



Precision, Quality, Innovation

# BAND SAW BLADES

Bi-Metal

Carbide Tipped

Carbide Grit

Carbon

Portaband

Diamond Grit

Wood Cutting

Food Processing

Power Hacksaws

Accessories

Services

Catalog 60R





# PRECISION, QUALITY, INNOVATION

For more than 135 years, manufacturers, builders and craftsmen worldwide have depended upon saws and precision tools from The L.S. Starrett Company to ensure the consistent quality of their manufacturing processes.

They know that the Starrett name on saw blades, hand tools and measuring tools means exceptional quality, innovative products and expert technical assistance.

With strict quality control, state-of-the-art equipment and an ongoing commitment to producing products with superior quality, the 5,000 plus products in today's Starrett line continues to be the most accurate, robust and durable tools available.

This catalog features Starrett Band Saw Blades, their applications and characteristics.



## INTRODUCTION

Starrett has been involved in precision tool manufacturing since 1880, sold products worldwide since the 1890s and introduced its first saw blade around 1890.

06

## CHOOSING THE RIGHT BLADE

Terminology, Tooth shapes, Band Saw Blade characteristics,

10

## BI-METAL SAW BLADES

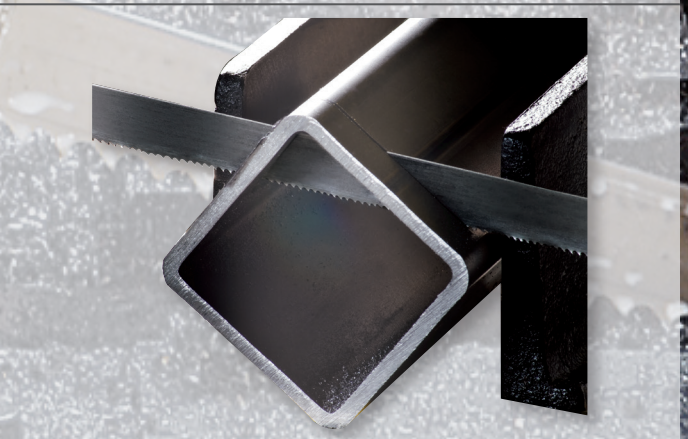
The best solution for cutting a variety of ferrous and non-ferrous materials. These saws suit all cutting, economic or high production needs for any model of machine.

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## CARBIDE TIPPED

Ideal for cutting extremely hard, abrasive materials. Withstands extreme cutting pressures and offers a high resistance to wear and fatigue.

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# BAND SAW BLADES





## CARBIDE GRIT, DIAMOND GRIT

Band saw blades coated with carbide grit or diamond grains are ideal for cutting abrasive materials with precision and excellent finish.

33



## CARBON

Suitable for horizontal and vertical machines with manual or gravity feed. A complete line with a wide range of widths, tooth pitches and shapes.

36



## WOOD CUTTING

A selection of carbon, bi-metal, and carbide-tipped blades ideal for a variety of wood cutting applications.

41



## FOOD PROCESSING

Constructed of the best quality specialty steels, polished and hardened to resist corrosion and contamination. These blades are the ideal choice for accuracy and efficiency at any food processing plant.

47



## POWER HACKSAWS

The Bi-Metal or Solid High-Speed Steel (HSS) Power Hacksaw blades are manufactured by Starrett, available in metric and inch.

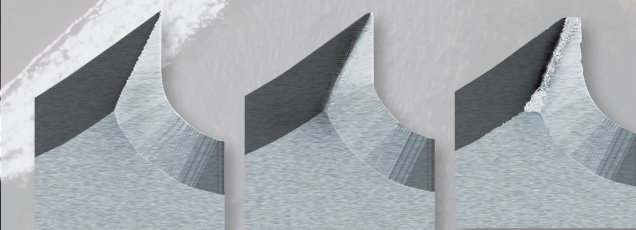
53



## RECOMMENDATIONS

Recommendations to ensure longer life and better blade performance. Break-in and installation instructions.

59



## ACCESSORIES

Pocket Laser Tachometer kit with case, Band Saw Blade Tension Gage and Band Saw Blade Alignment Gage.

62



## RESOURCES

Find information on the Starrett website and other resources to get the best performance from your band saw blade.

63



# BAND SAW BLADES



# FACTORIES AROUND THE WORLD



1-Athol, Massachusetts, USA



2-Laguna Hills, California, USA



3-Waite Park, Minnesota, USA



4-Cleveland, Ohio, USA







5-Mount Airy, North Carolina, USA



6-Columbus, Georgia, USA



7-Itu, São Paulo, Brazil



8-Suzhou, China





# TERMINOLOGY

## A-WIDTH

Tip of the cutting edge to the back of the blade.

## B-BLADE BODY

Distance between the back of the blade and the gullet.

## C-LENGTH

Measurement along the back edge of the blade.

## D-THICKNESS

Measurement of the body of the blade.

## E-BACK EDGE

Opposite side of the blade from the teeth.

## F-TOOTH PITCH

Distance from the tip of one tooth to the next tip.

## G-TEETH PER INCH/25MM

Number of teeth (constant pitch) per inch (25.4mm).

## H-GULLET

The curved area between two teeth, where the chips accumulate until being removed.

## I-TOOTH FACE

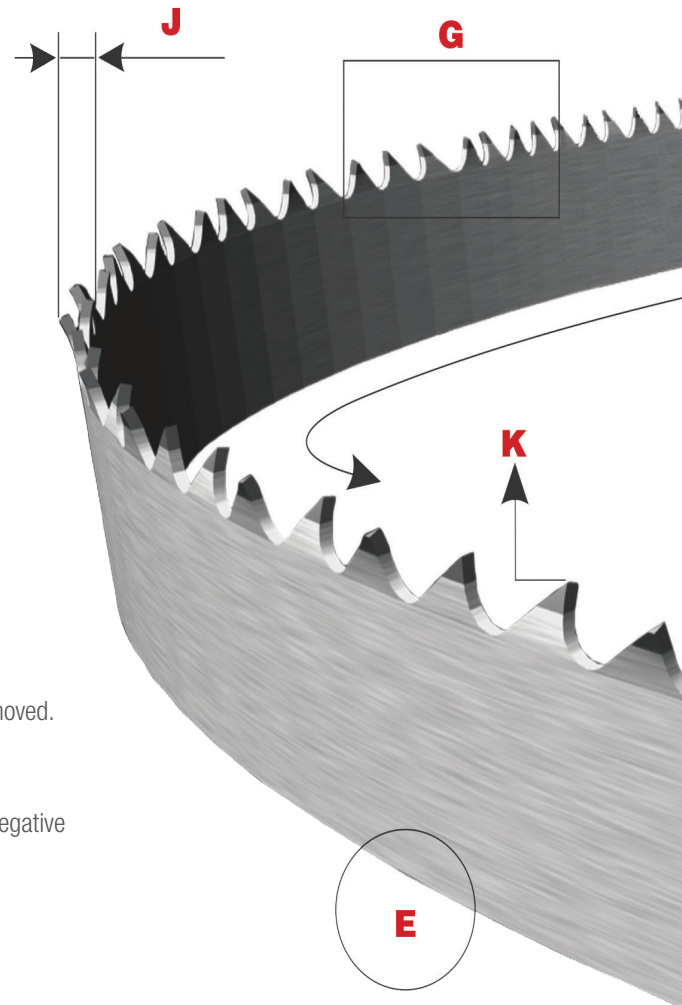
Surface of the tooth where the chip is formed. The tooth can have a positive, negative or straight angle. (Rake)

## J-TOOTH SET

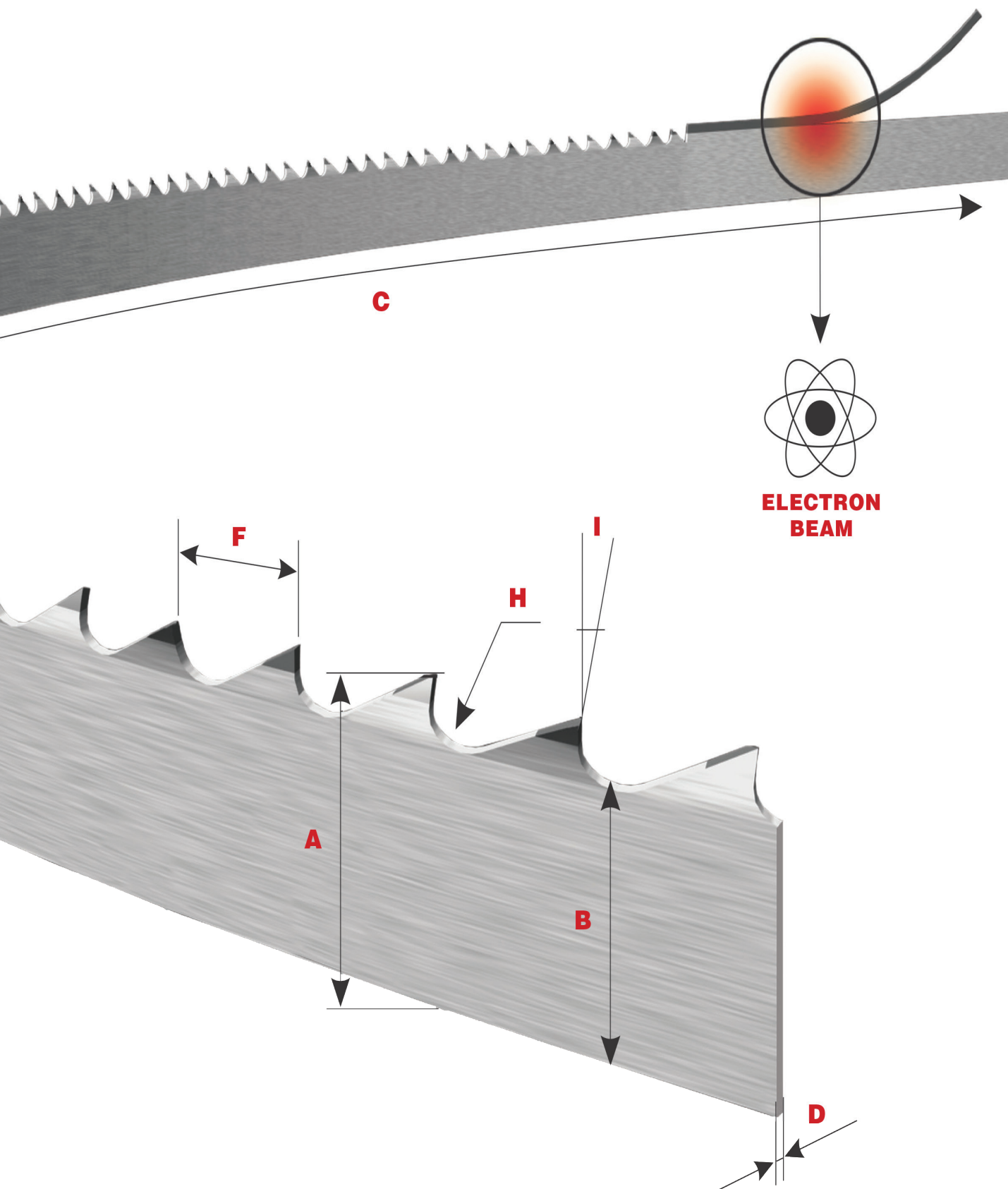
The side bending of the teeth to allow blade clearance through the cut.

## K-BACK ANGLE

Angle formed by the back of the teeth and a parallel line to the tip of the same.







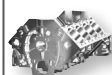
# CHOOSING THE RIGHT BLADE

## 1 QUICK GUIDE

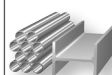


Performance

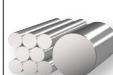
Ferrous



Aluminum



Tubes and Profiles



Carbon Steel



Carbon Steel Alloys



Cast Iron



Copper Alloys



High-speed steel



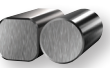
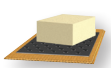
Stainless Steel

|          |                             | Aluminum | Tubes and Profiles | Carbon Steel | Carbon Steel Alloys | Cast Iron | Copper Alloys | High-speed steel | Stainless Steel |
|----------|-----------------------------|----------|--------------------|--------------|---------------------|-----------|---------------|------------------|-----------------|
| Bi-Metal | TENNAX™ - PRO<br>Page 19    |          | ☆☆☆                |              |                     |           |               |                  |                 |
|          | Primalloy™<br>Page 20       |          |                    |              | ☆☆☆                 | ☆☆☆       | ☆☆☆           | ☆☆☆              | ☆☆              |
|          | Intenss™ PRO-VTH<br>Page 21 |          |                    |              | ☆☆                  |           |               | ☆☆               | ☆☆☆             |
|          | Intenss™ PRO<br>Page 22     | ☆☆       | ☆☆                 | ☆☆☆          | ☆☆☆                 | ☆☆        | ☆☆            | ☆☆               | ☆☆              |
|          | Intenss™ PRO-DIE<br>Page 23 | ☆☆       | ☆☆                 | ☆☆☆          | ☆☆☆                 | ☆☆        | ☆☆            | ☆☆               | ☆☆              |
|          | Intenss™<br>Page 24         | ☆☆       | ☆☆                 | ☆☆           | ★                   | ☆☆        | ★             |                  |                 |
|          | Univerz™<br>Page 25         | ★        | ☆☆                 | ★            |                     |           |               |                  |                 |
| Carbide  | Advanz™ MC7<br>Page 28      | ☆☆       |                    | ☆☆☆          | ☆☆☆                 | ☆☆        | ☆☆            | ☆☆☆              | ☆☆☆             |
|          | Advanz™ MC5<br>Page 29      | ☆☆☆      |                    | ☆☆           | ☆☆                  | ☆☆☆       | ☆☆☆           | ☆☆☆              | ☆☆              |
|          | Advanz™ TS<br>Page 30       | ★        |                    | ☆☆           | ☆☆                  | ★         | ★             | ★                | ★               |
|          | Advanz™ CS**<br>Page 31     |          |                    |              |                     |           |               |                  |                 |
|          | Advanz™ FS*<br>Page 32      | ☆☆☆      |                    |              |                     | ☆☆☆       | ☆☆☆           |                  |                 |
|          | Advanz™ CG<br>Page 34       |          |                    |              |                     |           |               |                  |                 |
| Diamond  | Advanz™ DG<br>Page 35       |          |                    |              |                     |           |               |                  |                 |
| Carbon   | Duratec™ SFB<br>Page 38     | ★        | ★                  | ★            |                     |           |               |                  |                 |
|          | Duratec™ FC<br>Page 39      |          |                    |              |                     |           |               |                  |                 |
|          | Band Knives<br>Page 40      |          |                    |              |                     |           |               |                  |                 |

\*Foundry-Gates and Risers

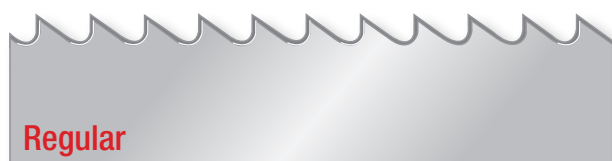
\*\*Induction or Case Hardened



| Ferrous                                                                                                   |                                                                                                             |                                                                                                                 |                                                                                                                      | Non-Ferrous                                                                                                             |                                                                                                                        |
|-----------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------|
| <br>Tool Steel - Hot Work | <br>Tool Steel - Cold Work | <br>Nickel and Titanium Alloys | <br>Steel with Hardness Above 45HRC | <br>Composite Materials and Abrasives | <br>Foam, Paper, Plastic and Rubber |
|                                                                                                           |                                                                                                             |                                                                                                                 |                                                                                                                      |                                                                                                                         |                                                                                                                        |
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# CHOOSING THE RIGHT BLADE

## 2 TOOTH SHAPES



Contant  
Pitch



Variable  
Pitch



.8-1.3 to  
14-18



1-1.2 to  
4-6



2-3 to  
10-14



6 to 32



2-3 to  
14-18



2 to 6



3 to 6



1 to 3



.9-1.1 to  
3-4



### Primalloy™/Intenss™ PRO/Intenss™ PRO-DIE/Univerz™

- Positive Rake angle
- Double back angle
- Fast and efficient chip clearance
- Excellent choice for a wide range of cuts

### Intenss™ PRO-VTH

- Variable tooth height providing pulsating action
- Easy penetration
- Ideal for cutting hard and difficult to machine materials

### TENNAX™ - PRO

- Increased resistance to wear and tooth breakage
- Positive Rake angle
- Ideal for cutting pipes, tubes and structural profiles

### Intenss/Duratec™ SFB/Duratec™ FC/Univerz™

- Neutral angle
- Shock resistant
- Excellent choice for a wide range of cuts
- Suitable for all types of machines

### Duratec™ SFB/Intenss™ PRO-DIE

- Positive Rake angle, extremely aggressive
- Faster cuts
- Suitable for cutting ferrous and non-ferrous metals

### Duratec™ SFB

- Neutral angle
- Shock resistant
- Suitable for cutting ferrous and non-ferrous metals

### Advanz™ MC7/Advanz™ MC5/Advanz™ TS/Advanz™ CS/Advanz™ FS

- Differential tooth design, accurately ground
- Triple chip tooth geometry
- Faster cuts
- Ideal for cutting hard and difficult to machine materials

### Advanz™ CG/Advanz™ DG

- Cutting edge coated with grains, continuous or with gullet
- Suitable for cutting abrasive or hardened materials



# CHOOSING THE RIGHT BLADE

## TOOTH



### Constant Pitch

All teeth on the blade have uniform spacing, gullet depth and rake angle throughout the full length. Typically for general purpose cutting. Identified by one pitch number.



