Raker	Broach	925090				
				2-5/8"	.063	66.8	1.60	1/8	Raker	Posi	925096
1.5/1	Raker	Posi	925098								
2/1.4	Raker	Posi	925097								
3/2	Raker	Posi	925099								
4/3	Raker	Posi	925102								
6/4	Raker	Posi	925095								
3"	.063	76	1.60	1/8	Raker	Posi	925100				

## Mach 12™ Bi-Metal M51



For cutting solid or thick walled materials which have work hardening or abrasive characteristics, exotic metals, super alloys and space age materials.

Width & Thickness Inches		T.P.I.		Set	Style	Item No.	
MM							
1-1/4".042	34	1.07	3/2	Raker	Posi	927216	
			4/3	Raker	Posi	927218	
			6/4	Raker	Posi	927220	
1-1/2".050	41	1.27	3/2	Raker	Posi	927238	
			4/3	Raker	Posi	927243	
			6/4	Raker	Posi	927245	
2"	.063	54	1.60	3/2	Raker	Posi	927254
				4/3	Raker	Posi	927258

### Applications

- Solid or thick walled materials
- Exotic metals
- Super alloys
- Space age materials

### Features & Benefits

- Tooth hardness Rc 69-70
- 10% Cobalt edge
- High chrome backer for maximum tool life
- Excellent heat and abrasion resistance
- 12 degree positive rake varied pitch tooth design

## Contour Band™ Bi-Metal M42



Ideal for contour or straight cutting applications when a narrow bandsaw blade is required, such as internal cutting and die work.

Width & Thickness Inches		T.P.I.		Set	Style	Item No.	
MM							
1/4"	.025	6.4	.64	6	Raker	Hook	923014
				14/10	Raker	Broach	923015
				18/14	Raker	Broach	923017
1/4"	.035	6.4	.90	10	Raker	Constant	923005
				14	Raker	Constant	923010
3/8"	.025	9.5	.64	14/10	Raker	Broach	923028
3/8"	.035	9.5	.90	4	Raker	Hook	923012
				6	Raker	Hook	923022
				10	Raker	Constant	923020
1/2"	.025	12.7	.64	4	Raker	Hook	923046
				6	Raker	Hook	923032
				10	Raker	Constant	923033
				14	Raker	Constant	923041
				10/6	Raker	Broach	923036
				12/8	Raker	Broach	923037
				14/10	Raker	Broach	923043
				18/14	Raker	Broach	923044
1/2"	.035	12.7	.90	3	Raker	Hook	923047
				6	Raker	Hook	923048
				14	Raker	Constant	923055
				10/6	Raker	Broach	923060
				14/10	Raker	Broach	923067

### Applications

- Die work

### Features & Benefits

- Tooth hardness Rc 68-69
- 8% Cobalt edge

## Cut Master™ Bi-Metal M42



Optimized tooth design balances rake angle, gullet depth and flank design for increased tool life when tooth strippage is a problem.

Width & Thickness Inches		MM		T.P.I.	Set	Style	Item No.
1"	.035	27	.90	4/3	Raker	Posi	925710
				6/4	Raker	Posi	925715
1-1/4"	.042	34	1.07	4/3	Raker	Posi	925720
				6/4	Raker	Posi	925725
1-1/2"	.050	41	1.27	4/3	Raker	Posi	925730
				6/4	Raker	Posi	925735
2"	.063	54	1.60	4/3	Raker	Posi	925740



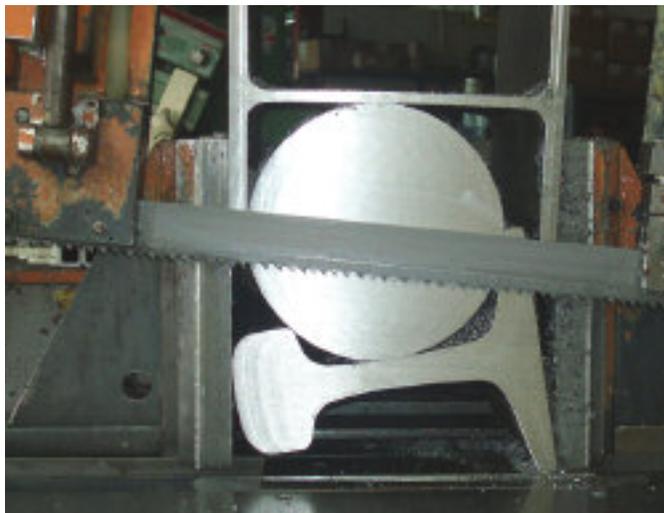
### Applications

- Mild steel, alloys and stainless steel shapes

### Features & Benefits

- Tooth hardness Rc 68-69
- 8% Cobalt M42 tool steel cutting edge
- Modified tooth profile and set resists strippage and provides better finish
- Reduces vibration and chatter

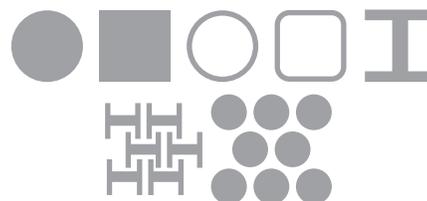
## Kerf Plus™ Bi-Metal M42



Wider kerf/heavy set to allow for production cutting of profiles and structural shapes that tend to bind in the cut.

\*10° Face angle

Width & Thickness Inches		MM		T.P.I.	Set	Style	Item No.
1"	.035	27	.90	6/4	Raker	Posi	920205
				4/3	Raker	Posi	920220
1-1/4"	.042	34	1.07	4/3	Raker	Posi	920222*
				6/4	Raker	Posi	920221
				4/3	Raker	Posi	920228*
1-1/2"	.050	41	1.27	3/2	Raker	Posi	920230
				4/3	Raker	Posi	920232*
				4/3	Raker	Posi	920231
				6/4	Raker	Posi	920237*
2"	.063	54	1.60	3/2	Raker	Posi	920240
				4/3	Raker	Posi	920242*
				4/3	Raker	Posi	920241
				6/4	Raker	Broach	920241
2-5/8"	.063	54	1.60	3/2	Raker	Posi	920250*
				4/3	Raker	Posi	920252*



### Applications

- Straight or miter cuts in heavy walled or flanged beams and stacked or bundled structurals or tubing

### Features & Benefits

- Tooth hardness Rc 68-69
- 8% Cobalt M42 tool steel cutting edge
- Wide kerf - heavy set
- 10 degree face angle



Width & Thickness		T.P.I.	Set	Style	Item No.
Inches	MM				
1/2"	.020	12.7	.50	10 Raker Constant	923030
				14 Raker Constant	923035
				18 Raker Constant	923040
				24 Wavy Constant	923039
				14/10 Raker Broach	923038
				18/14 Wavy Broach	923052
				18/14 Raker Broach	923034
5/8"	.032	16	.80	10/6 Raker Broach	923072
				14/10 Raker Broach	923074
3/4"	.035	19	.90	3 Raker Hook	923075
				10 Raker Constant	923090
				14 Raker Constant	923095
				6/4 Raker Broach	923107
				8/5 Raker Broach	923112
				10/6 Raker Broach	923115
				12/8 Raker Broach	923120
				14/10 Raker Broach	923122
				18/14 Raker Broach	923123
1"	.035	27	.90	10 Raker Constant	923150
				6/4 Raker Broach	923162
				8/5 Raker Broach	923167
				10/6 Raker Broach	923170
				12/8 Raker Broach	923175
				14/10 Raker Broach	923177
1-1/4"	.042	34	1.07	3/2 Raker Posi	923215
				4/3 Raker Posi	923217
				6/4 Raker Broach	923222
				8/5 Raker Broach	923227
				10/6 Raker Broach	923230

## Super Weld™ Bi-Metal Matrix II



For general purpose sawing on vertical and horizontal machines. Interrupted cuts in pipe, structurals and solid material. Narrow widths for vertical bandsaw machines.