### Variable Pitch

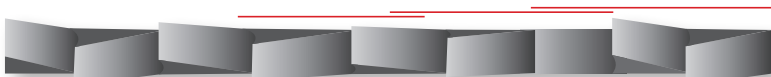
Size of tooth and depth of gullet varies to substantially reduce noise levels and vibrations. Cuts all structurals, tubing and solids smoothly and quickly. Identified by two pitch numbers.

## SETS



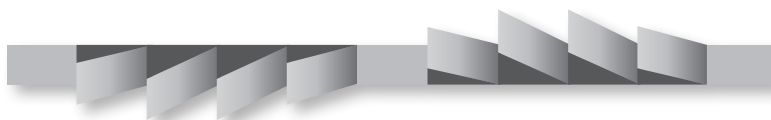
### Raker

A recurring sequence of teeth set left and right, followed by one tooth unset. Frequency of unset teeth on variable pitch blades varies depends on the tooth configurations.



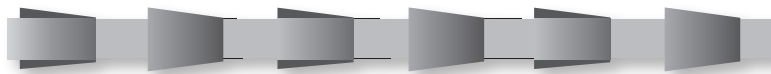
### Alternate

A recurring sequence of teeth set alternately left and right.



### Wavy

Groups of teeth set to each side of the blade, with varying amounts of set in a controlled pattern.



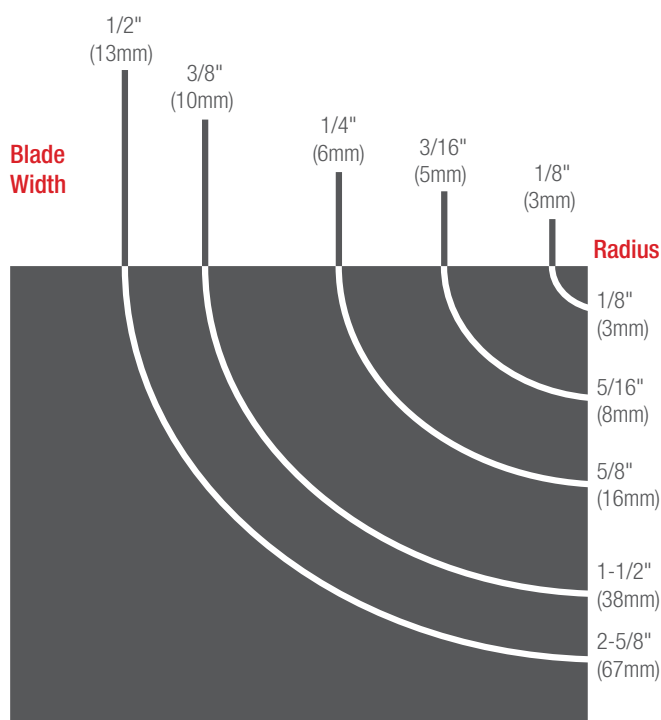
### Trapezoid

Special carbide cylinder, welded to an alloy backer, then precision ground with a high/low tooth form.

# CHOOSING THE RIGHT BLADE

## 3 BLADE WIDTH

Use the blade width recommended by the machine manufacturer, except for contour cutting in vertical machines when you should use the chart below.



## 4 PITCH

Pitch is the number of teeth per inch/25mm. Cutting thinner sections requires a finer pitch (more teeth per inch/25mm). Thick sections require coarser pitches (fewer teeth per inch/25mm).

The charts are good guidelines. Because the cross section limits in the chart are broad and overlap, choose a coarser pitch if the speed of cut is most important.

| Section to be Cut (in) | Constant Pitch (TPI) | Variable Pitch |
|------------------------|----------------------|----------------|
| 5/32" to 3/8"          | 32 or 24             | 14-18          |
| 1/4" to 1/2"           | 18 or 14             | 10-14          |
| 1/2" to 3/4"           | 14 or 10             | 8-12           |
| 3/4" to 1"             | 10 or 8              | 6-10           |
| 1" to 1-1/2"           | 8 or 6               | 5-8            |
| 1-1/2" to 3-1/2"       | 6 or 4               | 4-6            |
| 3-1/2" to 7"           | 4 or 3               | 3-4            |
| 7" to 10"              | 3                    | 2-3            |
| 10" to 16"             | —                    | 1/4-2          |
| 14" to 20"             | 1/3                  | 1-2            |
| 16" to 32"             | 1/3                  | 1-1/2          |
| Over 30"               | 1                    | .8-1/3/.9-1/1  |

- For cutting tubes and profiles, use the horizontal line to find the outside diameter (tube) or the largest section (profile). Find the thickness (tube/profile) using the vertical column. With that information, cross them to find the recommended pitch (chart below).

### Tubes and Profiles

| Wall Thickness<br>in | Outside diameter of tube or maximum profile section length (in) |       |        |        |        |       |        |      |      |      |       |       |       |
|----------------------|-----------------------------------------------------------------|-------|--------|--------|--------|-------|--------|------|------|------|-------|-------|-------|
|                      | 3/8"                                                            | 3/4"  | 1-5/8" | 2-3/8" | 3-1/4" | 4"    | 4-3/4" | 6"   | 8"   | 12"  | 16"   | 20"   | 24"   |
| 3/32"                | 14-18                                                           | 14-18 | 10-14  | 10-14  | 10-14  | 10-14 | 8-12   | 8-12 | 8-12 | 8-12 | 6-10  | 6-10  | 5-8   |
| 1/8"                 | 10-14                                                           | 10-14 | 10-14  | 10-14  | 10-14  | 8-12  | 8-12   | 8-12 | 6-10 | 6-10 | 6-10  | 5-8   | 5-8   |
| 5/32"                |                                                                 | 8-12  | 8-12   | 8-12   | 8-12   | 6-10  | 6-10   | 6-10 | 5-8  | 5-8  | 4-6   | 4-6   | 4-6   |
| 3/16"                |                                                                 | 6-10  | 6-10   | 6-10   | 6-10   | 5-8   | 5-8    | 5-8  | 5-8  | 4-6  | 4-6   | 4-6   | 4-6   |
| 1/4"                 |                                                                 | 5-8   | 5-8    | 5-8    | 5-8    | 5-8   | 5-8    | 5-8  | 4-6  | 4-6  | 4-6   | 4-6   | 3-4   |
| 5/16"                |                                                                 |       | 4-6    | 4-6    | 4-6    | 4-6   | 4-6    | 4-6  | 4-6  | 4-6  | 3-4   | 3-4   | 3-4   |
| 3/8"                 |                                                                 |       | 4-6    | 4-6    | 3-4    | 3-4   | 3-4    | 3-4  | 3-4  | 3-4  | 3-4   | 2-3   | 2-3   |
| 1/2"                 |                                                                 |       |        | 4-6    | 3-4    | 3-4   | 3-4    | 3-4  | 3-4  | 3-4  | 2-3   | 2-3   | 2-3   |
| 5/8"                 |                                                                 |       |        | 4-6    | 3-4    | 3-4   | 3-4    | 3-4  | 3-4  | 2-3  | 2-3   | 2-3   | 2-3   |
| 3/4"                 |                                                                 |       |        | 4-6    | 3-4    | 3-4   | 3-4    | 3-4  | 3-4  | 2-3  | 2-3   | 2-3   | 2-3   |
| 1"                   |                                                                 |       |        |        | 3-4    | 3-4   | 3-4    | 3-4  | 2-3  | 2-3  | 2-3   | 1/4-2 | 1/4-2 |
| 1-1/4"               |                                                                 |       |        |        | 3-4    | 3-4   | 3-4    | 3-4  | 2-3  | 2-3  | 2-3   | 1/4-2 | 1/4-2 |
| 1-5/8"               |                                                                 |       |        |        |        | 3-4   | 3-4    | 3-4  | 2-3  | 2-3  | 2-3   | 1/4-2 | 1/4-2 |
| 2"                   |                                                                 |       |        |        |        |       | 3-4    | 3-4  | 2-3  | 2-3  | 1/4-2 | 1/4-2 | 1-1/2 |
| 2-3/8"               |                                                                 |       |        |        |        |       |        |      | 2-3  | 2-3  | 1/4-2 | 1/4-2 | 1-1/2 |

## 5 BLADE LENGTH

The blade length varies according to the band saw machine type and specifications. Please find the correct blade length in your band saw machine user manual.





## ON-SITE TECHNICAL SUPPORT

Starrett Saw Specialists are available to tune up and perform preventative maintenance on your production sawing machine using Starrett Band Saw Blades, at no additional cost. They fully review machine condition, blade mounting and operation in detail, making adjustments, as required, to help maintain good sawing and long life for both the machine and blades.

## GUARANTEED BLADE SATISFACTION TRIAL PROGRAM

As a part of our Test & Trial Blade Program, Starrett Saw Specialists conduct on-site saw tests to observe your current blade performance and specific saw application. Our band saw testing process drives a data-driven approach to optimize performance and lower your cost per cut.

## TRAINING

Starrett Saw Specialists can also instruct saw operators on achieving the best performance of blade and machine for your applications. Contact Starrett directly or your nearest Starrett distributor about arranging a visit to your workplace by a Starrett Saw Specialist.

The L.S. Starrett Company  
121 Crescent Street  
Athol, MA 01331-1915 - U.S.A  
Tel: (978) 249-3551  
[www.starrett.com](http://www.starrett.com) | [sales@starrett.com](mailto:sales@starrett.com)





## CONTACT US

### HOW TO ORDER

Contact Starrett directly or your nearest Starrett distributor for prompt service, delivery and technical support.

### GUARANTEED BLADE SATISFACTION TRIAL PROGRAM

To inquire about our Test & Trial Blade Program, call the Starrett Sales Team at 978-249-3551 or email us at [sales@starrett.com](mailto:sales@starrett.com)

### PRODUCT DEMONSTRATION

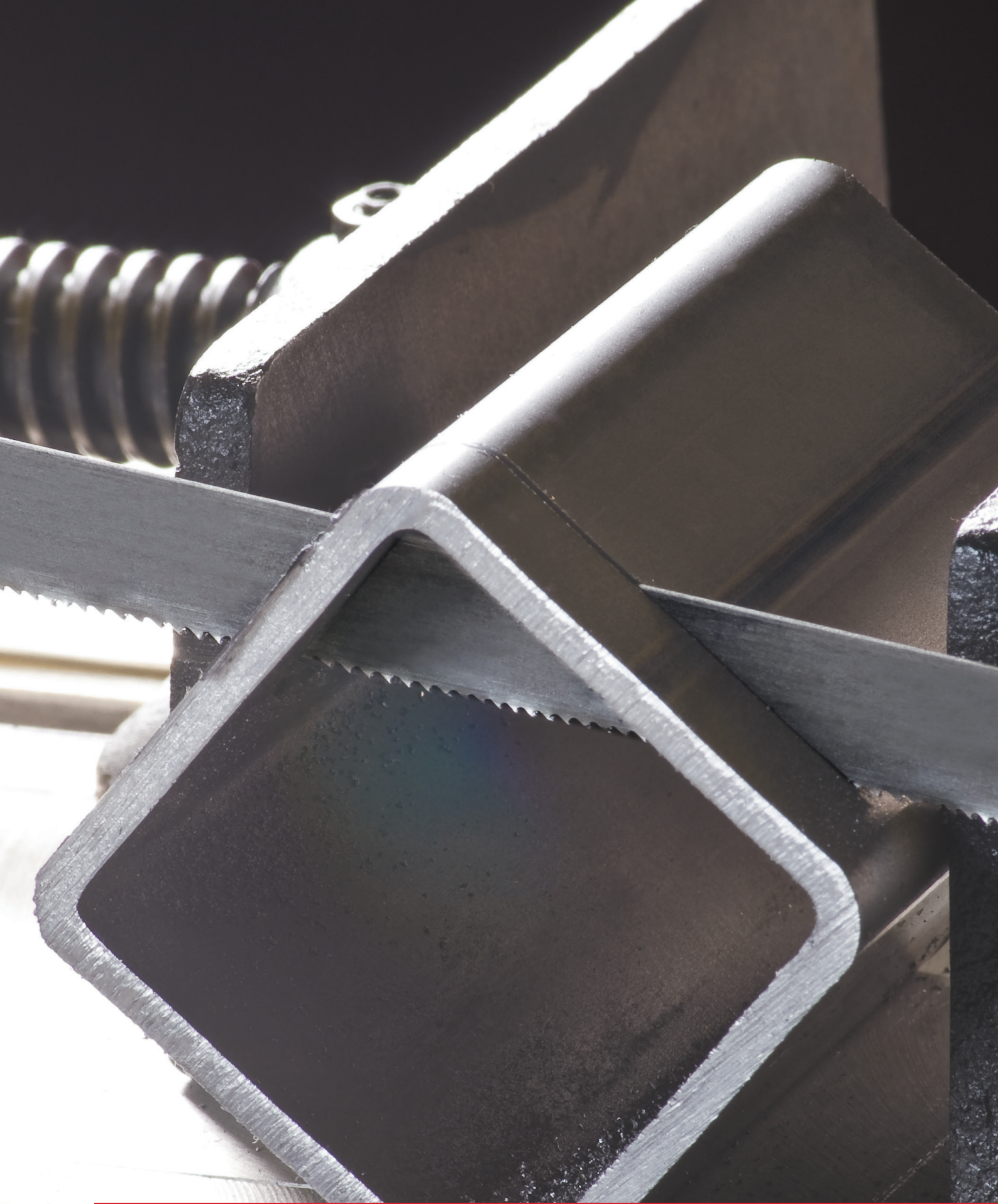
All Starrett manufacturing and branch locations and many distributors can demonstrate an array of Starrett products at work. Contact your Starrett distributor to learn more.

**Starrett®**  
(978) 249-3551 • [starrett.com](http://starrett.com)

Follow us!







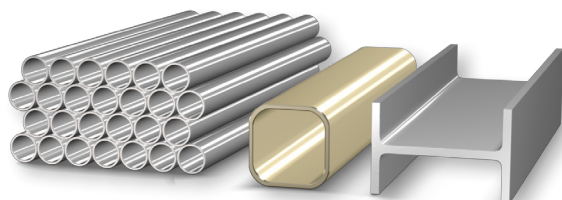
BI-METAL BAND SAW BLADES



# BI-METAL

## TENNAX™-PRO

NEW  
PRODUCT





The new bi-metal **TENNAX-PRO Band Saw Blades** by Starrett deliver next generation cutting performance on pipes, tubes, and structural profiles. TENNAX-PRO blades outperform competitive blades with lower noise, heat and vibration, and up to 25% more cuts per blade.

TENNAX-PRO Band Saw Blades replace Starrett Versatix MP. For cross reference support, please visit [starrett.com](http://starrett.com)

## FEATURES

- New tooth geometry developed for cutting pipes and structural material profiles
- M42 High Speed Edge
- Exclusive tooth setting process

## BENEFITS

- High level of productivity in extreme cutting processes used for pipes, profiles and structural materials
- Increased resistance to wear and tooth breakage
- Low noise, low vibration and improved cutting performance

## APPLICATIONS

- Pipes, tubes, and structurals
- Small solids
- Bundles
- For all machines: manual, hydraulic, gravity fed, etc.

| Width x Thickness<br>in | mm        | Pitch/Rake   | Material No. |
|-------------------------|-----------|--------------|--------------|
| 3/4 x .035              | 19 x 0.90 | 4-6/TX-P-H   | 99567        |
|                         |           | 5-8/TX-P-H   | 99568        |
|                         |           | 6-10/TX-P-H  | 99569        |
|                         |           | 8-12/TX-P-H  | 99570        |
|                         |           | 10-14/TX-P-H | 99571        |
| 1 x .035                | 27 x 0.90 | 3-4/TX-P-H   | 99572        |
|                         |           | 4-6/TX-P-H   | 99573        |
|                         |           | 5-8/TX-P-H   | 99574        |
|                         |           | 6-10/TX-P-H  | 99575        |
|                         |           | 8-12/TX-P-H  | 99576        |
| 1-1/4 x .042            | 34 x 1.10 | 10-14/TX-P-H | 99577        |
|                         |           | 2-3/TX-P-H   | 99578        |
|                         |           | 3-4/TX-P-H   | 99579        |
|                         |           | 4-6/TX-P-H   | 99580        |
|                         |           | 5-8/TX-P-H   | 99581        |
| 1-1/2 x .050            | 41 x 1.30 | 6-10/TX-P-H  | 99582        |
|                         |           | 2-3/TX-P-H   | 99583        |
|                         |           | 3-4/TX-P-H   | 99584        |
|                         |           | 4-6/TX-P-H   | 99585        |
|                         |           | 5-8/TX-P-H   | 99586        |
| 2 x .063                | 54 x 1.60 | 2-3/TX-P-H   | 99587        |
|                         |           | 3-4/TX-P-H   | 99588        |
|                         |           | 4-6/TX-P-H   | 99589        |
| 2-5/8 x .063            | 67 x 1.60 | 2-3/TX-P-H   | 99590        |
|                         |           | 3-4/TX-P-H   | 99591        |

TX - TENNAX-PRO tooth profile | P - Positive rake | H - Heavy set

3/4" to 1-1/4" sizes available in 150' (45m) and 250' (75m) coils. 1-1/2" and 2" sizes available in 150' (45m) coils.

2-5/8" size available only in welded blades.

All coils supplied within plus or minus 10% of ordered size.

Furnished in welded bands for all widths, or in random coils for 3/4" to 2" widths. Special products on request.

# BI-METAL

## PRIMALLOY™



### FEATURES

- Special high-speed steel edge
- Exclusive tooth geometry with positive rake angle
- Extended Life Treatment (EXT)-ensures maximum fatigue life
- Ground teeth

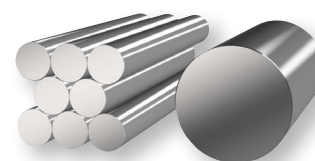
### BENEFITS

High content of Cobalt and Vanadium guarantee:

- High production, longer operating blade life with high quality surface finishing
- Increased wear and heat resistance
- Easy penetration in hard and difficult to machine materials, increasing the blade performance
- Cost-effective over conventional bi-metal blades

### APPLICATIONS

- Tool steel and high-speed steel
- Stainless steels
- Nickel and titanium alloys
- Hardened steel
- For machines with hydraulic feed control



| Width x Thickness |           | Pitch/Rake   | Material No. |
|-------------------|-----------|--------------|--------------|
| in                | mm        |              |              |
| 1-1/4 x .042      | 34 x 1.10 | 2-3/IP-P-R   | 99801        |
|                   |           | 1.4-2/IP-P-R | 99803        |
| 1-1/2 x .050      | 41 x 1.30 | 2-3/IP-P-R   | 99804        |
|                   |           | 3-4/IP-P-R   | 99805        |
| 2 x .063          | 54 x 1.60 | 2-3/IP-P-R   | 99807        |
|                   |           | 3-4/IP-P-R   | 99808        |
| 2-5/8 x .063      | 67 x 1.60 | 1-1.2/IP-P-R | 99809        |

IP - Intensts™tooth profile I P - Positive rake I R - raker set

1" to 1-1/4" sizes available in 150' (45m) and 250' (75m) coils. 1-1/2" and 2" sizes available in 150' (45m) coils. 2-5/8" sizes available only in welded blades.

All coils supplied within plus or minus 10% of ordered size.

Furnished in welded bands for all widths, or in random coils for 1" to 2" widths.

Special products on request.



### EXTENDED LIFE TREATMENT (EXT)

The Starrett Primalloy Band Saw product line applies a proprietary Extended Life Treatment (EXT) to its alloy steel backing material. This process, in addition to controlled blast peening, enhances the fatigue life of the blade. The EXT applied during the peening operation adds increased residual stress into the surface of the blade. Higher stress levels aid in the reduction of fatigue cracks that originate along microscopic grain boundaries. The benefits of extended life treatment are proven with X-Ray Diffraction (XRD) and extensive mechanical fatigue tests. This process will soon be applied to most Starrett bi-metal and carbide tip product lines.



# BI-METAL

## INTENS<sup>TM</sup> PRO-VTH

### bi-metal unique<sup>®</sup>

Starrett<sup>®</sup> Intens<sup>TM</sup> PRO-VTH

#### FEATURES

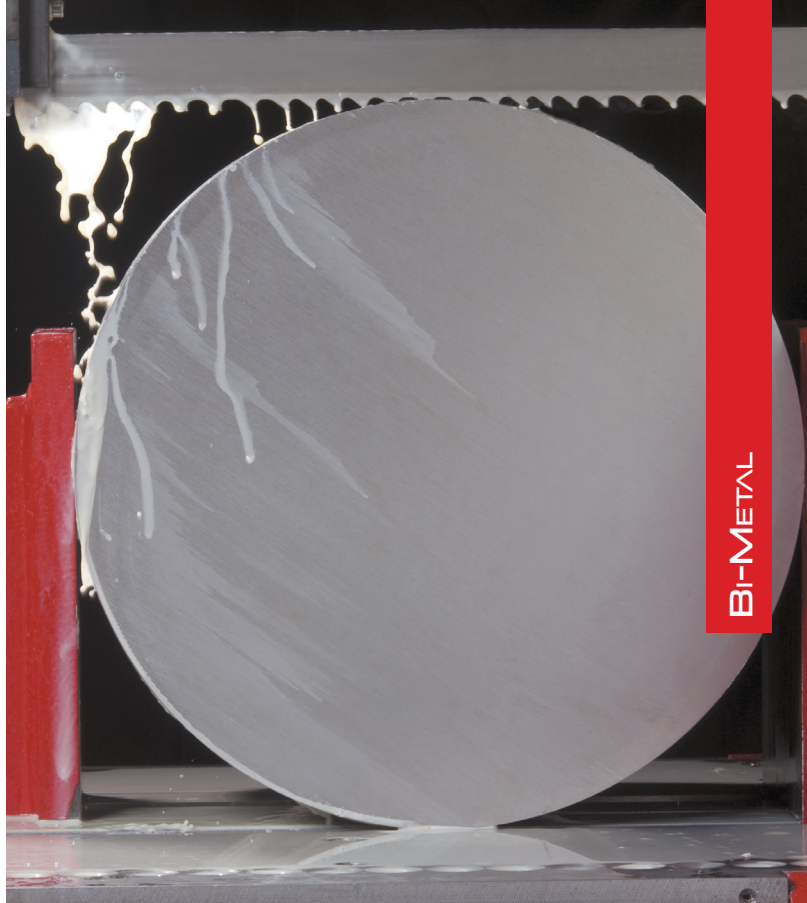
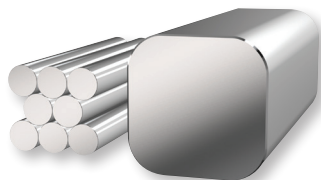
- Uniquely designed tooth edge with variable height and set
- Positive rake, ground teeth

#### BENEFITS

- Easy penetration for faster cuts
- Excellent heat and wear resistance
- Pulsating action allow the teeth to penetrate, resulting in faster cuts

#### APPLICATIONS

- Tool steel and high-speed steel
- Stainless steels
- Aluminum bronze alloys
- For machines with hydraulic feed control
- Ideal for cutting all steels and non-ferrous metals up to 40 HRC



BI-METAL

| Width x Thickness |           | Pitch/Rake   | Material No. |
|-------------------|-----------|--------------|--------------|
| in                | mm        |              |              |
| 1 x .035          | 27 x 0.90 | 3-4/IP-P-R   | 99949*       |
|                   |           | 4-6/IP-P-R   | 99950*       |
| 1-1/4 x .042      | 34 x 1.10 | 3-4/IP-P-R   | 99954        |
| 2 x .063          | 54 x 1.60 | 1.4-2/IP-P-R | 99967        |
| 3-1/8 x 0.63      |           | 1-1.2/IP-P-R | 99993        |

IP - Intens<sup>TM</sup> tooth profile | P - Positive rake | R - raker set

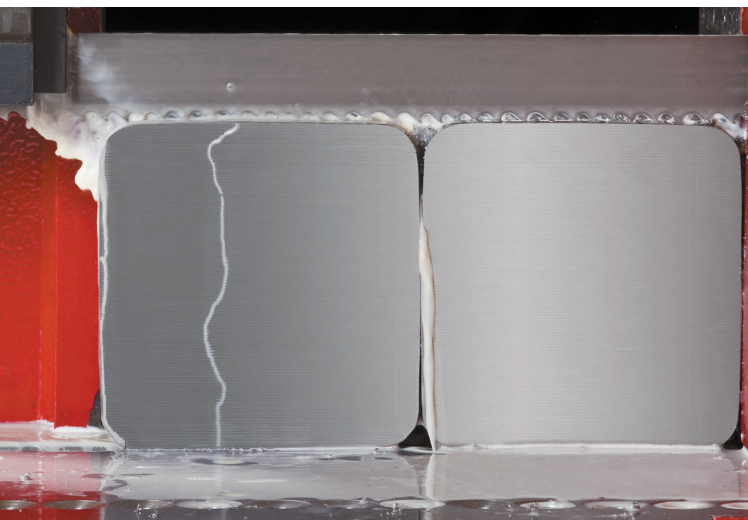
\*bi-metal unique<sup>®</sup> Technology

3/4" to 1-1/4" sizes available in 150' (45m) and 250' (75m) coils. 1-1/2" and 2" sizes available in 150' (45m) coils. 2-5/8" and 3-1/8" sizes available only in welded blades.

All coils supplied within plus or minus 10% of ordered size.

Furnished in welded bands for all widths, or in random coils for 3/4" to 2" widths.

Special products on request.

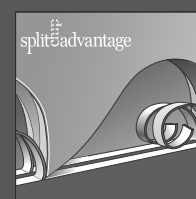
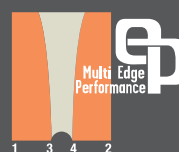


1. Patented process providing 170% more weld contact for superior teeth stripping resistance

2. Significantly reduced fracture and breakage

3. Multi-edge cutting performance resulting in faster cuts and longer blade life

## bi-metal unique<sup>®</sup>



# BI-METAL

## INTENS<sup>TM</sup> PRO

**bi-metal**  
**unique<sup>®</sup>**
**Starrett<sup>®</sup>** Intens<sup>TM</sup> PRO

### FEATURES

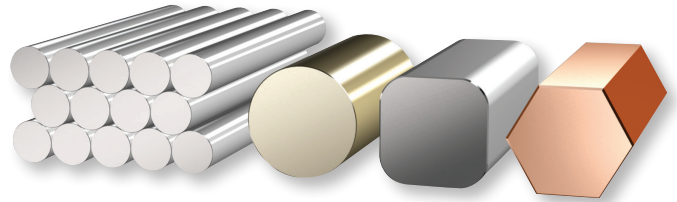
- Complete line with a full range of widths and pitches to suit a variety of cutting needs
- Unique tooth geometry provides intense production cutting in ferrous and non-ferrous metals

### BENEFITS

- Faster and straighter cuts
- Improved fatigue and wear resistance

### APPLICATIONS

- Ideal for production cutting across a wide range of metals
- For solids and thick wall tubes



| Width x Thickness |           | Pitch/Rake    | Material No. |
|-------------------|-----------|---------------|--------------|
| in                | mm        |               |              |
| 3/4 x .035        | 19 x 0.90 | 3-4/IP-P-R    | 99191*       |
|                   |           | 4-6/IP-P-R    | 99902*       |
|                   |           | 5-8/IP-P-R    | 99903*       |
|                   |           | 6-10/IP-P-R   | 99206*       |
| 1 x .035          | 27 x 0.90 | 2-3/IP-P-R    | 99905*       |
|                   |           | 3/P/IP-P-R    | 99484*       |
|                   |           | 3-4/IP-P-R    | 99906*       |
|                   |           | 4-6/IP-P-R    | 99907*       |
| 1-1/4 x .042      | 34 x 1.10 | 5-8/IP-P-R    | 99908*       |
|                   |           | 6-10/IP-P-R   | 99318*       |
|                   |           | 2-3/IP-P-R    | 99912        |
|                   |           | 3-4/IP-P-R    | 99913        |
| 1-1/2 x .050      | 41 x 1.30 | 4-6/IP-P-R    | 99914        |
|                   |           | 5-8/IP-P-R    | 99915        |
|                   |           | 6-10/IP-P-R   | 99500        |
|                   |           | 1-1.2/IP-P-R  | 99917        |
| 2 x .063          | 54 x 1.60 | 2-3/IP-P-R    | 99923        |
|                   |           | 3-4/IP-P-R    | 99924        |
|                   |           | 4-6/IP-P-R    | 99926        |
|                   |           | 5-8/IP-P-R    | 99927        |
| 2-5/8 x .063      | 67 x 1.60 | .8-1.3/IP-P-R | 99928        |
|                   |           | 1.4-2/IP-P-R  | 99931        |
|                   |           | 2-3/IP-P-R    | 99932        |
|                   |           | 3-4/IP-P-R    | 99933        |
| 3-1/8 x .063      | 80 x 1.60 | 4-6/IP-P-R    | 99962        |
|                   |           | .8-1.3/IP-P-R | 99934        |
|                   |           | 1-1.2/IP-P-R  | 99937        |
|                   |           | 1.4-2/IP-P-R  | 99941        |
| 3-1/8 x .063      | 80 x 1.60 | 2-3/IP-P-R    | 99965        |
|                   |           | 3-4/IP-P-R    | 99938        |
|                   |           | .8-1.3/IP-P-R | 99942        |
|                   |           | 1-1.2/IP-P-R  | 99943        |
| 3-1/8 x .063      | 80 x 1.60 | 1.4-2/IP-P-R  | 99947        |
|                   |           |               |              |

IP - Intens<sup>TM</sup> tooth profile | P - Positive rake | R - Raker set

\*bi-metal unique<sup>®</sup> Technology

3/4" to 1-1/4" sizes available in 150' (45m) and 250' (75m) coils. 1-1/2" and 2" sizes available in 150' (45m) coils. 2-5/8" and 3-1/8" sizes available only in welded blades.