### Applications

- Ferrous and non-ferrous grating and expanded metals
- Maintenance, tool room and repair shops
- Light fabrication of mild steel
- Thin wall tubing, sheet metal
- Vertical, hand fed machines
- Contour cutting

### Features & Benefits

- Tooth hardness Rc 66-68
- 8% Cobalt Matrix II tool steel cutting edge
- Comes in a wide variety of configurations including hook, broach, constant and posi



To Order Call Toll Free:  
**1-800-828-1180**

## New Wave™ Bi-Metal Matrix II



For structurals, tubing and troublesome interrupted cuts. The set pattern helps reduce tooth strippage problems. Excellent for maintenance departments.

### Applications

- Maintenance, tool room and repair shops
- Light fabrication of mild steel
- Thin wall tubing
- Sheet metal
- Vertical, hand fed machines
- Contour cutting

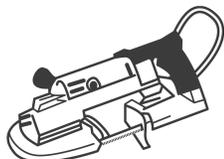
### Features & Benefits

- Tooth hardness Rc 66-68
- 8% Cobalt Matrix II tool steel cutting edge
- Wavy set
- 0 degree face angle

Width & Thickness			T.P.I.	Set	Style	Item No.
Inches		MM				
1/4"	.025	6.4 64	14/10	Wavy	Broach	923016
			18/14	Wavy	Broach	923018
3/8"	.025	9.5 .64	18/14	Wavy	Broach	923031
1/2"	.025	12.7 .64	14/10	Wavy	Broach	923049
			18/14	Wavy	Broach	923051
3/4"	.035	19 .90	8/5	Wavy	Broach	923113
			10/6	Wavy	Broach	923118
			12/8	Wavy	Broach	923121
			14/10	Wavy	Broach	923124
			18/14	Wavy	Broach	923126
1"	.035	27 .90	8/5	Wavy	Broach	923166
			10/6	Wavy	Broach	923172
			12/8	Wavy	Broach	923176
			14/10	Wavy	Broach	923178
1-1/4"	.042	34 1.07	8/5	Wavy	Broach	923228
			10/6	Wavy	Broach	923231
			12/8	Wavy	Broach	923234
1-1/2"	.050	41 1.27	8/5	Wavy	Broach	923253
2"	.050	54 1.27	8/5	Wavy	Broach	923255
2"	.063	54 1.60	8/5	Wavy	Broach	923260



## Super Weld MX™ Bi-Metal Portable Band Saw Blades



### Features

- 8% Cobalt Matrix II
- Provides excellent life in tough cutting applications
- Available 5 per pack or bulk 100
- Other sizes available upon request

Width & Thickness	T.P.I.	Set	Style	Item No.	Item No.
Feet & Inches				5/PK	100/PK
3'8-7/8" 1/2 .020	10	Raker	Constant	23900-5	23900-100
	14	Raker	Constant	23903-5	23903-100
	18	Raker	Constant	23906-5	23906-100
	24	Wavy	Constant	23907-5	23907-100
	14/10	Raker	Broach	23908-5	23908-100
	18/14	Wavy	Broach	23904-5	23904-100
	18/14	Raker	Broach	23905-5	23905-100

Width & Thickness		T.P.I.	Set	Style	Item No.
Inches	MM				
1/4"	.025	6.4	.64	10 Raker Constant	914040
				14/10 Raker Broach	914070
3/8"	.025	9.5	.64	4 Raker Skip	914095
				4 Raker Hook	914090
				6 Raker Hook	914100
1/2"	.025	12.7	.64	4 Raker Hook	914170
				6 Raker Hook	914180
				6 Raker Constant	914185
				10 Raker Constant	914190
				14 Raker Constant	914200
				14 Wavy Constant	914205
				18 Raker Constant	914210
				10/6 Raker Broach	914225
				14/10 Raker Broach	914235
3/4"	.032	19	.80	3 Raker Hook	914275
				6 Raker Constant	914295
				8 Raker Constant	914300
				10 Raker Constant	914310
				14 Raker Constant	914330
				10/6 Raker Broach	914350
				12/8 Raker Broach	914355
				14/10 Raker Broach	914360
1"	.035	25.4	.90	14 Raker Constant	914410
				6/4 Raker Posi	914420
				10/6 Raker Broach	914430
				12/8 Raker Broach	914435

## Tri-Temp Hard Edge Hard Back

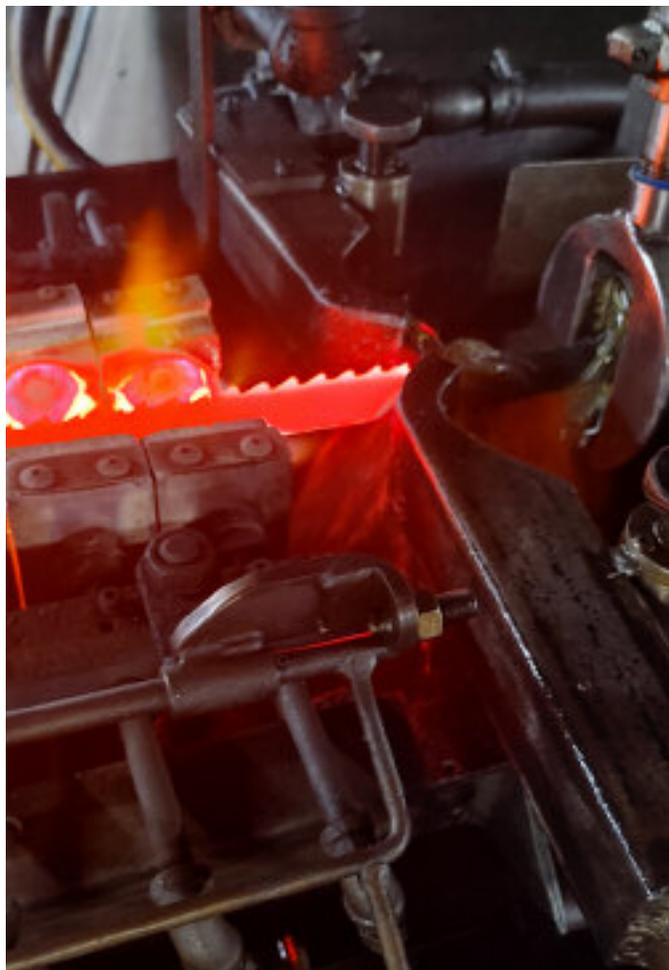
Light duty production blade. Use where additional beam strength is beneficial. Not recommended for band speeds over 4,000 surface feet per minute.

### Applications

- Tool room cutting
- Mild steel cutting
- Economy blade

### Features & Benefits

- Special heat treating process
- Spring tempered hardness on tooth edge and back
- Available in a variety of tooth forms



## Carbon Hard Edge Flex Back

Light duty production blade for easy to machine materials.

### Applications

- Hobby and production wood working
- Cabinet shops
- Furniture manufacturing
- Aluminum, brass and other soft materials
- Wet ice and dry ice
- Straight, contour and resawing

### Features & Benefits

- Tooth hardness Rc 64-65
- Teeth are flame hardened for durability
- Flexible body to run at high speeds
- Available in skip, hook and constant tooth forms



Width & Thickness		T.P.I.	Set	Style	Item No.				
Inches	MM								
3/16"	.025	4.8	.64	4 Raker Skip	911012				
				10 Raker Constant	911015				
				14 Raker Constant	911020				
1/4"	.025	6.4	.64	4 Raker Hook	911035				
				6 Raker Skip	911050				
				6 Raker Hook	911045				
				10 Raker Constant	911055				
				14 Raker Constant	911065				
				18 Raker Constant	911070				
3/8"	.025	9.5	.64	3 Raker Hook	911095				
				4 Raker Skip	911110				
				4 Raker Hook	911105				
				6 Raker Hook	911115				
				10 Raker Constant	911125				
				14 Raker Constant	911130				
1/2"	.025	12.7	.64	3 Raker Hook	911180				
				4 Raker Skip	911195				
				4 Raker Hook	911190				
				4 Raker Hook	911192**				
				6 Raker Hook	911200				
				6 Raker Constant	911205				
				10 Raker Constant	911210				
				14 Raker Constant	911220				
				18 Raker Constant	911230				
				24 Wavy Constant	911235				
				5/8"	.032	16	.80	4 Raker Hook	911270
								10 Raker Constant	911285
3/4"	.032	19	.80	2 Raker Hook	911295				
				3 Raker Hook	911300				
				4 Raker Hook	911310				
				6 Raker Hook	911320				
				6 Raker Constant	911325				
				8 Raker Constant	911330				
				10 Raker Constant	911335				
				14 Raker Constant	911355				
1"	.035	25.4	.90	3 Raker Hook	911385				
				6 Raker Constant	911395				
				10 Raker Constant	911405				
1-1/4"	.042	31.8	1.07	3 Raker Hook	911427				