All coils supplied within plus or minus 10% of ordered size.

Furnished in welded bands for all widths, or in random coils for 3/4" to 2" widths.

Special products on request.





# BI-METAL

## INTENSS™ PRO-DIE

bi-metal  
unique®

Starrett® Intenss™ PRO-DIE

### FEATURES

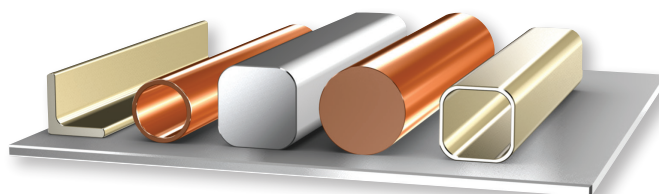
- Split Chip Advantage Technology
- Multiple cutting edges-Multi Edge Performance

### BENEFITS

- Technology that allows faster cutting rates for longer blade life
- Cost-effective over conventional carbon steel blades
- Excellent fatigue, abrasion and shock resistance

### APPLICATIONS

- Ideal for contour cutting on vertical machines
- Carbon steel and low alloy steels
- Sheet metal
- Die and Mold steel
- Stainless steel



| Width x Thickness |           | Pitch/Rake   | Material No. |
|-------------------|-----------|--------------|--------------|
| in                | mm        |              |              |
| 1/4 x .025        | 6 x 0.65  | 10-14/IP-P-R | 99079*       |
|                   |           | 14-18/RG-S-W | 99080*       |
| 1/4 x .035        | 6 x 0.90  | 10-14/IP-P-R | 99078*       |
|                   |           | 8-12/IP-P-R  | 99122*       |
| 3/8 x .025        | 10 x 0.65 | 10-14/IP-P-R | 99124*       |
|                   |           | 14-18/RG-S-W | 99125*       |
| 3/8 x .035        | 10 x 0.90 | 6/HH-P-R     | 99093*       |
|                   |           | 14-18/RG-S-R | 99190*       |
| 1/2 x .020        | 13 x 0.50 |              |              |

RG - Regular tooth profile | S - Straight (Zero) rake | R - Raker set | W - Wavy set  
IP - Intenss™ tooth profile | HH - Hook high tooth profile | P Positive rake

\*bi-metal unique® Technology

All sizes available in 100' (30m) and 250' (75m) coils or welded bands.

All coils supplied within plus or minus 10% of ordered size.

Special products on request.

| Width x Thickness |           | Pitch/Rake   | Material No. |
|-------------------|-----------|--------------|--------------|
| in                | mm        |              |              |
| 1/2 x .025        | 13 x 0.65 | 4/HH-P-R     | 99143*       |
|                   |           | 6/HH-P-R     | 99151*       |
|                   |           | 6-10/IP-P-R  | 99102*       |
|                   |           | 8-12/IP-P-R  | 99165*       |
|                   |           | 10-14/IP-P-R | 99186*       |
|                   |           | 14-18/RG-S-W | 99188*       |
| 1/2 x .035        | 13 x 0.90 | 4/HH-P-R     | 99144*       |
|                   |           | 6/HH-P-R     | 99152*       |
|                   |           | 6-10/IP-P-R  | 99154*       |
|                   |           | 8-12/IP-P-R  | 99167*       |
|                   |           | 10-14/IP-P-R | 99178*       |

RG - Regular tooth profile | S - Straight (Zero) rake | R - Raker set | W - Wavy set  
IP - Intenss™ tooth profile | HH - Hook high tooth profile | P Positive rake

\*bi-metal unique® Technology

All sizes available in 100' (30m) and 250' (75m) coils or welded bands.

All coils supplied within plus or minus 10% of ordered size.

Special products on request.

# BI-METAL

INTENS<sup>SM</sup>

bi-metal  
unique<sup>®</sup>

Starrett<sup>®</sup> Intens<sup>SM</sup>

## FEATURES

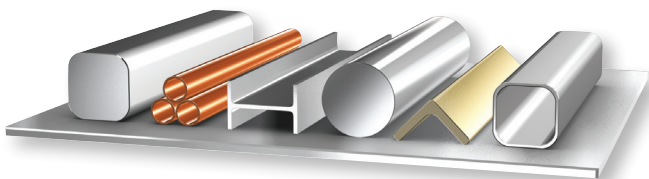
- Strong tooth geometry
- M42 high-speed steel teeth combined with a fatigue resistant backing

## BENEFITS

- Ideal for horizontal machines and light duty verticals
- Ideal for toolrooms and maintenance shops

## APPLICATIONS

- Sheets, carbon steel solids and structurals, aluminum, copper, brass, cast iron, alloy steel, stainless steel etc.
- Small and medium solid dimensions



| Width x Thickness |           | Pitch/Rake   | Material No. |
|-------------------|-----------|--------------|--------------|
| in                | mm        |              |              |
| 1/2 x .025        | 13 x 0.65 | 14/RG-S-R    | 99192*       |
|                   |           | 18/RG-S-W    | 99185*       |
|                   |           | 10/RG-S-R    | 99176*       |
| 1/2 x .035        | 13 x 0.90 | 14/RG-S-R    | 99181*       |
|                   |           | 4-6/RG-S-R   | 99195*       |
|                   |           | 5-8/RG-S-R   | 99198*       |
|                   |           | 6-10/RG-S-R  | 99197*       |
|                   |           | 8-12/RG-S-R  | 99199*       |
|                   |           | 10/RG-S-R    | 99231*       |
|                   |           | 10-14/RG-S-R | 99193*       |
| 3/4 x .035        | 19 x 0.90 | 14/RG-S-R    | 99238*       |
|                   |           | 3-4/RG-S-R   | 99282*       |
|                   |           | 4-6/RG-S-R   | 99307*       |
|                   |           | 5-8/RG-S-R   | 99297*       |
|                   |           | 6-10/RG-S-R  | 99303*       |
|                   |           | 8-12/RG-S-R  | 99304*       |
|                   |           | 10/RG-S-R    | 99331*       |
|                   |           | 10-14/RG-S-R | 99302*       |
|                   |           | 14/RG-S-R    | 99109*       |
|                   |           | 2-3/RG-S-R   | 99411        |
| 1 x .035          | 27 x 0.90 | 3-4/RG-S-R   | 99423        |
|                   |           | 4-6/RG-S-R   | 99430        |
|                   |           | 5-8/RG-S-R   | 99434        |
|                   |           | 6-10/RG-S-R  | 99424        |
|                   |           | 8-12/RG-S-R  | 99425        |
| 1-1/4 x .042      | 34 x 1.10 |              |              |
|                   |           |              |              |
|                   |           |              |              |
|                   |           |              |              |
|                   |           |              |              |

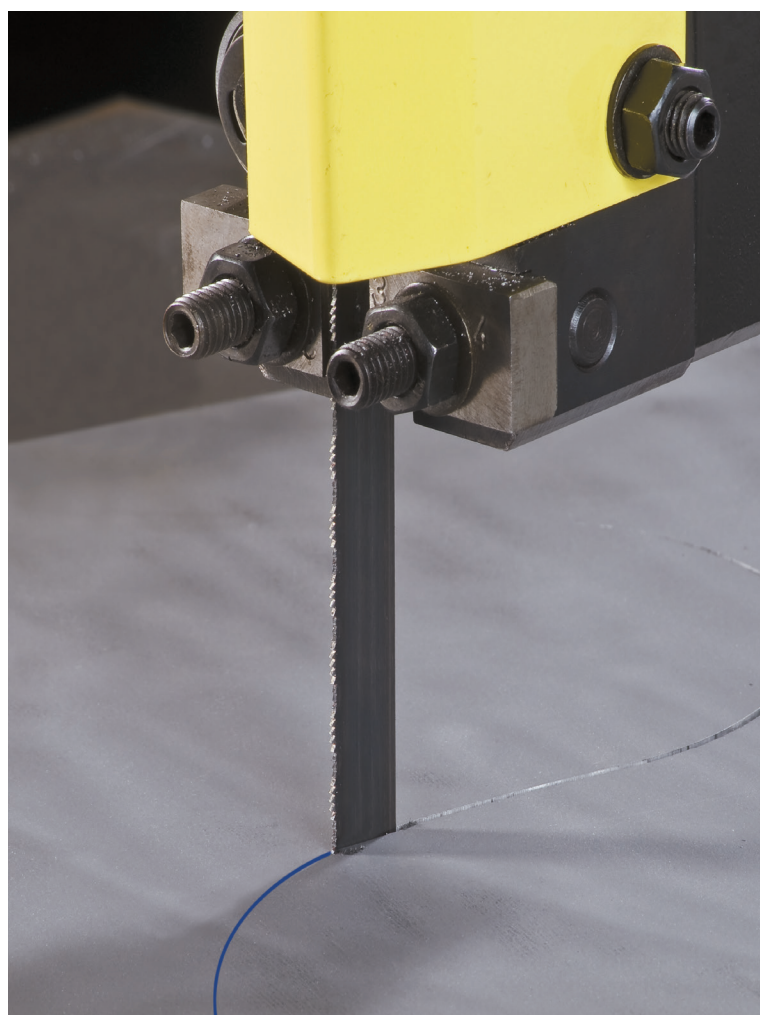
RG - Regular tooth profile | S - Straight (Zero) rake | R - Raker set | W - Wavy set

\*bi-metal unique<sup>®</sup> Technology

1/2" sizes available in 100' (30m) and 250' (75m) coils. 3/4" to 1-1/4" sizes available in 150' (45m) and 250' (75m) coils. 1-1/2" sizes available in 150' (45m) coils.

All coils supplied within plus or minus 10% of ordered size.  
Furnished in welded bands or in random coils for all widths.

Special products on request.







FEATURES

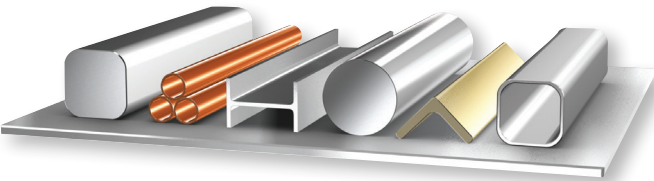
- Split Chip Advantage Technology
- Multiple cutting edges-Multiple Edge Performance
- Blade thickness: 0.020"

BENEFITS

- Technology that allows faster cutting rates and increased blade life
- More cost-effective than conventional carbon steel blades
- Excellent fatigue, abrasion and shock resistance
- For contour cuts

APPLICATIONS

- Portable machines
- Vertical machines with reduced wheel diameter
- Ideal for metal workshops, construction and hobbyists
- Steel, iron, aluminum



| Width x Thickness |           | Pitch/Rake   | Material No. |
|-------------------|-----------|--------------|--------------|
| in                | mm        |              |              |
| 1/2 x .020        | 13 x 0.50 | 10/RG-S-R    | 99171*       |
|                   |           | 14/RG-S-R    | 99179*       |
|                   |           | 18/RG-S-W    | 99182*       |
|                   |           | 24/RG-S-W    | 99184*       |
|                   |           | 10-14/RG-S-R | 99187*       |
|                   |           | 14-18/RG-S-W | 99180*       |

RG - Regular tooth profile | S - Straight (Zero) rake | R - Raker set | W - Wavy set  
\*bi-metal unique® Technology  
Available in 100' (30m) and 250' (75m) coils.  
All coils supplied within plus or minus 10% of ordered size.  
Furnished in welded bands.  
Special products on request.



PORTABAND

bi-metal  
unique®

Starrett® Univerz™

## FEATURES

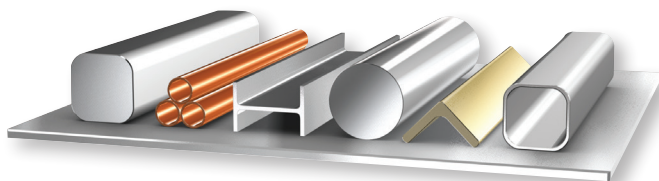
- Split Chip Advantage Technology
- Multiple cutting edges-Multiple Edge Performance
- Blade thickness: 0.020"

## BENEFITS

- Technology that allows faster cutting rates and increased blade life
- More cost-effective than conventional carbon steel blades
- Excellent fatigue, abrasion and shock resistance
- For contour cuts

## APPLICATIONS

- Ideal for metal workshops, construction and hobbyists
- Steel, iron, aluminum



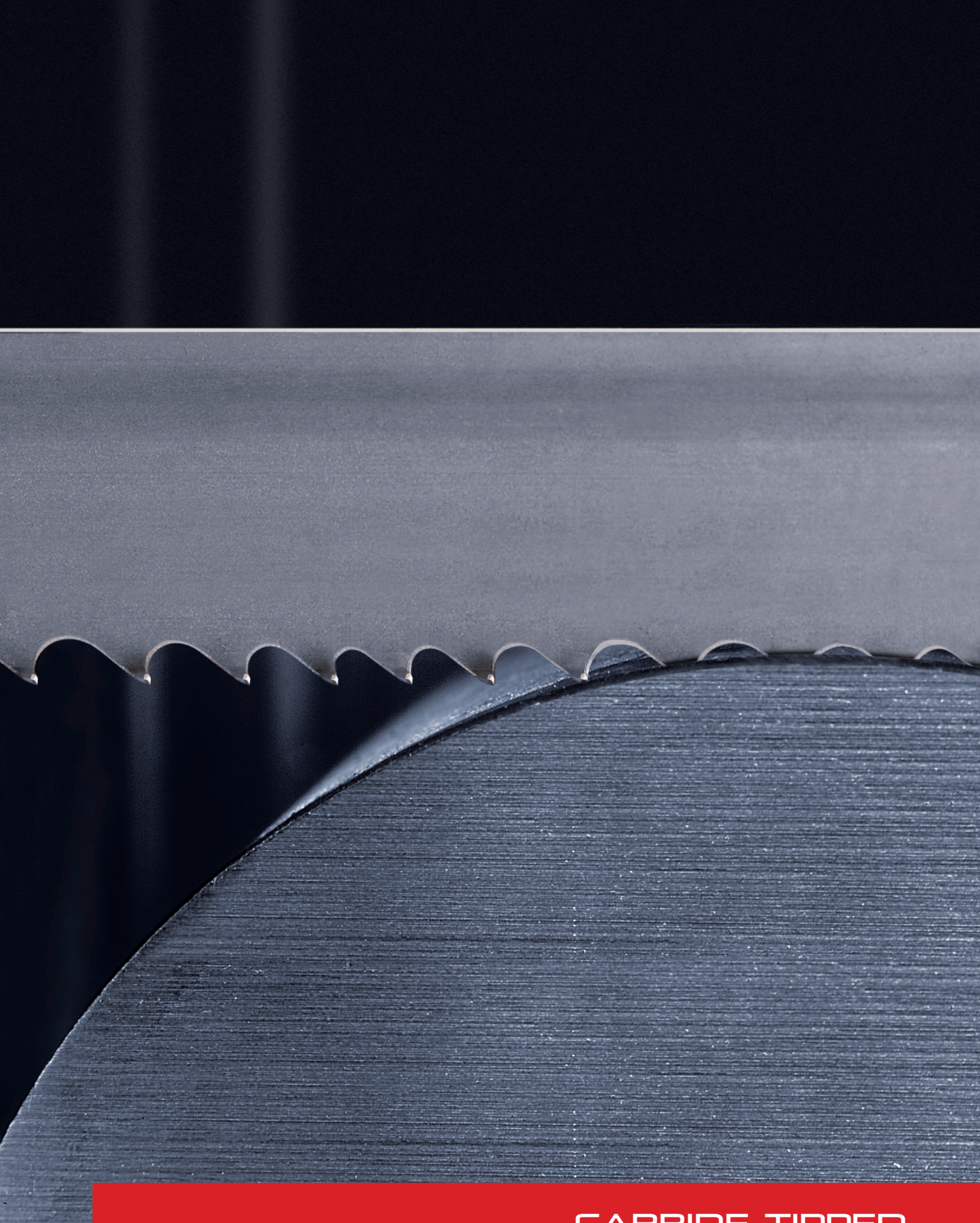
| Cat. No.                              | EDP   | Length<br>in | cm  | Width x Thickness |           | Pitch/Rake   |
|---------------------------------------|-------|--------------|-----|-------------------|-----------|--------------|
| Univerz™ - 3 Bands per Sleeve         |       |              |     |                   |           |              |
| BM10                                  | 14600 | 44-7/8       | 114 | 1/2 x .020        | 13 x 0.50 | 10/RG-S-R    |
| BM14                                  | 14601 |              |     |                   |           | 14/RG-S-R    |
| BM18                                  | 14602 |              |     |                   |           | 18/RG-S-W    |
| BM24                                  | 14603 |              |     |                   |           | 24/RG-S-W    |
| BM1014                                | 15708 |              |     |                   |           | 10-14/RG-S-R |
| BM1418                                | 16088 | 14-18/RG-S-W |     |                   |           |              |
| Univerz™ - 100 per Box                |       |              |     |                   |           |              |
| BM10B                                 | 16948 | 44-7/8       | 114 | 1/2 x .020        | 13 x 0.50 | 10/RG-S-R    |
| BM14B                                 | 16949 |              |     |                   |           | 14/RG-S-R    |
| BM18B                                 | 16950 |              |     |                   |           | 18/RG-S-W    |
| BM24B                                 | 16951 |              |     |                   |           | 24/RG-S-W    |
| BM1014B                               | 16952 |              |     |                   |           | 10-14/RG-S-R |
| BM1418B                               | 16953 | 14-18/RG-S-W |     |                   |           |              |
| Advanz™ CG - Carbide Grit - 1 per Box |       |              |     |                   |           |              |
| CG4CM                                 | 19954 | 44-7/8       | 114 | 1/2 x .020        | 13 x 0.50 | Continuous   |

RG - Regular tooth profile | S - Straight (Zero) rake | R - Raker set | W - Wavy set

\*All products feature bi-metal unique® Technology







CARBIDE TIPPED



# CARBIDE

## ADVANTZ™ MC7

Starrett® Advanz™ MC7

AVAILABLE WITH  
**AMP**  
TECHNOLOGY

### FEATURES

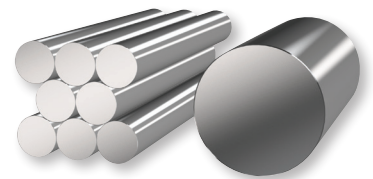
- Exclusive Starrett tooth geometry
- Carbide tipped
- Progressively ground trapezoidal tooth design
- Utilizes a progressive four tooth grind creating seven distinct chips
- Positive rake angle
- Submicron carbide (HV1600)

### BENEFITS

- Cutting ferrous metals
- Higher productivity through reduced cutting time
- Precision cuts - superb surface finish
- Excellent "cost per cut" for production cutting
- Exclusive Starrett edge preparation - minimizes micro chipping
- Less wear compared to conventional triple chip

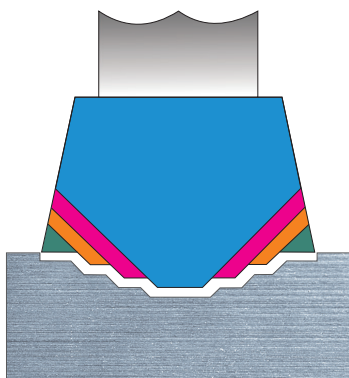
### APPLICATIONS

- Difficult to machine steels
- Tool steels, heat-treated steels, stainless materials
- Inconel, nickel alloys
- Titanium

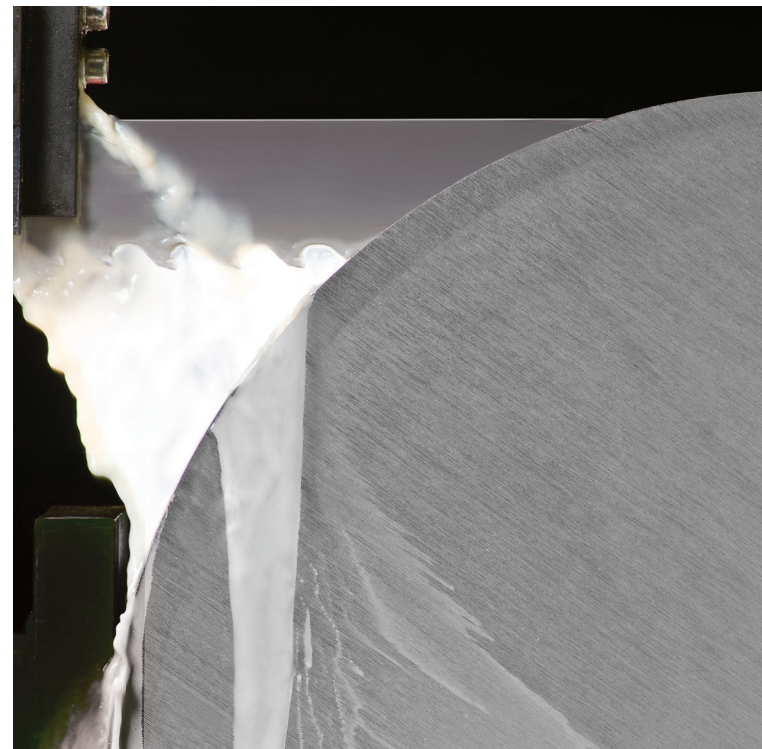
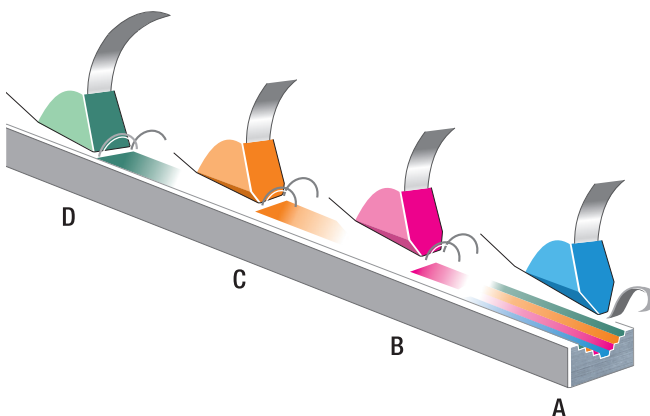


| Width x Thickness |           | Pitch/Rake    | Material No. |
|-------------------|-----------|---------------|--------------|
| in                | mm        |               |              |
| 1-1/4 x .042      | 34 x 1.10 | 2-3/SC-P-T    | 92573        |
| 1-1/2 x .050      | 41 x 1.30 | 1.4-2/SC-P-T  | 92575        |
|                   |           | 2-3/SC-P-T    | 92581        |
| 2 x .063          | 54 x 1.60 | 1.4-2/SC-P-T  | 92578        |
|                   |           | 2-3/SC-P-T    | 92582        |
| 2-5/8 x .063      | 67 x 1.60 | .9-1.1/SC-P-T | 92583        |
|                   |           | 1.4-2/SC-P-T  | 92584        |
| 3-1/8 X 0.63      | 80 X 1.60 | .9-1.1/SC-P-T | 92594        |
|                   |           | 1.4-2/SC-P-T  | 92595        |

P - Positive rake | SC - Septuple chip | T - Trapezoid set  
Furnished in welded bands.  
Special products on request.



MC7 (Seven Multiple Chips)





# CARBIDE

## ADVANTZ™ MC5



### FEATURES

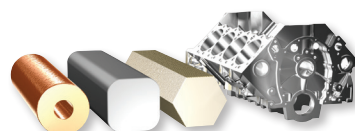
- Exclusive Starrett tooth geometry
- Carbide tipped
- Ground tooth produces 5 chips
- Utilizes a multiple chip grind with a high/low tooth sequence
- Positive rake angle
- Submicron carbide (HV1600)

### BENEFITS

- Higher productivity through reduced cutting time
- Precision cuts - superb surface finish
- Excellent "cost per cut" for production cutting
- Starrett exclusive edge preparation - minimizes micro chipping
- The chip load is spread out over more teeth to facilitate longer life

### APPLICATIONS

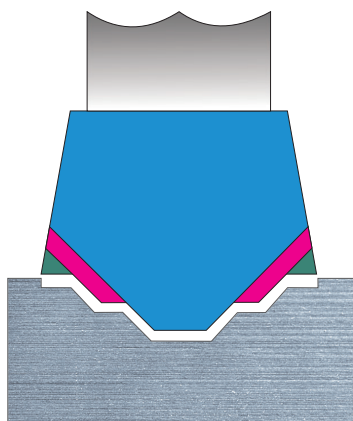
- Alloy tool steels
- Aerospace alloys
- Stainless steel
- Nickel alloys
- Automotive aluminum casting blocks
- Cast iron



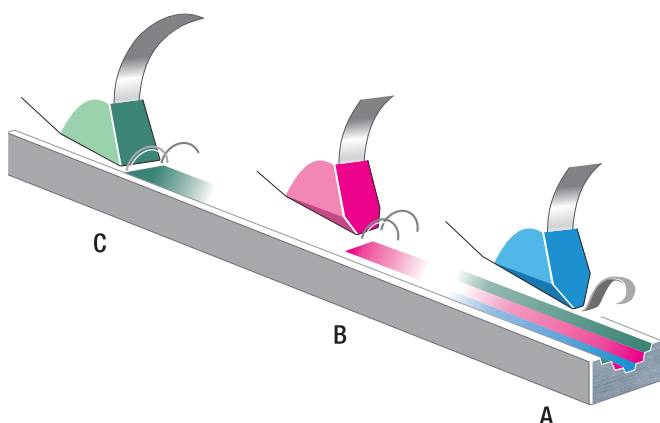
CARBIDE

| Width x Thickness<br>in | mm        | Pitch/Rake     | Material No. |
|-------------------------|-----------|----------------|--------------|
|                         |           |                |              |
| 1-1/4 x .042            | 34 x 1.10 | 2-3/QC-P-T     | 92572        |
| 1-1/2 x .050            | 41 x 1.30 | 1.4-2/QC-P-T   | 92574        |
|                         |           | 2-3/QC-P-T     | 92586        |
| 2 x .063                | 54 x 1.60 | 1.4-2/QC-P-T   | 92577        |
|                         |           | 2-3/QC-P-T     | 92580        |
| 2-5/8 x .063            | 67 x 1.60 | .9-1.1/ QC-P-T | 92533        |
|                         |           | 1.4-2/QC-P-T   | 92598        |
|                         |           | .9-1.1/QC-P-T  | 92545        |
| 3-1/8 x .063            | 80 x 1.60 | 1.4-2/QC-P-T   | 92585        |
|                         |           |                |              |

P - Positive rake | QC - Quintuple chip | T - Trapezoid set  
Furnished in welded bands.  
Special products on request.



MC5 (Five Multiple Chips)



## NOW AVAILABLE WITH NEW AMP TECHNOLOGY!



The new AMP technology available on Starrett band saw blades increases cutting efficiency and blade life. A custom back edge enhancement on the blade generates a rocking motion while cutting which results in an increase in tooth penetration without added feed pressure. This cutting motion also serves to minimize surface contact area, increasing the blade life on hard to cut alloys.

# CARBIDE

## ADVANZ™ TS

Starrett® Advanz™ TS

### FEATURES

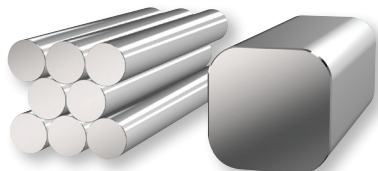
- Carbide tipped teeth
- Triple chip tooth geometry
- Aggressive Rake angle

### BENEFITS

- General purpose cutting
- Ferrous and non-ferrous metals
- Reduced cutting time - Higher productivity
- Precise cuts producing excellent finish
- Excellent "cost per cut" for production cutting
- Good for less rigid saw machines

### APPLICATIONS

- High-alloy metals
- Aerospace alloys
- Stainless steel
- Nickel alloys
- Hard and abrasive materials
- For machines with hydraulic feed control
- Cast iron
- Brass, bronze, copper



| Width x Thickness |           | Pitch/Rake   | Material No. |
|-------------------|-----------|--------------|--------------|
| in                | mm        |              |              |
| 1/2 x .035        | 13 x 0.90 | 3/TC-P-T     | 92593        |
|                   |           | 3-4/TC-P-T   | 92503        |
| 3/4 x .035        | 19 x 0.90 | 3/TC-P-T     | 92500        |
| 3/4 x .050        |           | 3/TC-P-T     | 92571        |
| 1 x .035          | 27 x 0.90 | 3-4/TC-P-T   | 92509        |
|                   |           | 3/TC-P-T     | 92504        |
| 1-1/4 x .042      | 34 x 1.10 | 2-3/TC-P-T   | 92515        |
|                   |           | 3-4/TC-P-T   | 92517        |
|                   |           | 1.4-2/TC-P-T | 92521        |
| 1-1/2 x .050      | 41 x 1.30 | 2-3/TC-P-T   | 92516        |
|                   |           | 3-4/TC-P-T   | 92569        |

P - Positive rake | TC - Triple chip | T - Trapezoid set

Furnished in welded bands.

Special products on request.

| Width x Thickness |           | Pitch/Rake    | Material No. |
|-------------------|-----------|---------------|--------------|
| in                | mm        |               |              |
| 2 x .063          | 54 x 1.60 | 1.4-2/TC-P-T  | 92559        |
|                   |           | 2-3/TC-P-T    | 92528        |
| 2-5/8 x .063      | 67 x 1.60 | .9-1.1/TC-P-T | 92560        |
|                   |           | 1.4-2/TC-P-T  | 92561        |
| 3-1/8 x .063      | 80 x 1.60 | 1.4-2/TC-P-T  | 92563        |

P - Positive rake | TC - Triple chip | T - Trapezoid set

Furnished in welded bands.

Special products on request.