\*\* Heavy Set



Width & Thickness Inches      MM		T.P.I.	Set	Style	Item No.
1/2"	.032	12.7	.80	10 Raker Constant	917000
				14 Raker Constant	917003
1"	.035	25.4	.90	8 Raker Constant	917019
				10 Raker Constant	917021

Width & Thickness Inches      MM		T.P.I.	Set	Style	Item No.
1/4"	.032	6.4	.80	4 Raker Hook	916000
3/8"	.032	9.5	.80	2 ETS Hook	916008
				3 Raker Hook	916010
				3 ETS Hook	916012
				4 Raker Hook	916015
1/2"	.032	12.7	.80	2 ETS Hook	916019
				3 ETS Hook	916020
				4 Raker Hook	916025

**Straight and contour cutting of wood, flake board, plastic and nonferrous materials.**

Width & Thickness Inches      MM		T.P.I.	Set	Style	Item No.
3/8"	.025	9.5	.64	3 ETS Hook	918000
1/2"	.025	12.7	.64	4 ETS Hook	918009

- Available in "Every Tooth Set" configuration for rapid cutting in all types of wood

## Friction

### For Friction Cutting Only

Friction cutting is accomplished by running the band saw blade at high speeds (8,000 to 15,000 SFPM), creating high frictional heat which allows the band to melt its way through the workpiece.

## Applications

- Ferrous metals
- Sheet metals and light plate
- Thin wall aircraft tubing and structurals
- Cut thin and odd shaped exotic materials
- Super alloys

## Features & Benefits

- Made of special silicon carbon steel
- Good abrasion resistance and fatigue life
- Oxygenated tooth design

## X-tra Duty .032

### Hard Edge Flex Back

**Heavy gauge for additional beam strength.**

## Applications

- Hobby wood working
- Cabinet shops
- Furniture manufacturing
- High production wood manufacturing
- Straight, contour and resawing

## Features & Benefits

- Tooth hardness Rc 64-65
- .032 Gauge body for additional strength and rigidity
- Teeth and back edge flame hardened for durability
- Flexible body to run at high speeds
- Available in raker and "Every Tooth Set" hook tooth

## Every Tooth Set (ETS)

### Carbon

## Applications

- Hobby wood working
- Cabinet shops
- Furniture manufacturing
- High production wood manufacturing
- Straight, contour and resawing

## Features & Benefits

- Tooth hardness Rc 64-65
- Teeth and back edge flame hardened for durability
- Flexible body to run at high speeds

## Timber Master TK™

### Blade Stock for Stationary and Portable Wood Mill Applications

PRODUCTION WOOD WORKING • RESAWING • PORTABLE BAND MILLS

#### Timber Master TK™ CT Carbide Tipped

Width & Thickness		T.P.I.	Set	Item No.
Inches	MM			
1-1/2"	.050 41	1.27	1.7/1 Triple Chip	943133
2"	.062 54	1.60	1.7/1 Triple Chip	943172

#### Features & Benefits

- Precision ground carbide teeth provide long life with excellent finish
- Flexible backer to resist fatigue
- Welded tip, not soldered for strength
- Works especially well in hardwoods

#### Timber Master TK™ B Bi-Metal

Width & Thickness		T.P.I.	Set	Style	Item No.
Inches	MM				
1-1/4"	.042 34	1.07	1 Raker	Hook	925310
			1.2 Raker	Hook	923305
1-1/2"	.050 41	1.27	1 Raker	Hook	925320
2"	.050 54	1.27	1 Raker	Hook	925329
2"	.063 54	1.60	1 Raker	Hook	925330

#### Features & Benefits

- M42 bi-metal with Rc 68-69 tooth
- Good for hard and soft wood

#### Timber Master TK™ Pro Cut™

Width & Thickness		T.P.I.	Set	Style	Item No.
Inches	MM				
1"	.035 27	.90	1.3 Raker	Hook	913104
			2 Raker	Hook	913106
1"	.042 27	1.07	1.2 Raker	Hook	913110
			1.3 Raker	Hook	913112
1-1/4"	.042 34	1.07	1 Raker	Hook	913116
			1.2 Raker	Hook	913118
			1.2 Raker	Hook	913119**
			1.3 Raker	Hook	913121
1-1/2"	.050 41	1.27	1 Raker	Hook	913125
			1.2 Raker	Hook	913127
			1.2 Raker	Hook	913129**
2"	.050 54	1.27	1 Raker	Hook	913134
			1.2 Raker	Hook	913136

\*\* Heavy Set



#### Features & Benefits

- Flexible backer to resist fatigue
- Full hardened tooth provides for several sharpenings

## Pallet Slayer™

Premium pallet reclaim product produced with high chromium and hardened tool steel. Unique atmospheric cryo process to provide greater performance.

Width & Thickness Inches      MM		T.P.I.	Set	Style	Item No.
1-1/4	.042	34	1.07	6 Raker Constant	915010
				8/5 Raker Broach	915015

### Applications

- Pallet disassembly

### Features & Benefits

- Rc 50-55 full hard teeth
- Hard edge, hard back



## Pallet Reclaim C Carbon

Width & Thickness Inches      MM		T.P.I.	Set	Style	Item No.
1-1/4	.042	34	1.07	8/5 Wavy Broach	914443
				8/5 Raker Broach	914450

### Applications

- Pallet disassembly

### Features & Benefits

- Rc 64-65 full hard teeth
- Hard edge, hard back

## Safety Tip

### Bi-Metal Reciprocating Blade

Length	Width	Thkns	T.P.I	Item no.
8	3/4"	.035	18	46920

### Applications

- Pallet disassembly

### Features & Benefits

- Rounded tip for added protection in pallet repair operations
- Packaged 50 per box

## Super Sterling® Heavy Duty Oil-Free Synthetic Sawing Fluid

Super Sterling® is a State-of-the-Art heavy duty oil-free coolant designed to replace soluble oil in production sawing of all metals except magnesium. This product is excellent on aluminum. The coolant contains a remarkable package of EP additives and corrosion inhibitors which offer outstanding performance without the mess and disposal concerns of soluble oil coolants. Super Sterling® works on all sawing applications including cutoff, band, power hacksaw, reciprocating, etc. This product may be used on ferrous and nonferrous metals. It is available in a variety of packaging options.

**5 Gallon Container**  
Item No. 10800

**4 (1-Gallon) Containers**  
Item No. 10805

**55 Gallon Drum**  
Item No. 10807

**Sterling® Mist Unit**  
Item No. 10810

For use with Super Sterling® oil free synthetic sawing fluid. Unit requires 50 to 100 PSI air supply and delivers up to one gallon per minute (Instructions and replacement parts list included).

## Knife Edge

Spring tempered carbon steel Knife Edge bands are produced for cutting soft and fibrous materials that would fray or tear if cut with a conventional tooth type band. If you do not see your desired blade specification, call and ask for availability.