# CARBIDE

## ADVANZ™ CS

Starrett® Advanz™ CS

### FEATURES

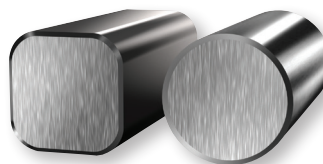
- Carbide tipped teeth
- Triple chip tooth geometry
- Negative Rake angle

### BENEFITS

- Ideal for cutting hardened materials
- High resistance to abrasion
- Reduced cutting time - Higher productivity
- Precise cuts produces excellent finish

### APPLICATIONS

- Case hardened steel
- Steel for shafts and linear guides
- Case hardened materials up to 60 HRC

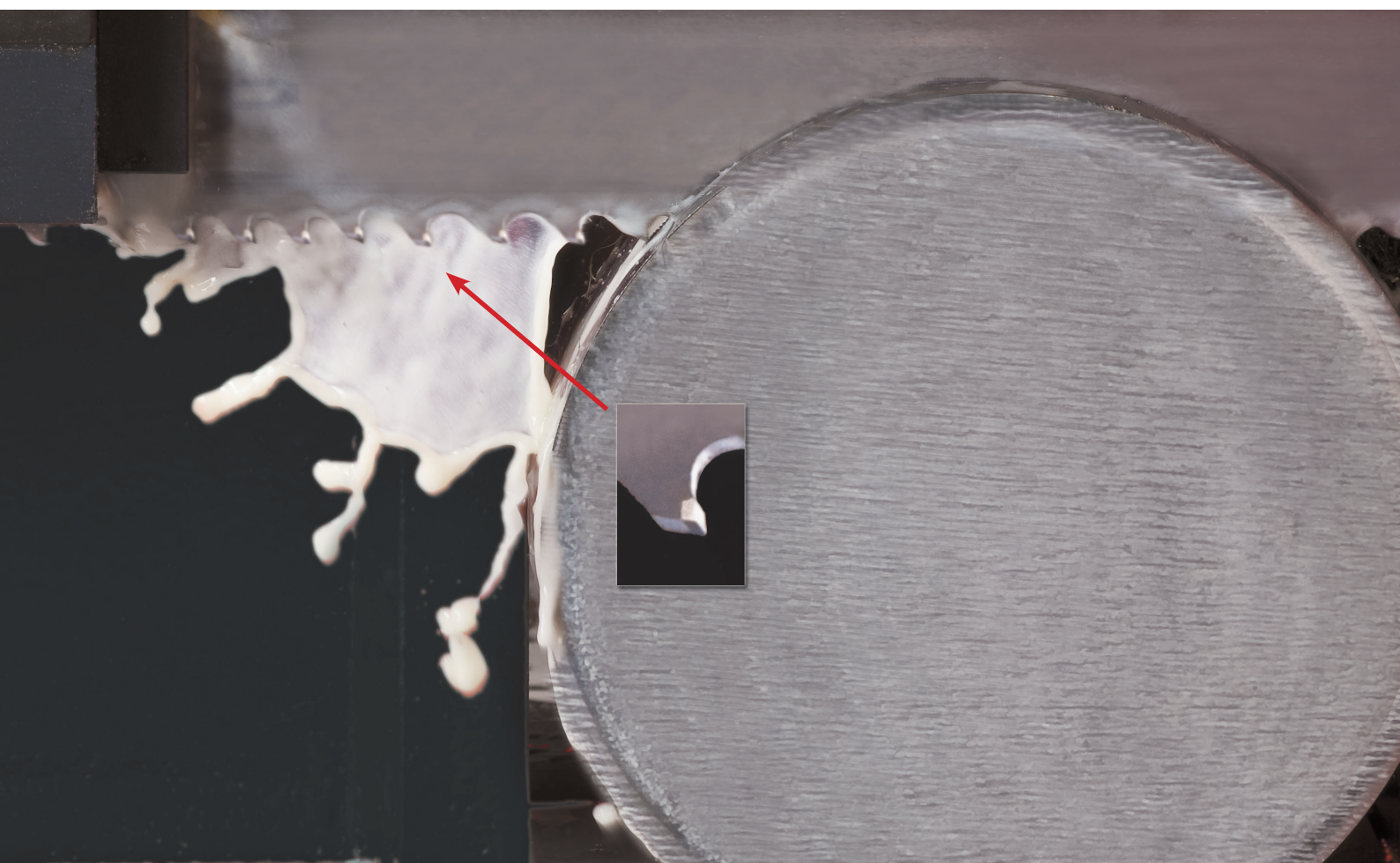


| Width x Thickness |           | Pitch/Rake | Material No. |
|-------------------|-----------|------------|--------------|
| in                | mm        |            |              |
| 1 x .035          | 27 x 0.90 | 3-4/TC-N-T | 92564        |
| 1-1/4 x .042      | 34 x 1.10 | 3-4/TC-N-T | 92565        |
| 1-1/2 x .050      | 41 x 1.30 | 2-3/TC-N-T | 92576        |
|                   |           | 3-4/TC-N-T | 92570        |
| 2 x .063          | 54 x 1.60 | 2-3/TC-N-T | 92592        |

N - Negative rake | TC - Triple chip | T - Trapezoid set

Furnished in welded bands.

Special products on request.



CARBIDE



## CARBIDE

## ADVANZ™ FS

Starrett® Advanz™ FS

## FEATURES

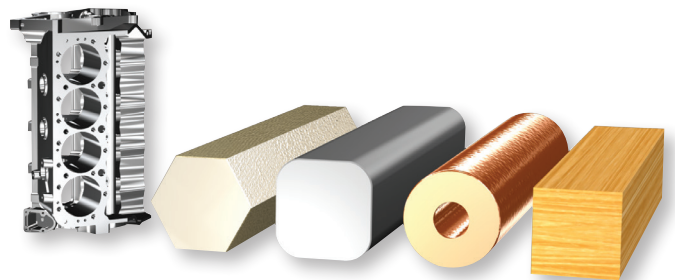
- Carbide tipped teeth
- Triple chip tooth geometry
- Positive Rake angle

## BENEFITS

- Ideal for cutting abrasive materials
- Exceptional resistance to fatigue, abrasion and shocks
- Reduced cutting time-Higher productivity
- Precise cuts and excellent finishing

## APPLICATIONS

- Abrasive non-ferrous metals
- Aluminum
- Cast materials and risers
- Composite materials
- Fiberglass
- Graphite
- Abrasive and hardwoods such as Tauari and others
- Robust vertical and horizontal machines



| Width x Thickness |           | Pitch/Rake | Material No. |
|-------------------|-----------|------------|--------------|
| in                | mm        |            |              |
| 3/4 x .035        | 19 x 0.90 | 2-3/TC-P-T | 92546        |
|                   |           | 3/TC-P-T   | 92550        |
| 1 x .035          | 27 x 0.90 | 2-3/TC-P-T | 92507        |
|                   |           | 3/TC-P-T   | 92552        |
| 1 x .050          | 27 x 1.30 | 3/TC-P-T   | 92553        |
| 1-1/4 x .042      | 34 x 1.10 | 3/TC-P-T   | 92513        |
| 1-1/4 x .050      | 34 x 1.30 | 3/TC-P-T   | 92555        |

P - Positive rake | TC - Triple chip | T - Trapezoid set

Furnished in welded bands.

Special products on request.





CARBIDE GRIT / DIAMOND GRIT



## CARBIDE GRIT

## ADVANZ™ CG

Starrett® Advanz™ CG

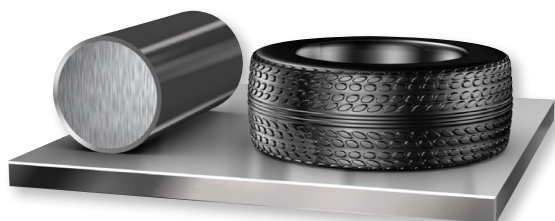
Starrett® Advanz™ CG

## FEATURES

- With continuous or gulletted cutting edge
- High fatigue resistance

## BENEFITS

- Ideal for cutting hard and/or abrasive materials
- Precise cuts and excellent finishing
- Superior durability



| Width x Thickness |           | Edge Type  | Grade         | Material No. |
|-------------------|-----------|------------|---------------|--------------|
| in                | mm        |            |               |              |
| 1/4 x .020        | 6 x 0.50  | Gullet     | Medium        | 95401        |
|                   |           | Gullet     | Medium        | 95403        |
| 3/8 x .025        | 10 x 0.65 | Gullet     | Medium/Coarse | 95404        |
|                   |           | Continuous | Medium        | 95406        |
| 1/2 x .020        | 13 x 0.50 | Continuous | Medium        | 95414        |
|                   |           | Gullet     | Medium        | 95407        |
| 1/2 x .025        | 13 x 0.65 | Gullet     | Medium/Coarse | 95408        |
|                   |           | Continuous | Medium        | 95410        |
|                   |           | Gullet     | Medium        | 95416        |
|                   |           | Gullet     | Medium/Coarse | 95417        |
| 3/4 x .032        | 19 x 0.80 | Gullet     | Coarse        | 95418        |
|                   |           | Continuous | Medium        | 95419        |
|                   |           | Continuous | Coarse        | 95421        |
|                   |           | Gullet     | Medium/Coarse | 95422        |
| 1 x .035          | 25 x 0.90 | Gullet     | Coarse        | 95423        |
|                   |           | Continuous | Medium        | 95425        |
| 1-1/4 x .035      | 32 x 0.90 | Gullet     | Coarse        | 95430        |
|                   |           | Continuous | Coarse        | 95431        |
| 1-1/4 x .042      | 32 x 1.10 | Gullet     | Medium/Coarse | 95432        |
| 1-1/2 x .042      | 38 x 1.10 | Gullet     | Coarse        | 95440        |

Furnished in welded bands. 100' and 250' coils.  
Special products on request.

| Cat. No. | EDP   | Length |     | Width x Thickness |           | Pitch/Rake |
|----------|-------|--------|-----|-------------------|-----------|------------|
|          |       | in     | cm  | in                | mm        |            |
| CG4CM    | 19954 | 44-7/8 | 114 | 1/2 x .020        | 13 x 0.50 | Continuous |

S - Straight (Zero) rake | W - Wavy Set, Zero rake | P - Positive rake  
Packaged 1 per box

## APPLICATIONS

- Steel-belted tires
- Composite materials
- Reinforced plastics
- Composite Graphite
- Case-Hardened steels
- Fiberglass





# DIAMOND GRIT

## ADVANZ™ DG

### FEATURES

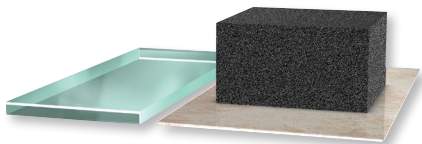
- Cutting edge coated with diamond grains
- Continuous cutting edge
- High strength body

### BENEFITS

- Ideal for cutting abrasive materials that conventional blades cannot cut
- Precise cuts and excellent finishing
- Exceptional durability and fatigue resistance

### APPLICATIONS

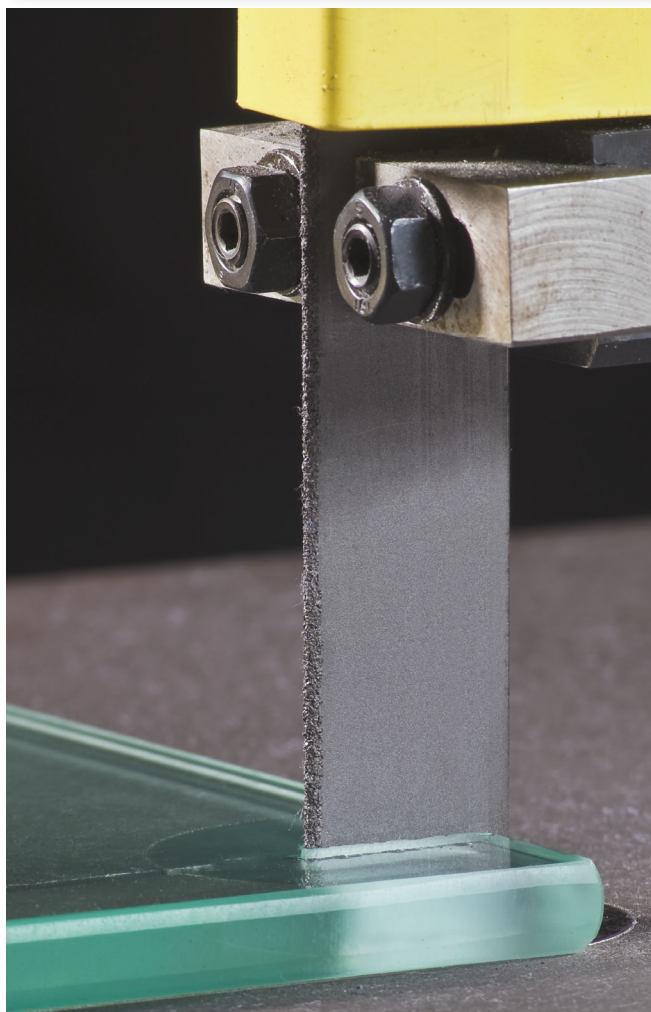
- Glass
- Glazed ceramic
- Silicon
- Graphite
- Fiberglass
- Stones
- Pyrex
- Ideal for machines that have high cutting speed



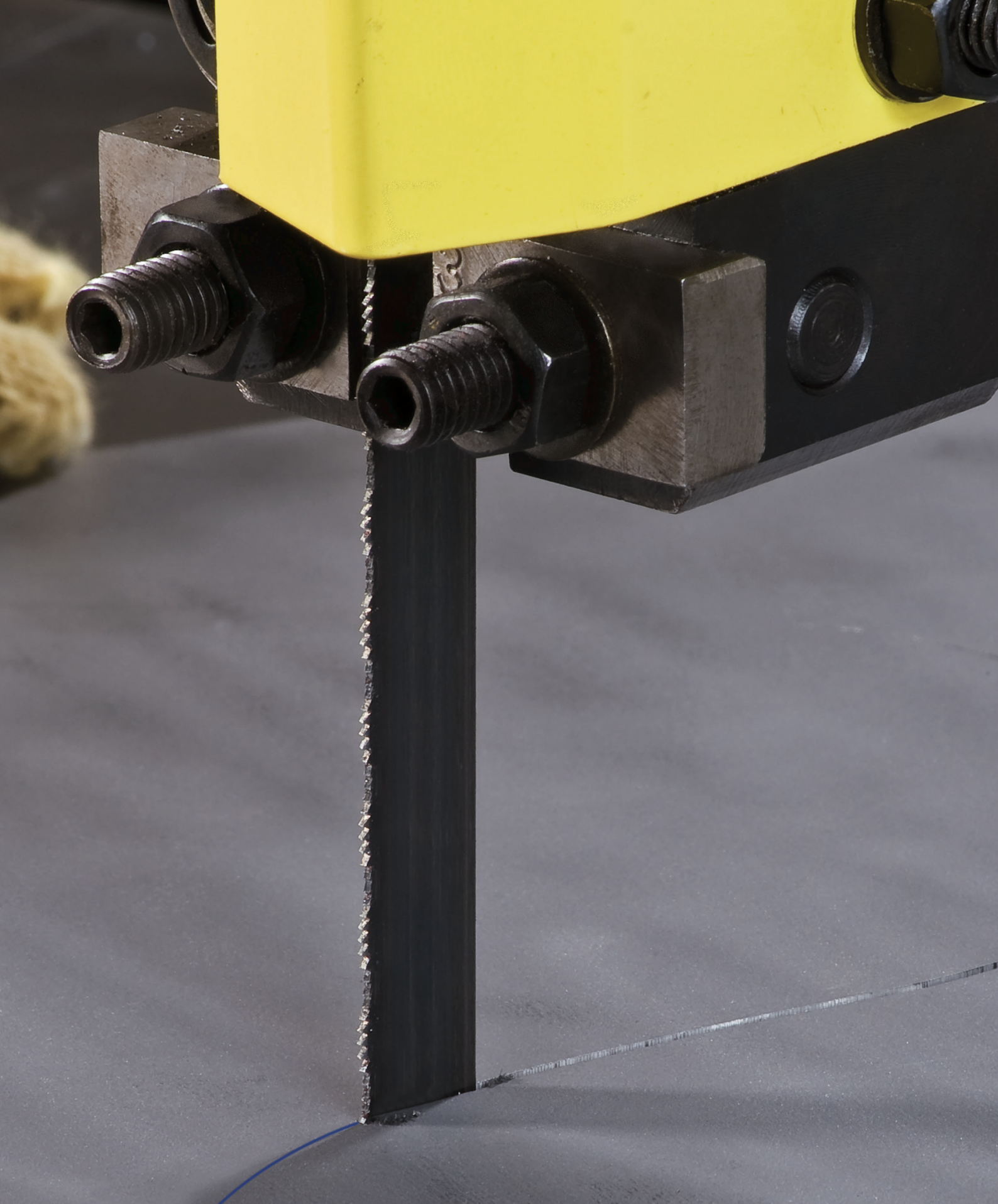
| Width x Thickness<br>in mm | Edge Type  | Grit Size | Grade         | Material No. |
|----------------------------|------------|-----------|---------------|--------------|
| 1/2 x .020 13 x 0.50       | Continuous | 40/50     | Medium Coarse | 95122        |
|                            |            | 60/80     | Medium Fine   | 95123        |
|                            |            | 100/120   | Fine          | 95124        |
| 3/4 x .020 19 x 0.50       | Continuous | 40/50     | Medium Coarse | 95125        |
|                            |            | 60/80     | Medium Fine   | 95126        |
|                            |            | 100/120   | Fine          | 95127        |
| 3/4 x .040 19 x 1          | Continuous | 170/200   | Extra Fine    | 95128        |
|                            |            | 30/40     | Coarse        | 95129        |
|                            |            | 40/50     | Medium Coarse | 95243        |
| 1 x .020 25 x 0.50         | Continuous | 60/80     | Medium Fine   | 95244        |
|                            |            | 100/120   | Fine          | 95245        |
|                            |            | 170/200   | Extra Fine    | 95246        |
| 1 x .040 25 x 1            | Continuous | 20/30     | Extra Course  | 95247        |
|                            |            | 30/40     | Coarse        | 95248        |
|                            |            | 40/50     | Medium Coarse | 95249        |
| 1-1/4 x .020 32 x 0.50     | Continuous | 60/80     | Medium Fine   | 95250        |
|                            |            | 40/50     | Medium Coarse | 95251        |
|                            |            | 60/80     | Medium Fine   | 95252        |
| 1-1/4 x .040 32 x 1        | Continuous | 100/120   | Fine          | 95253        |
|                            |            | 20/30     | Extra Coarse  | 95254        |
|                            |            | 30/40     | Coarse        | 95255        |
| 1-1/2 x .020 38 x 0.50     | Continuous | 60/80     | Medium Fine   | 95256        |
|                            |            | 40/50     | Medium Coarse | 95257        |
|                            |            | 30/40     | Coarse        | 95258        |
| 2 x .040 50 x 1            | Continuous | 30/40     | Coarse        | 95259        |
|                            |            | 60/80     | Medium Fine   | 95260        |

Furnished in welded bands only.  
Diamond Grit blades are Made-to-Order items.  
Longer standard lead time applies - inquire for details.  
Special products on request.

Starrett® Advanz™ DG







CARBON



# CARBON

## DURATEC™ SFB

Starrett® Duratec™ SFB

### FEATURES

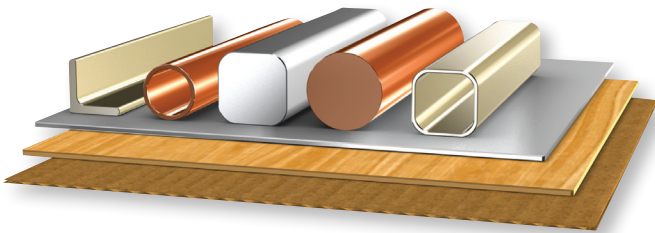
- Made from special high carbon steel
- Flexible back

### BENEFITS

- Contour and straight cutting
- Economical
- Can be welded with "standard" welders

### APPLICATIONS

- Easy-to-machine carbon steel
- Non-ferrous metals
- Composites and plastics
- Plywood and MDF
- Cardboard
- Ideal for light vertical and horizontal machines
- Mechanical workshops, toolroom, carpentry, etc.





## DURATEC™ SFB

| Width x Thickness<br>in | mm        | Pitch/Rake | Material No. |
|-------------------------|-----------|------------|--------------|
| 1/8 x .025              | 3 x 0.65  | 14/RG-S-R  | 91050        |
|                         |           | 18/RG-S-W  | 91060        |
| 3/16 x .025             | 5 x 0.65  | 4/SK-S-R   | 91080        |
|                         |           | 10/RG-S-R  | 91090        |
| 1/4 x .025              | 6 x 0.65  | 4/SK-S-R   | 91120        |
|                         |           | 4/HH-P-R   | 91130        |
|                         |           | 6/SK-S-R   | 91140        |
|                         |           | 6/RG-S-R   | 91151        |
|                         |           | 6/HH-P-R   | 91147        |
|                         |           | 10/RG-S-R  | 91161        |
|                         |           | 14/RG-S-R  | 91181        |
|                         |           | 18/RG-S-R  | 91190        |
|                         |           | 24/RG-S-W  | 91204        |
|                         |           | 32/RG-S-W  | 91210        |
|                         |           | 3/HL-P-R   | 91230        |
|                         |           | 4/SK-S-R   | 91240        |
| 3/8 x .025              | 10 x 0.65 | 4/HH-P-R   | 91250        |
|                         |           | 6/SK-S-R   | 91265        |
|                         |           | 6/RG-S-R   | 91261        |
|                         |           | 6/HH-P-R   | 91264        |
|                         |           | 8/RG-S-R   | 91271        |
|                         |           | 10/RG-S-R  | 91281        |
|                         |           | 14/RG-S-R  | 91291        |
|                         |           | 18/RG-S-R  | 91300        |
|                         |           | 24/RG-S-W  | 91307        |
|                         |           | 3/HL-P-R   | 91930        |
| 3/8 x .035              | 10 x 0.90 | 3/HL-P-R   | 91330        |
|                         |           | 4/SK-S-R   | 91340        |
| 1/2 x .025              | 13 x 0.65 | 4/HH-P-R   | 91350        |
|                         |           | 6/SK-S-R   | 91372        |
|                         |           | 6/RG-S-R   | 91361        |
|                         |           | 6/HH-P-R   | 91373        |
|                         |           | 8/RG-S-R   | 91374        |
|                         |           | 10/RG-S-R  | 91380        |
|                         |           | 14/RG-S-R  | 91401        |
|                         |           | 18/RG-S-R  | 91420        |
|                         |           | 24/RG-S-W  | 91430        |

RG - Regular tooth profile | SK - Skip tooth profile | S - Straight (Zero) rake | R - Raker set | W - Wavy set

HL - Hook Low tooth profile | HH - Hook High tooth profile | P Positive rake

Available in 100' (30m), 250' (75m), 500' (150m) coils and welded bands.

All coils supplied within plus or minus 10% of ordered size.

Special products on request.

| Width x Thickness<br>in | mm        | Pitch/Rake | Material No. |
|-------------------------|-----------|------------|--------------|
| 5/8 x .032              | 16 x 0.80 | 3/HL-P-R   | 91434        |
|                         |           | 3/SK-S-R   | 91435        |
|                         |           | 10/RG-S-R  | 91450        |
|                         |           | 14/RG-S-R  | 91471        |
|                         |           | 3/SK-S-R   | 91510        |
| 3/4 x .032              | 19 x 0.80 | 3/HL-P-R   | 91515        |
|                         |           | 4/SK-S-R   | 91529        |
|                         |           | 4/HH-P-R   | 91528        |
|                         |           | 6/RG-S-R   | 91531        |
|                         |           | 8/RG-S-R   | 91550        |
|                         |           | 10/RG-S-R  | 91570        |
|                         |           | 14/RG-S-R  | 91621        |
|                         |           | 18/RG-S-R  | 91622        |
|                         |           | 2/HL-P-R   | 91670        |
|                         |           | 3/SK-S-R   | 91680        |
| 1 x .035                | 25 x 0.90 | 3/HL-P-R   | 91689        |
|                         |           | 4/RG-S-R   | 91696        |
|                         |           | 6/RG-S-R   | 91701        |
|                         |           | 8/RG-S-R   | 91720        |
|                         |           | 10/RG-S-R  | 91730        |
|                         |           | 14/RG-S-R  | 91761        |

RG - Regular tooth profile | SK - Skip tooth profile | S - Straight (Zero) rake | R - Raker set | W - Wavy set

HL - Hook Low tooth profile | HH - Hook High tooth profile | P Positive rake

Available in 100' (30m), 250' (75m), 500' (150m) coils and welded bands.

All coils supplied within plus or minus 10% of ordered size.

Special products on request.



# CARBON

## DURATEC™ FC



Starrett® Duratec™ FC

| Width x Thickness<br>in |           | mm | Pitch/Rake | Material No. |
|-------------------------|-----------|----|------------|--------------|
| 1 x .035                | 25 x 0.90 |    | 8/RG-S-R   | 91726        |
|                         |           |    | 10/RG-S-R  | 91740        |
|                         |           |    | 4/BC-P-R   | 91769        |

R - Raker set  
 RG - Regular tooth profile | S - Straight (Zero) rake | BC - Bearcat tooth profile | P - Positive rake  
 Available in 100' (30m) coils and welded bands.  
 All coils supplied within plus or minus 10% of ordered size.  
 Special products on request.

### FEATURES

- Made of high-carbon steel with high Silicon-content
- Flexible backer for excellent fatigue resistance
- Special set design for increased frictional heat
- Special "air scoop" design teeth
- Fully hardened teeth and tempered back

### BENEFITS

- Ideal for cutting materials that conventional blades cannot cut
- High resistance to wear and abrasion
- Teeth specifically designed to bring oxygen into the cut to burn up the material

### APPLICATIONS

- Steel-belted radial tires
- Cuts thin, ferrous sections up to 5/8" (16mm)
- Weldments, sheet metal, unconventional shapes
- Vertical machines with speeds up to 15,000 SFPM

CARBON



## CARBON BAND KNIVES

### FEATURES

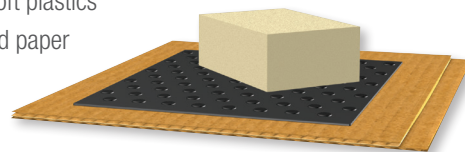
- Available with straight, scallop or wavy tooth cutting edges and a single or double edge bevel
- Made of high-carbon steel and stainless steel
- Razor edge

### BENEFITS

- Quick, smooth and precise cuts, with excellent finishing
- Without material waste

### APPLICATIONS

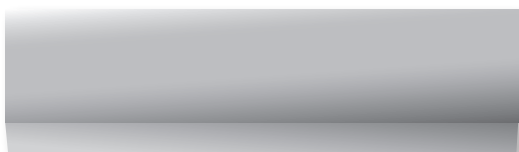
- Foam
- Rubber and soft plastics
- Cardboard and paper
- Cork



Straight Edge, Single Bevel



Straight Edge, Double Bevel



Scallop Edge, Double Bevel



Wavy Edge, Double Bevel



| Width x Thickness |           | Edge and Bevel | Material No. |
|-------------------|-----------|----------------|--------------|
| in                | mm        |                |              |
| 3/8 x .022        | 10 x 0.55 | SC-DB          | 93126        |
|                   |           | ST-SB          | 93135        |
| 1/2 x .022        | 13 x 0.55 | ST-DB          | 93160        |
|                   |           | SC-DB          | 93189        |
|                   |           | WV-DB          | 93388        |
| 5/8 x .018        | 16 x 0.46 | SC-DB          | 93580*       |
| 5/8 x .022        | 16 x 0.55 | SC-DB          | 93590        |
|                   |           | ST-DB          | 93609        |
|                   |           | SC-DB          | 93637        |
| 3/4 x .022        | 19 x 0.55 | WV-DB          | 93715        |
|                   |           | SC-DB          | 93629        |
|                   |           | WV-DB          | 93717        |
| 3/4 x .028        | 19 x 0.70 | ST-DB          | 93794        |
|                   |           | SC-DB          | 93806        |
| 1 x .025          | 25 x 0.60 | ST-DB          | 93796        |
|                   |           | SC-DB          | 93809        |
| 1 x .035          | 25 x 0.90 | SC-DB          | 93809        |
|                   |           | WV-DB          | 93912        |

ST-SB - Straight edge - Single bevel

ST-DB - Straight edge - Double bevel

SC-DB - Scallop edge - Double Bevel

WV-DB - Wavy edge - Double Bevel

Available in 100' (30m), 250' (75m), random length coils and welded bands.

\*Stainless steel blade.

Special products on request.





WOOD CUTTING



# XPW TECHNOLOGY

## EXTREME PERFORMANCE FOR WOOD



## XPW TECHNOLOGY

The technology and knowledge from our bi-metal range have been adapted and enhanced to meet the demands of wood applications. XPW Technology is available in both our bi-metal and high carbon blades and is designed for optimal precision, guaranteeing unparalleled cutting efficiency with minimal chips and enhanced quality in every cut.

## NEW TOOTH PROFILE

Our new and exclusive tooth profile is designed for sawmill and re-saw applications, ensuring precision at high speeds. It is compatible with the most popular grinders on the market.

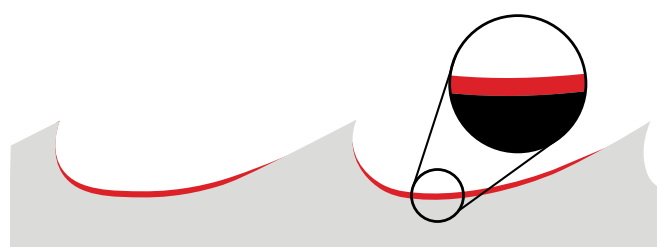
## FEATURES & BENEFITS

- Superior cutting finish
- Enhanced durability for increased product lifespan
- High fatigue resistance ensures high-quality cuts and superior durability

## GRINDING WHEEL FOR REGRINDING

To complement the XPW technology, we offer a new range of grinding wheels.

| Outside Diameter x Bore Diameter<br>in | mm       | TPI | Catalog No. |
|----------------------------------------|----------|-----|-------------|
| 6 x 1.260                              | 150 x 32 | 1.1 | REB-22.22   |
| 6 x 1.260                              | 150 x 32 | 1.3 | REB-20      |



XPW Technology includes a deeper gullet when compared to previous Woodpecker blades.