### Straight Knife Single Edge

Width & Thickness	Item No.
3/8" x .020	950102
3/8" x .025	950104
1/2" x .020	950106
1/2" x .032	950108
3/4" x .020	950112
1" x .020	950114
1" x .032	950116
1-1/4" x .020	950118

### 'V' Toothed Knife Single Edge

Width & Thickness	T.P.I	Item No.
1/2" x .020	10	950404
1/2" x .032	10	950406
5/8" x .022	10	950408
3/4" x .020	10	950410
3/4" x .020	14	950411
3/4" x .032	10	950412
1" x .020	10	950414
1" x .020	14	950415

### Features & Benefits

- Produces little downward drag resulting in no tearing during the cut and producing an excellent finish
- Run at speeds of 2000 - 8000 SFPM depending upon material

### Applications

#### Single Edge

- Cutting foam, food, plastics, rubber, fabric, sponges, fiberglass insulation and filter material

#### Double Edge

- Bi-directional cutting of foam, plastics, rubber, fabric, plastic film, food and filter material

### Scalloped Single Wavy Edge

Width & Thickness	Item No.
3/8" x .020	950300
1/2" x .020	950302
1/2" x .032	950304
5/8" x .022	950306
3/4" x .020	950308
3/4" x .032	950310
1" x .020	950312
1" x .032	950314

### 'V' Toothed Knife Double Edge

Width & Thickness	T.P.I	Item No.
1/2" x .020	14	950505
5/8" x .022	14	950509
3/4" x .020	10	950510
1" x .020	10	950514
1" x .020	14	950515

## Band Saw Blade Accessories & Tools

### Tachometer

Item No. 10012

Contact digital tachometer for measuring RPM and bandsaw blade speed surface feet per minute. Maximum contact speed is 6560 SFPM (Instructions included).

### Tension Meter

Item No. 10006

For use on band saw blades and/or power hack saw blades. The tension meter checks for proper blade tension ensuring straighter cutting and longer blade life. The dial indicator provides you with a direct readout in P.S.I. (Instructions included).

### Refractometer

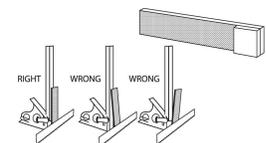
Item No. 10017

This industrial refractometer with case has a 0-18 Brix analog scale to determine the concentration of Super Sterling® and other industrial fluids (Instructions included).

### Magnetic Guide Alignment Tool

Item No. 10010

The blade alignment tool is used to check and make sure the saw blade is square to the cut. This will improve your cutting accuracy (Instructions included).





Diamond edged air, jig and reciprocating saw blades are for use on various composites and hard friable materials such as quartz, glass, fiberglass, carbon graphite and ceramics.

## Universal 1/4", "T" and Reciprocating Shank Styles

Length	Width	Thkns	Grit	Shank	Item no.
5"	1/2"	.025	40/50	Air Saw	12700
3-1/2"	1/4"	.042	40/50	1/4" Univ	82700
6"	3/4"	.035	40/50	Recip	46700

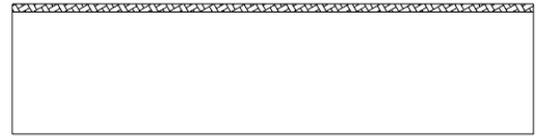
Packaged 1 per vinyl pouch

## Band Saw Blue Diamond Collection

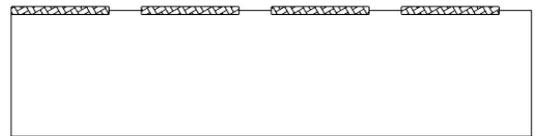
Diamond edge bands will provide high cutting rates with minimal material loss. Finish quality can help eliminate expensive secondary operations.

Width & Thickness		Style	Item No.
Inches	MM		
1/2"	.020	Continuous	960100
	.025	Segmented	960105
1/2"	.025	4P Gulleted	960110
	.020	Continuous	960115
3/4"	.020	Segmented	960120
	.032	4P Gulleted	960125
1"	.020	Continuous	960130
	.025	Segmented	960135
1"	.025	Continuous	960140
	.035	Segmented	960145
1"	.035	4P Gulleted	960150
	.040	Continuous	960155
1"	.040	Segmented	960160
	.040	Continuous	960165
1-1/4"	.025	Segmented	960170
	.025	Continuous	960175
1-1/4"	.040	Continuous	960180
	.040	Segmented	960185
1-1/4"	.040	Continuous	960190
	.042	4P Gulleted	960195
1-1/2"	.040	Continuous	960200
	.040	Segmented	960205

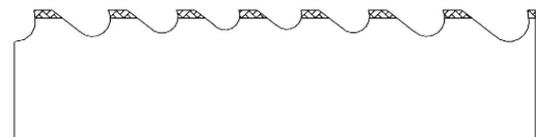
Continuous Edge



Segmented Edge



4P Gulleted Edge



## Applications

- For cutting carbon, graphite, fiberglass, ceramics, stones, granite, and etc.

## Features & Benefits

- Made from a special silicon hardened steel
- Can be run at speeds of 2,200 to 2,500 SFPM
- Available in 25/35, 35/40, 40/50, 60/80, 80/100 blended grit sizes
- Available in welded to length only



## Universal 1/2" Metal Cutting

Item No.	Length	Width	ThKns	T.P.I.	Recommended Uses
40610	6"	3/4"	.035	10	For metal decking, roofing, and nonferrous metals.
40810	8"	3/4"	.035	10	
40010	6"	3/4"	.050	10	For cutting soil pipe and heavy gauge metal and nail-embedded wood.
40640	6"	3/4"	.035	14/10	Heavy gauge metals, compositions, masonite, wood, etc.
40840	8"	3/4"	.035	14/10	
40120	12"	3/4"	.035	14/10	
40040	6"	3/4"	.050	14/10	For cutting soil pipe and heavy gauge metal.
40080	8"	3/4"	.050	14/10	
40414	4"	3/4"	.035	14	For metals heavier than 1/8", bar stock, angles, etc. Also rubber, masonite, fiberglass, etc.
40614	6"	3/4"	.035	14	
40814	8"	3/4"	.035	14	
40014	6"	3/4"	.050	14	For cutting soil pipe and heavy gauge metal.
40418	4"	3/4"	.035	18	For heavy gauge sheet metal, conduit, pipe, tubing, thin fiberglass, etc.
40618	6"	3/4"	.035	18	
40818	8"	3/4"	.035	18	
40018	6"	3/4"	.050	18	For conduit, angle iron and heavy gauge metal up to 1/4".
39684	6"	3/4"	.035	18/14	Graduated teeth for fast cuts in metals heavier than 3/32", bar stock, angles, pipe. Also fiberglass and fiber.
40424	4"	3/4"	.035	24	For metals lighter than 18 gauge thin wall tubing, formed sheet, trim, etc.
40624	6"	3/4"	.035	24	
40432	4"	3/4"	.035	32	For very thin gauge metals, sheet, tubing, trim, etc.

Packaged 5 per vinyl pouch or 50 per box



## Fire & Rescue



Item No.	Length	Width	ThKns	T.P.I.	Recommended Uses
40911	8"	3/4"	.050	14/10	For fire and rescue work.
46911	9"	1"	.062	12/8	

Packaged 2 per vinyl pouch or 50 per box

## Ruff Neck™ Demolition Blades

Item No.	Length	Width	ThKns	T.P.I.	Recommended Uses
46685	6"	1"	.062	8/5	For demolition work, remodeling, wood, wallboard, paneling, plaster, nail-embedded wood.
46985	9"	1"	.062	8/5	
46185	12"	1"	.062	8/5	
46190	12"	1"	.062	3	Fastest cutting, roughing-in work in wood.
46706	6"	1"	.062	12/8	Wavy set for nail-embedded wood, metal lath, thin steel plate and metal demolition work.
46906	9"	1"	.062	12/8	

Packaged 2 per vinyl pouch or 50 per box.

## Pipe Cutting

Item No.	Length	Width	ThKns	T.P.I.	Recommended Uses
42210	8"	3/4"	.050	18	Automotive applications; mufflers and exhaust systems. Also performs well in general tubing and pipe applications.

Packaged 2 per vinyl pouch or 50 per box.

## Metal Scroll Cutting

Item No.	Length	Width	ThKns	T.P.I.	Recommended Uses
43114	3-5/8"	5/16"	.035	14	For scroll cutting heavy gauge metal, fiberglass, masonite.
42018	3"	1/4"	.035	18	For scroll cutting metals lighter than 14 gauge.

Packaged 5 per vinyl pouch or 50 per box.

## Wood & Plaster Cutting

Item No.	Length	Width	ThKns	T.P.I.	Recommended Uses
45004	6"	TAPER	.050	4	Fast cutting, positive rake design with wide gullet spacing for roughing-in.
45606	6"	3/4"	.035	6	For wood and nail-embedded woods, all composition material. Also nonferrous metals.
45006	6"	TAPER	.050	6	General roughing-in work in wood and nail-embedded woods. Fast cutting.
45906	9"	TAPER	.050	6	
45106	12"	TAPER	.050	6	
45110	12"	TAPER	.050	10	For thinner sections of wood, plastics, metals 1/8" and under, where extra blade length is required.
52056	5"	3/4"	.035	6 V-TTH	PLASTER CUTTING - For smooth, fast cuts in plaster, plasterboard and metal lath plaster.

Packaged 5 per vinyl pouch or 50 per box.



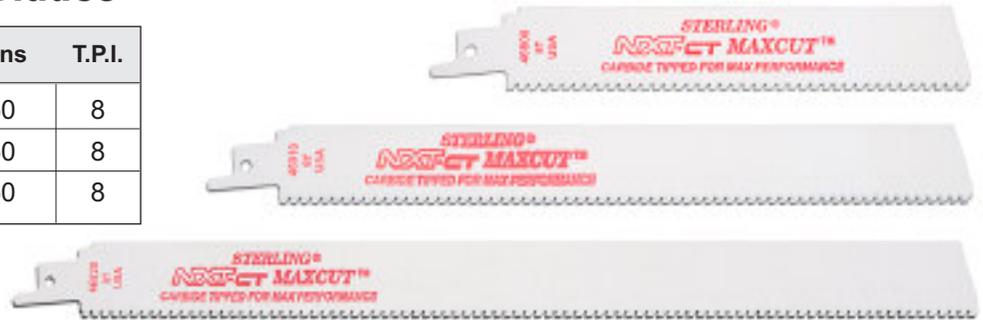
## Carbide Tipped

These blades are meant for the toughest applications. Their wide heavy gauge construction, combined with the durability of carbide tipped teeth, insure maximum performance in heavy gauge steel, angle, channel, flat stock and more.

### NXT-CT™ MAXCUT™ Blades

Item No.	Length	Width	ThKns	T.P.I.
46800	6"	1"	.050	8
46810	9"	1"	.050	8
46820	12"	1"	.050	8

Packaged 1 per vinyl pouch.



### Slik-Kote™ Collection

A special treatment and coating results in a hard abrasion resistant surface that adds to the cutting life of the blade. Especially recommended for fiberglass and other abrasive applications. Also effective on metals, including stainless steel.

#### All Jig Saw and Reciprocating Shank Styles

Item No.	Length	Width	ThKns	T.P.I.	Shank Type
82040	3-1/2"	5/16"	.042	10	UNIV. 1/4"
82041	3-1/2"	5/16"	.042	14	
80148	3"	3/8"	.035	14	BAYONET
88266	4"	5/16"	.042	8	"T" STYLE
88269	3"	5/16"	.042	12	
41666	6"	TAPER	.050	6	RECIP.
41679	9"	TAPER	.050	6	
41668	6"	3/4"	.035	10	
41670	6"	3/4"	.035	14	

Universal, Bayonet and "T" style blades are packaged 5 per vinyl pouch or 100 per box. Reciprocating blades are packaged 5 per vinyl pouch or 50 per box.



### Glas-Fab™ Collection

#### All Jig Saw Shank Styles

Item No.	Length	Width	ThKns	T.P.I.	Shank Type
82032	3-1/2"	5/16"	.050	2-WAY	UNIV. 1/4"
87072	4"	5/16"	.050	2-WAY	"T" STYLE

Packaged 5 per vinyl pouch or 100 per box.





## Carbide Grit Collection - Imported

For abrasive cutting in cast iron, ceramic tile, clay pipe, fiberglass, plaster and brick. Grit provides a smooth cut and will not snag.

### All Jig Saw and Reciprocating Shank Styles



Item No.	Length	Width	ThKns	Grit	Shank Type
30042	2-7/8"	5/16"	.032	MEDIUM	UNIV. 1/4"
30040	2-7/8"	5/16"	.032	COARSE	UNIV. 1/4"
36201	3"	5/16"	.032	MEDIUM	T-STYLE
36402	3"	5/16"	.032	COARSE	T-STYLE
51400	4"	3/4"	.040	COARSE	RECIP
51800	8"	3/4"	.040	COARSE	RECIP

Packaged 5 blades per vinyl pouch.

## Jig Saw Blades Universal "T" Style



### Metal Cutting

Item No.	Length	Width	ThKns	T.P.I.	Recommended Uses
86260	4"	5/16"	042	8	Mild steel 1/4" - 3/8". Nonferrous 1/4" - 5/8", laminates and plastics. 5/16" width for tight contours in metal, wood, etc.
86263	3"	5/16"	042	12	Mild steel 1/8" - 1/4". Nonferrous 1/8" - 5/8", laminates and reinforced plastics. 5/16" width for tighter contours in metal, wood, etc.
86264	3"	5/16"	.042	18	Mild steel up to 3/16". Nonferrous up to 1/4" and laminates. 5/16" width for tighter contours in metal, wood, etc.
86267	3"	5/16"	042	24	Thin wall tubing and metal under 1/8".

Packaged 5 per vinyl pouch or 100 per box.



### Wood Cutting

Item No.	Length	Width	ThKns	T.P.I.	Recommended Uses
87073	4"	5/16"	.050	10	For smooth cuts in hard and soft wood, plywood up to 3-1/4", also plastics. 5/16" width for tighter contours in wood, metal etc. Hollow Ground.
87077	4"	5/16"	.050	10 DOWN CUT	Reversed tooth direction for down cutting. Reduces top splintering and chipping. Hollow Ground.

Packaged 5 per vinyl pouch or 100 per box.

## Jig Saw Blades **Universal 1/4" Style**



### Metal Cutting

Item No.	Length	Width	ThKns	T.P.I.	Recommended Uses
82050	3-1/2"	5/16"	.042	10	1/4" - 1/2" steel; 1/4" - 3/4" nonferrous (aluminum, thick masonite, fiberglass, etc.).
82051	3-1/2"	5/16"	.042	14	1/8" - 1/4" steel; 1/8" - 1/2" nonferrous (aluminum, fiberglass, plastics, etc.).
82052	3-1/2"	5/16"	.042	18	1/16" - 1/8" steel, conduit, plastics, tubing, etc.
82053	3-1/2"	5/16"	.042	24	1/16" steel and under, thin wall tubing, formica, etc.

Packaged 5 per vinyl pouch or 100 per box.



### Wood Cutting

Item No.	Length	Width	ThKns	T.P.I.	Recommended Uses
82021	3-1/2"	1/4"	.035	6	Positive rake for roughing-in and scroll cuts up to 1/2" in wood, plywood, hardwood, plastics, etc.
82022	3-1/2"	1/4"	.035	10	Smoother finish and scroll cuts in wood, plywood, hardwood, plastics, and laminates up to 1/2".
82008	4"	3/8"	.035	6	Long life in wood cutting, laminates, composites, etc.
82011	4"	3/8"	.035	10	Fine set teeth for finish cuts in wood, plywood, plastics, masonite, brass and aluminum.

Packaged 5 per vinyl pouch or 100 per box.

## Jig Saw Blades **Bayonet Style**



### Metal Cutting

Item No.	Length	Width	ThKns	T.P.I.	Recommended Uses
80112	3"	3/8"	.035	14	1/8" - 1/4" steel; 1/8" - 1/4" nonferrous and laminates.
80113	3"	3/8"	.035	24	Thin sheet steel, thin wall tubing and thin nonferrous.
80114	1-3/4"	1/4"	.035	14	1/8" - 1/4" steel, 1/8" - 3/8" nonferrous, suitable for scroll work.
80115	1-3/4"	1/4"	.035	24	Thin sheet steel, thin wall tubing, suitable for scroll work.

Packaged 5 per vinyl pouch or 100 per box.



## Slik-Kote Pneu-Saw™ Blades

A special treatment and coating results in a hard abrasion resistant surface that adds to the cutting life of the blade. Especially recommended for fiberglass and other abrasive applications. Also effective on metals, including stainless steel.

Item No.	Length	Width	ThKns	T.P.I.
12718	3-5/8"	1/2"	.025	18
12724	3-5/8"	1/2"	.025	24
12732	3-5/8"	1/2"	.025	32

Packaged 5 per vinyl pouch or 100 per box



## Pneu-Saw™ Blades

For applications in automotive repair work and sheet metal work. Shatter resistant bi-metal blades.

**Fits all standard air saws**

Item No.	Length	Width	ThKns	T.P.I.	Recommended Uses
12510	3-5/8"	1/2"	.025	10	For scroll cuts in heavy metal, composites, fiberglass, plastics.
12514	3-5/8"	1/2"	.025	14	For scroll cutting heavy gauge metal, fiberglass.
12614	5"	1/2"	.025	14	
12518	3-5/8"	1/2"	.025	18	For scroll cutting metals lighter than 14 gauge.
12618	5"	1/2"	.025	18	
12524	3-5/8"	1/2"	.025	24	For scroll cutting metals lighter than 18 gauge, thin tubing, formed sheet, trim, etc.
12624	5"	1/2"	.025	24	
12532	3-5/8"	1/2"	.025	32	For scroll cutting very thin gauge metals, sheet, tubing, trim, etc.

Packaged 5 per vinyl pouch or 100 per box.

**Fits Nitto Kohki air saws**

Item No.	Length	Width	ThKns	T.P.I.	Recommended Uses
13014	4"	TAPER	.035	14	For metal heavier than 1/8", bar stock, angles, etc. Also rubber, masonite, fiberglass, etc.
13018	4"	TAPER	.035	18	For heavy gauge sheet metal, conduit pipe, tubing, thin fiberglass.
13024	4"	TAPER	.035	24	For metals lighter than 18 gauge, thin wall tubing, formed sheet, trim, etc.
13032	4"	TAPER	.035	32	For very thin gauge metals, sheet, tubing, trim, etc.

Packaged 5 per vinyl pouch or 100 per box.



## Carbide Tipped Circular Saw Blades - Imported

### Ferrous and Nonferrous Blades

Item No.	Description	Arbor	RPM	Grade
10700	7-1/4" x 36T TCG Saw Blade (Fer)	*5/8"	5800	C-6
10705	8" x 48T TCG Saw Blade (Fer)	*5/8"	5800	C-6
10707	9" x 48T TCG Saw Blade (Fer)	1"	5200	C-6
10715	12" x 100T TCG Saw Blade (Fer)	1"	2000	C-6
10720	14" x 120T TCG Saw Blade (Fer)	1"	1700	C-6

Packaged 1 per box

\*Diamond Arbor

- Cuts with fewer burrs and less heat than abrasive blades
- No need for secondary finish grinding
- Modified triple chip grind resists material build up on the tooth allowing longer life between re-sharpening

### Wood Cutting Blades

Item No.	Description	Arbor	RPM	Grade
10750	7-1/4" x 24T ATB Saw Blade	*5/8"	7000	C-2
10755	7-1/4" x 40T ATB Saw Blade	*5/8"	7000	C-2
10765	10" x 40T ATB Saw Blade	5/8"	7000	C-3
10775	10" x 80T ATB Saw Blade	5/8"	7000	C-3

Packaged 1 per box

\*Diamond Arbor



- Alternate tooth bevel grind for fast clean cuts

### Dado Sets

Item No.	Description	Arbor	RPM	Grade
10790	6" X 30T Stack Dado Set	5/8"	7000	C-4

Packaged 1 per box

- Bevel ground outside saws and chipper sets
- Stay sharp longer even when cutting man made materials

## Power Hacksaw Blades Bi-Metal Shatterproof

### Porta-Hack™

Fits Fein, Widder and other portable reciprocating hacksaw machines.

Item No.	Length	Width	ThKns	T.P.I.
10906	12"	1-1/4"	.062	14
10907	16"	1-1/4"	.062	14
10929	16"	1-1/4"	.062	8
10930	21"	1-1/4"	.062	14
10973	24"	1-1/4"	.062	14
10975	30"	1-1/4"	.062	14

- Portable hacksaw
- Used for job-site cutting of pipe, structurals and other materials
- Packaged 10 blades per box



## Power Hacksaw Blades Bi-Metal-Shatterproof - Imported

Item No.	Length	Width	ThKns	T.P.I.
10304	12"	1"	.050	14
10316	14"	1"	.050	14
10320	14"	1-1/4"	.062	6
10324	14"	1-1/4"	.062	10
10340	14"	1-1/2"	.075	6
10380	18"	1-1/4"	.062	10
10392	18"	1-1/2"	.075	4
10396	18"	1-1/2"	.075	6
10412	18"	1-3/4"	.088	6
10428	21"	1-3/4"	.088	6
10456	24"	2"	.100	4

Packaged 10 per box



- Shatterproof power hacksaw
- Strong, shatter-resistant for high productivity and safety
- Extra wide blade gives rigidity and durability

## Hand Hacksaw Frames (with blade) Item No.10022 High Tension Frame

- Blades can be mounted straight or at a 45 degree angle for flush cutting
- Packaged 5 per box



## Hand Hacksaw Blades Bi-Metal-Shatterproof



Item No.	Length	Width	ThKns	T.P.I.	Recommended Uses
10077	12"	1/2"	.025	14	For metals heavier than 1/4" , heavy angles, beams, rails, and for soft materials where maximum chip clearance is needed.
10079	12"	1/2"	.025	18	For metals 3/16" - 3/8" , medium weight angles, channels, drill rod, machine steel, small solid stock etc., general shop use when cutting a variety of jobs.
10081	12"	1/2"	.025	24	For metals 1/8" - 1/4" , pipe, heavy tubing, light angles and channels, large wires, small drill rod, heavy gauge sheet metal.
10083	12"	1/2"	.025	32	For metals thinner than 3/16" , thin wall tubing, light sheet metal, and for hard or brittle materials.
10073	12"	1/2"	.025	18/14	A versatile varied pitch blade for cutting a wider range of materials and cross sections from 1/4" - 3/4".
10075	12"	1/2"	.025	24/20	Varied pitch for ease and efficiency of cutting. Use on sections 3/16" - 3/8" thin wall tubing, sheet metal, etc.

Packaged 5 per vinyl pouch or 100 per box.

- Shatter resistant bi-metal construction allows blade to bend & flex
- High hardness provides extended tool life

## PVC/ABS Plastic Pipe Saw Blades Spring Tempered Carbon Steel

- Spring tempered to resist flexing
- 63-66 Rc hardness
- Cuts plastic, wood, drywall, PVC and ABS pipe
- Packaged 5 per box

Item No.	Length	Width	ThKns	T.P.I.
70130	12"	2-1/2"	.035	10
70180	18"	2-1/2"	.035	10
70131	12"	WITH HANDLE		
70181	18"	WITH HANDLE		

## Bi-Metal Varied Pitch

Item No.	Diameter	
	Inches	MM
55009	9/16	14
55010	5/8	16
55011	11/16	17
55012	3/4	19
55013	13/16	21
55014	7/8	22
55015	15/16	24
55016	1	25
55017	1-1/16	27
55018	1-1/8	29
55019	1-3/16	30
55020	1-1/4	32
55021	1-5/16	33
55022	1-3/8	35
55023	1-7/16	37
55024	1-1/2	38
55025	1-9/16	40
55026	1-5/8	41
55027	1-11/16	43
55028	1-3/4	44
55029	1-13/16	46
55030	1-7/8	48
55032	2	51
55033	2-1/16	52
55034	2-1/8	54
55036	2-1/4	57
55037	2-5/16	59
55038	2-3/8	60
55040	2-1/2	64
55041	2-9/16	65
55042	2-5/8	67
55044	2-3/4	70
55046	2-7/8	73
55048	3	76
55050	3-1/8	79
55052	3-1/4	83
55054	3-3/8	86
55056	3-1/2	89
55058	3-5/8	92
55060	3-3/4	95
55062	3-7/8	98
55064	4	102
55066	4-1/8	105
55068	4-1/4	108
55070	4-3/8	111
55072	4-1/2	114
55076	4-3/4	121
55080	5	127
55088	5-1/2	140
55092	5-3/4	146
55096	6	152

## Carbide Tipped Imported

Item No.	Diameter	
	Inches	MM
56012	3/4	19
56013	13/16	21
56014	7/8	22
56015	15/16	24
56016	1	25
56017	1-1/16	27
56018	1-1/8	29
56020	1-1/4	32
56022	1-3/8	35
56023	1-7/16	37
56024	1-1/2	38
56025	1-9/16	40
56026	1-5/8	41
56027	1-11/16	43
56028	1-3/4	44
56030	1-7/8	48
56032	2	51
56033	2-1/16	52
56034	2-1/8	54
56036	2-1/4	57
56038	2-3/8	60
56040	2-1/2	64
56042	2-5/8	67
56044	2-3/4	70
56046	2-7/8	73
56048	3	76
56050	3-1/8	79
56052	3-1/4	83
56054	3-3/8	86
56056	3-1/2	89
56058	3-5/8	92
56060	3-3/4	95
56062	3-7/8	98
56064	4	102
56066	4-1/8	105
56068	4-1/4	108
56070	4-3/8	111
56072	4-1/2	114
56076	4-3/4	121
56080	5	127
56088	5-1/2	140
56092	5-3/4	146
56096	6	152

## Blue Diamond™

Item No.	Diameter	
	Inches	MM
54100	9/16	14
54105	5/8	16
54110	11/16	17
54115	3/4	19
54120	13/16	21
54125	7/8	22
54130	15/16	24
54135	1	25
54140	1-1/16	27
54145	1-1/8	29
54150	1-3/16	30
54155	1-1/4	32
54160	1-5/16	33
54165	1-3/8	35
54170	1-7/16	37
54175	1-1/2	38
54180	1-9/16	40
54185	1-5/8	41
54190	1-11/16	43
54195	1-3/4	44
54200	1-13/16	46
54205	1-7/8	48
54210	2	51
54215	2-1/16	52
54220	2-1/8	54
54225	2-1/4	57
54230	2-5/16	59
54235	2-3/8	60
54240	2-1/2	64
54245	2-9/16	65
54250	2-5/8	67
54255	2-3/4	70
54260	2-7/8	73
54265	3	76
54270	3-1/8	79
54275	3-1/4	83
54280	3-3/8	86
54285	3-1/2	89
54290	3-5/8	92
54295	3-3/4	95
54300	3-7/8	98
54305	4	102
54310	4-1/8	105
54315	4-1/4	108
54320	4-3/8	111
54325	4-1/2	114
54330	4-3/4	121
54335	5	127
54340	5-1/2	140
54345	6	152

Depth of cut: 1-5/8"  
for all sizes

Packaged 1 per box

## Bi-Metal Varied Pitch

- High Hardness teeth
- Varied pitch
- Positive rake teeth

## Carbide Tipped Imported

- Best suited for use in fiberglass, flake board & cast iron

## Blue Diamond™

- Bi-metal matrix steel
- 40/50 blended diamond grit nickel matrix braze bonded edge
- Best suited for use in abrasive, non-ferrous materials



## Arbors with High Speed 1/4" Pilot Drills - Imported

Item No.	Fits Hole Saws (Diameter)	Follows Through	Shank	Thread Size	Chuck Size
57015	9/16" - 1-3/16"	1" - 1-3/16"	1/4" Hex	1/2-20	1/4"
57016	9/16" - 1-3/16"	1" - 1-3/16"	3/8" Hex	1/2-20	3/8"
57018	9/16" - 1-3/16"	7/8"- 1-1/2"	7/16" Hex	1/2-20	1/2"
57020	1 1/4" - 2-3/8"	1-1/4"-2-3/8"	7/16" Hex	5/8-18	1/2"
57045*	1 1/4" - 6"	1-7/16" - 6"	7/16" Hex	5/8-18	1/2"

Packaged 1 per box

\*Quick change design, with knurled collar.

## Extra 1/4" Pilot Drills & 12" Extension - Imported

Item No.	Description
54500	3" Brazed diamond pilot drill for use with Blue Diamond Saws
57035	Pilot drill for use with 1/4" Rd., 7/16" Hex and 5/8" Hex, Length 4", 2/pkg.
57036	Pilot drill for use with 1/4" Hex and 3/8" Hex, Length 3", 2/pkg.
57100	12" Extension for 7/16" Hex shank, 1/pkg.

## Arbor Adaptor - Imported

Item No.	Description
57000	Converts 1/2"-20 threaded arbors ( 57015, 57016, 57018) to 5/8"-18 threaded size to accommodate larger diameter saws, 2/pkg.

## Hole Saw Kits

### Bi-Metal Pro Pack Hole Saw Kit

Item No.	Description
57515	Contains 1 each of the following hole saws: 3/4", 7/8", 1-1/8", 1-3/8", 1-1/2", 1-3/4", 2", 2-1/4" & 2-1/2". 1 each of the following arbors: (57014) 1/4" round, (57045*) 7/16" hex, one (1) additional (57035) 1/4" pilot drill, and one (1) (57000) arbor adaptor.

### Bi-Metal Plumber's Hole Saw Kit

Item No.	Description
57528	Contains 1 each of the following hole saws: 3/4", 7/8", 1-1/8", 1-1/2", 1-3/4", 2-1/4". 1 each of the following arbors: (57014) 1/4" round, (57045*) 7/16" hex, one (1) additional (57035) 1/4" pilot drill.

### Bi-Metal Electrician's Hole Saw Kit

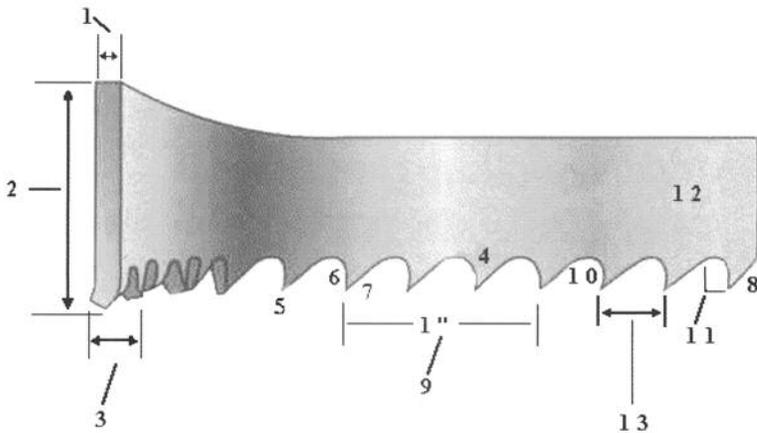
Item No.	Description
57527	Contains 1 each of the following hole saws: 7/8", 1-1/8", 1-3/8", 1-3/4", 2, & 2-1/2". 1 each of the following arbors: (57018) 7/16" hex, (57045*) 7/16" hex, and one (1) additional (57035) 1/4" pilot drill.

### Carbide Tipped Hole Saw Kit - Imported

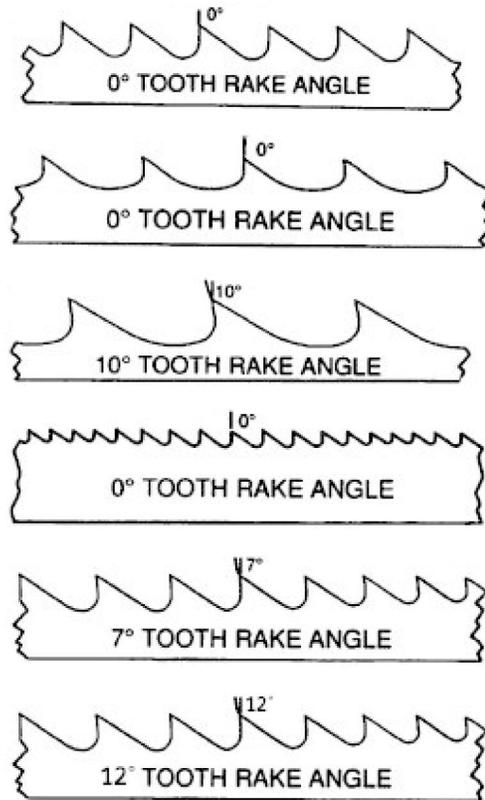
Item No.	Description
57507	Contains 1 each of the following hole saws: 3/4", 7/8", 1-1/8", 1-3/8", 1-1/2", 1-3/4", 2", 2-1/4" & 2-1/2". 1 each of the following arbors: (57014) 1/4" round, (57045*) 7/16" hex, one (1) additional (57035) 1/4" pilot drill, and one (1) (57000) arbor adaptor.

\*Quick change design, with knurled collar.

# Blade Basics



1. **Gage** - The thickness of the blade.
2. **Blade Width** - The distance from the tip of the tooth to the back edge of the blade.
3. **Set** - The bending of teeth right or left to allow clearance of the back through the cut.
4. **Tooth Back** - The surface of the tooth opposite the tooth face.
5. **Tooth Tip** - The cutting edge of the tooth.
6. **Tooth Face** - The surface of the tooth on which the chip is formed.
7. **Tooth** - The cutting portion of the saw blade.
8. **Tooth Rake Angle** - The angle of the tooth face measured to a line perpendicular to the cutting direction of the saw.
9. **T.P.I.** - The number of teeth per inch.
10. **Gullet** - The curved area at the base of the tooth.
11. **Gullet Depth** - The distance from the tooth tip to the bottom of the gullet.
12. **Blade Back** - The body of the blade not including the tooth portion.
13. **Tooth Pitch** - The distance from the tip of one tooth to the tip of the next tooth.



**Constant Pitch:** Fixed teeth per inch. Contour or cut-off work. For ferrous, non-ferrous materials.

**Skip Tooth:** Greater gullet capacity than constant pitch. Better chip clearance. For softer wood, plastics, other materials.

**Hook Tooth:** Greater gullet capacity than constant pitch. Requires less feed pressure than skip tooth. 10 degree rake angle bites into material better.

**Broach Tooth:** Varied tooth pitch. Improved blade life. Less vibration noise than constant pitch. Use for interrupted cuts, tubing and shapes.

**Posi Tooth:** Varied tooth pitch. 7, 10 and 12 degree forward rake angle. Requires less feed pressure for longer life. Excellent for sawing solids.

**Raker Set:** Pattern is one tooth left, one tooth right and third tooth unset. Allows for fast efficient cutting on both solids and thicker sections.

**Wavy Set:** Groups of teeth alternately set to left and then to right, forming a wave pattern. Excellent for thin or interrupted sections to help reduce tooth breakage or stripping.

**E.T.S.:** Every tooth is set alternately left then right, no raker tooth. For woodworking or non-ferrous metals.

# Band Saw Speed Chart

Material to Cut		Bi-Metal Band	S.F.P.M.	Cut Rate Aq. In/Min	Feed Pressure	Tool Life Sq In/Ft	Tool Life Sq In/Ft
Low Carbon	1010-1019	Matrix II	300-350	11-15	Medium/light	650-800	Free machining
Medium Carbon	1020-1050	Matrix II	190-225	7-9	Medium/light	425-700	Free machining
High Carbon	1055-1095	Matrix II	145-170	6-8	Medium	300-400	Free machining
Free Machining	1109-1113	Matrix II	300-350	12-15	Medium/light	700-850	Free machining
	1115-1213	Matrix II	200-250	8-10	Medium/light	500-750	Free machining
Manganese	1320-1340	M42/M51	175-220	6-8	Medium	330-375	Work hardening
Nickel	2015-2517	M42/M51	225-250	6-7	Medium	250-300	Work hardening
	2320-2350	M42/M51	110-140	5-6	Medium	250-300	Work hardening
	2513-2515	M42/M51	175-220	4-5	Medium	250-300	Work hardening
Nickel-Chrome	3115-3150	M42	125-160	6-9	Medium	275-350	Tendency to chip weld
	3215-3240	M42/M51	110-140	5-8	Medium	250-300	Work hardening
	3415-3450	M42/M51	90-125	4-6	Medium/heavy	250-300	Work hardening
Molybdenum	4023-4037	Matrix II	230-270	6-8	Medium	350-375	Abrasive
	4042-4063	Matrix II	180-220	5-7	Medium/heavy	325-350	Abrasive
Chrome-Moly	4120-4140	M42/M51	185-210	5-7	Medium	275-350	Work hardening/abrasive
	4320-4340	M42/M51	180-230	5-7	Medium	250-325	Work hardening/abrasive
Nick-Chro-Moly	86020-8750	M42	175-230	5-7	Medium	275-425	Good cutting characteristics
	9310-9850	M42/M51	160-220	4-6	Medium/heavy	175-300	Work hardening
Nickel-Moly	4615-4640	M42/M51	210-240	5-7	Medium	275-300	Work hardening
	4812-4820	M42/M51	175-190	4-6	Medium/heavy	225-275	Work hardening
Chrome	5120-5160	M42	190-230	6-8	Medium	225-350	Good cutting characteristics
	50100-52100	M42/M51	150-185	4-6	Medium	200-275	Abrasive
Chro-Van-Silicon	6115-6120	M42	160-225	3-6	Medium	200-275	Abrasive
Silicon	9262	M42	175-200	8-16	Medium	175-250	Extremely abrasive
Stainless	201-304	M42/M51	80-125	2-4	Medium/heavy	275-300	Work hardening
	308-348	M42/M51	55-80	2-4	Medium/heavy	100-250	Work hardening
	410-430	M42/M51	110-150	2-4	Medium	125-250	Work hardening/abrasive
	440 & 17-series	M42/M51	75-110	1-2	Medium/heavy	125-175	Work hardening/abrasive
Tool Steel	M1, M2, M3, T1, T2	M42/M51	120-150	3-5	Medium/heavy	125-175	Work hardening/abrasive
Die Steel	O-1, O-2, O-6, O-7	M42/M51	175-210	3-5	Medium/heavy	225-350	Work hardening/abrasive
	A-2, A-4	M42/M51	180-220	3-4	Medium/heavy	200-250	Work hardening/abrasive
	D-2, D-3, D-4	M42/M51	90-120	2-3	Medium/heavy	125-175	Work hardening/abrasive
Hot Work Steel	H12, H13, H21	M42	160-200	4-5	Medium	275-325	Abrasive
	H22, H24, H25	M42	130-175	2-4	Medium/heavy	175-225	Abrasive
Monel		M42/M51	60-90	.5-4	Medium/heavy	50-100	Extremely work hardening
Inconel		M42/M51	50-80	.5-4	Medium/heavy	25-70	Extremely work hardening
Hastelloy		M42/M51	50-80	.5-4	Medium/heavy	55-100	Extremely work hardening
Titanium		M42/M51	40-60	.5-4	Medium/heavy	25-60	Extremely work hardening
Aluminum	2011-7075	Matrix II	325-400	14-25	Medium/light	175-275	Abrasive/chip build up
Copper		Matrix II	275-350	6-8	Medium/light	250-600	Good cutting characteristics
Bronze		Matrix II	225-300	14-18	Medium/light	200-425	Good cutting characteristics
Brass Red		Matrix II	225-300	14-18	Medium/light	225-400	Good cutting characteristics
Brass, Navel		Matrix II	275-350	10-14	Medium/light		Good cutting characteristics
Cast Iron		Matrix II	165-225		Medium		
Cast Steel		Matrix II	110-225		Medium		
Structurals		Matrix II	175-250		Medium/light		Tooth breakage potential



Sterling® Saw Blades are manufactured by

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