# WOOD CUTTING

WOODPECKER™ PREMIUM

CARBON STEEL



## FEATURES

- Hardened spring-tempered steel back
- Positive angle precision set teeth
- Thin kerf available
- XPW technology on select materials

## BENEFITS

- Available as thin as .020" (0.50mm) for contour cutting fine hardwoods, thicker blades are also available for tougher tasks, such as grade lumber re-saws and pallet dismantling work.
- Longer life and faster cutting with less feed
- High production rates and increased yields
- Can be re-sharpened

## APPLICATIONS

- Compatible with all types of cutting machines
- Capable of cutting softwoods, hardwoods and exotic woods
- Excels in a variety of applications including cutting lumber, boards and panels
- XPW technology ideal for sawmill and re-saw applications

| Width x Thickness |            | Tooth Shape | Tooth Pitch (TPI) | Rake   | Material No. | XPW |
|-------------------|------------|-------------|-------------------|--------|--------------|-----|
| in                | mm         |             |                   |        |              |     |
| 1/4 x .020        | 6.5 x 0.50 | Skip        | 6                 | SK-S-R | 91992        | -   |
| 3/8 x .022        | 10 x 0.55  | Hook        | 4                 | HK-P-R | 91996        | -   |
|                   |            | Skip        | 6                 | SK-S-R | 91997        | -   |
| 1/2 x .022        | 13 x 0.55  | Hook        | 3                 | HK-P-R | 92000        | -   |
|                   |            | Hook        | 4                 | HK-P-R | 92001        | -   |
|                   |            | Skip        | 6                 | SK-S-R | 92002        | -   |
| 5/8 x .022        | 16 x 0.55  | Hook        | 3                 | HK-P-R | 92003        | -   |
|                   |            | Hook        | 4                 | HK-P-R | 92004        | -   |
| 3/4 x .028        | 19 x 0.70  | Hook        | 3                 | HK-P-R | 92007        | -   |
| 1 x .023          | 27 x 0.55  | Hook        | 3                 | HK-P-R | 92010        | -   |
| 1 x .035          | 27 x 0.90  | Hook        | 1.3               | HK-P-R | 92035        | XPW |
|                   |            | Hook        | 2                 | HK-P-R | 92036        | -   |
| 1-1/4 x .035      | 32 x 0.90  | Hook        | 1.3               | HK-P-R | 92043        | XPW |
|                   |            | Hook        | 1.1               | HK-P-R | 92042        | XPW |
| 1-1/4 x .042      | 32 x 1.10  | Hook        | 1.1               | HK-P-R | 92017        | XPW |
| 1-1/2 x .042      | 38 x 1.10  | Hook        | 1.3               | HK-P-R | 92018        | XPW |
| 1-1/2 x .042      | 38 x 1.10  | Hook        | 1.1               | HK-P-R | 92022        | XPW |
| 2 x .042          | 50 x 1.10  | Hook        | 1.1               | HK-P-R | 92026        | XPW |
| 2-9/16 x .042     | 65 x 1.10  | Hook        | 1.1               | HK-P-R | 92030        | XPW |

HK - Hook tooth profile | P - Positive rake | R - Raker set  
SK - Skip tooth profile | S - Straight (zero) rake | R - Raker set

Available in 100' (30m), 250' (75m), 500' (150m), random length coils and welded bands  
All coils supplied within plus or minus 10% of ordered size.

Special products on request.



WOOD CUTTING

# WOOD CUTTING

## WOODPECKER™ PRO

BI-METAL



### FEATURES

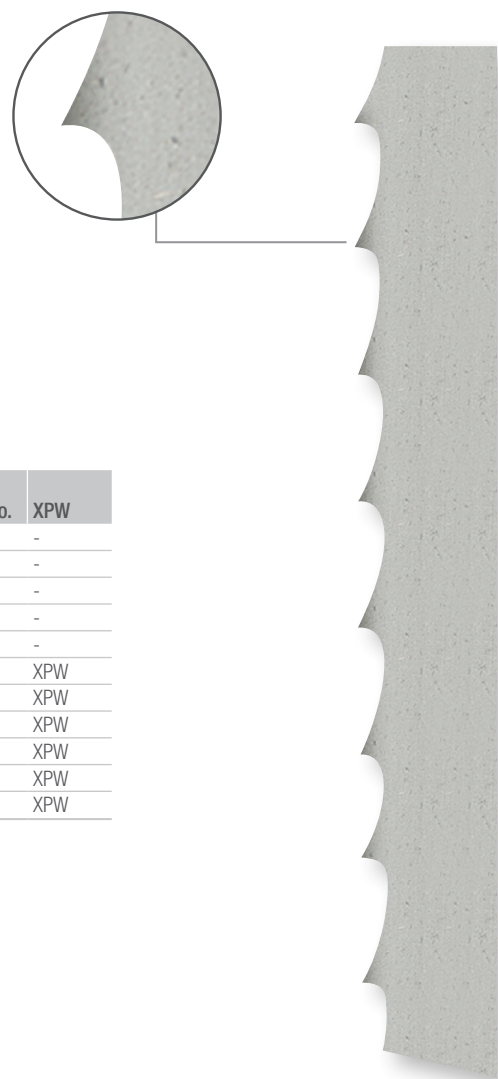
- Manufactured from high-speed steel M42 containing 8% cobalt
- Electron beam welded bi-metal construction
- Rockwell tooth hardness C67-69 ensures longer blade life
- XPW technology available on select materials

### BENEFITS

- Wide range widths and thickness to cover fine contour cutting and tougher cutting applications like lumber re-saws and pallet dismantling work
- Increased blade lifespan with bi-metal construction and tooth geometry
- High fatigue resistance ensures long lasting durability
- Improved cutting performance producing precise cuts with minimal waste
- Can be resharpened

### APPLICATIONS

- Compatible with all types of cutting machines
- Highly effective on all types of softwoods, hardwoods and exotic woods
- XPW technology ideal for sawmill and re-saw applications



| Width x Thickness |            | Tooth Shape | Tooth Pitch (TPI) | Rake   | Material No. | XPW |
|-------------------|------------|-------------|-------------------|--------|--------------|-----|
| in                | mm         |             |                   |        |              |     |
| 1/4 x .025        | 6.5 x 0.65 | Hook        | 6                 | HK-P-R | 92100        | -   |
| 3/8 x .025        | 10 x 0.65  | Hook        | 4                 | HK-P-R | 92101        | -   |
| 1/2 x .025        | 13 x 0.65  | Hook        | 3                 | HK-P-R | 92102        | -   |
| 3/4 x .035        | 19 x 0.90  | Hook        | 3                 | HK-P-R | 92103        | -   |
| 1 x .035          | 27 x 0.90  | Hook        | 2                 | HK-P-R | 92104        | -   |
| 1-1/4 x .035      | 34 x 0.90  | Hook        | 1.1               | HK-P-R | 92105        | XPW |
|                   |            | Hook        | 1.3               | HK-P-R | 92106        | XPW |
| 1-1/4 x .042      | 34 x 1.10  | Hook        | 1.1               | HK-P-R | 92109        | XPW |
|                   |            | Hook        | 1.3               | HK-P-R | 92108        | XPW |
| 1-1/2 x .050      | 41 x 1.30  | Hook        | 1.1               | HK-P-R | 92110        | XPW |
| 2 x .063          | 54 x 1.30  | Hook        | 1.1               | HK-P-R | 92111        | XPW |

HK - Hook tooth profile | P - Positive rake | R - Raker set  
 Available in 100' (30m), 250' (75m), random length coils and welded bands.  
 All coils supplied within plus or minus 10% of ordered size.  
 Special products on request.



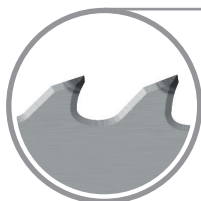
# WOOD CUTTING

## WOODPECKER™ CT

### CARBIDE TIPPED

NEW  
PRODUCT

AN IDEAL SOLUTION  
FOR CUTTING HARD  
AND ABRASIVE WOOD!



#### FEATURES

- Carbide-tipped teeth for enhanced strength
- Teeth precision-ground with triple sharpening for superior cutting
- Aggressively angled teeth for optimal cutting efficiency

#### BENEFITS

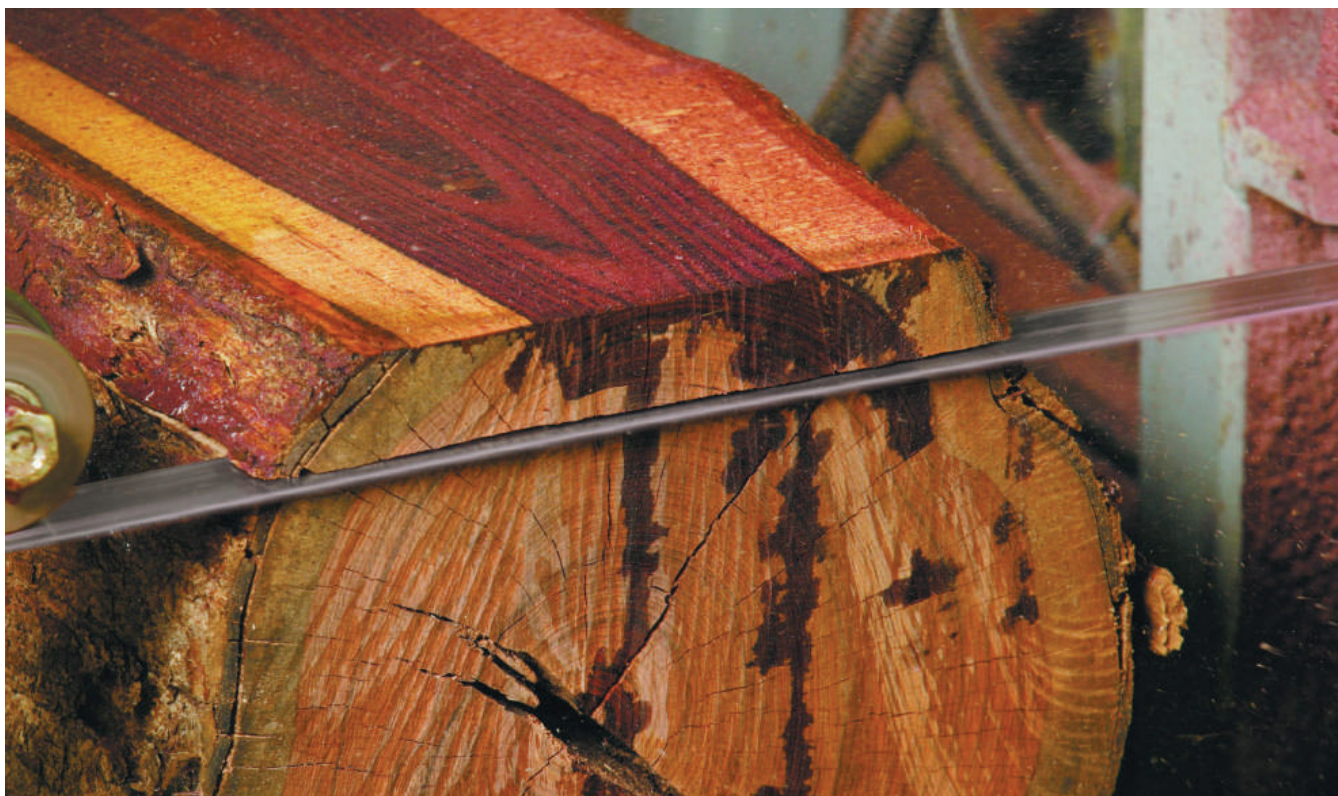
- High fatigue resistance for lasting durability
- Excellent cutting finish
- Contour cutting for versatile applications
- Reduces cutting time, improving productivity

#### APPLICATIONS

- Compatible with all types of cutting machines
- Superior performance for cutting hard, abrasive and frozen wood especially in high-volume production cutting environments
- Ideal for use on railroad ties, hardwoods and exotic woods

| Width x Thickness |           | Tooth Pitch (TPI) | Rake    | Kerf (Inches) | Material No. |
|-------------------|-----------|-------------------|---------|---------------|--------------|
| in                | mm        |                   |         |               |              |
| 1/2 x .032        | 13 x 0.80 | 3                 | WCT-P-T | 0.051         | 92200        |
| 1/2 x .035        | 13 x 0.90 | 3                 | WCT-P-T | 0.062         | 92204        |
| 3/4 x .035        | 19 x 0.90 | 3                 | WCT-P-T | 0.062         | 92205        |
| 1 x .035          | 27 x 0.90 | 1.3               | WCT-P-T | 0.053         | 92201        |
|                   |           | 3                 | WCT-P-T | 0.062         | 92206        |
| 1-1/4 x .042      | 34 x 1.10 | 1.3               | WCT-P-T | 0.060         | 92202        |
|                   |           | 3                 | WCT-P-T | 0.068         | 92207        |
| 2 x .035          | 54 x 0.90 | 1.3               | WCT-P-T | 0.053         | 92203        |

WCT - Woodpecker Carbide Tipped | P - Positive rake | T - Trapezoid set  
Furnished in welded bands  
Special products on request.







PRECISION MAKES THE DIFFERENCE

GOES THE  
DISTANCE.



**Starrett®**

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FOOD PROCESSING



# FOOD PROCESSING

## MEATKUTTER™ PREMIUM

### MKP



#### FEATURES

- High carbon steel with a polished finish
- Precision ground, hardened teeth
- Engraved laser-etched identification
- USDA approved

#### BENEFITS

- Highly durable blades with stronger teeth
- Fast, smooth, and clean cuts
- Less kerf loss per cut and higher yield
- Guarantee of origin and traceability

#### APPLICATIONS

- Great general-purpose blade for fresh meat, frozen meat and prepared foods
- Suitable for cutting meat, bone-in or boneless
- Ideal for butcher shops, supermarkets, meatpacking, case ready facilities and secondary cutting operations

#### MEAT TYPES

- Fresh, frozen, bone-in and boneless
- Poultry
- Seafood and fish
- Beef, pork, lamb, goat and bison

| Width x Thickness<br>in | mm              | Pitch/Rake | Material No. |
|-------------------------|-----------------|------------|--------------|
| 1/2 x .022              | 13 x 0.55       | 3/HK-P-A   | 94310        |
|                         |                 | 4/HK-P-A   | 94311        |
|                         |                 | 6/SK-S-A   | 94312        |
| 5/8 x .018              | 16 x 0.46       | 4/HK-P-A   | 94314        |
|                         |                 | 6/SK-S-A   | 94315        |
| 5/8 x .022              | 16 x 0.55       | 3/HK-P-A   | 94316        |
|                         |                 | 4/HK-P-A   | 94317        |
|                         |                 | 8/RG-S-A   | 94328        |
| 5/8 x .025              | 16 x 0.65       | 3/HK-P-A   | 94325        |
|                         |                 | 4/HK-P-A   | 94326        |
| 3/4 x .022              | 19 x .055       | 3/HK-P-A   | 94318        |
|                         |                 | 4/HK-P-A   | 94319        |
| 3/4 x .022 x 8          | 19 x .055 x 203 | 8/RG-S-A   | 94320        |

HK - Hook tooth profile | P - Positive rake | A - Alternate set

SK - Skip tooth profile | S - Straight (zero) rake | RG - Regular tooth profile

Available in 100' (30m), 250' (75m), 500' (150m), random length coils and welded bands.

All coils supplied within plus or minus 10% of ordered size.

Special products on request.



**Starrett**

**Meatkutter™  
Premium**

5/8 x .018"

5/8 x .022"

16 x 0.46mm

**X6**

OP21221504





## FOOD PROCESSING



### MEATKUTTER™ STAINLESS MKS

#### FEATURES

- Stainless steel AISI 420
- Rust-proof
- Precision ground teeth
- Engraved laser-etched identification
- USDA approved

#### BENEFITS

- Highly resistant to rust to maintain the perfect condition of blades quality
- Fast, smooth and clean cuts
- Durable and corrosion resistant
- Guarantee of origin and traceability

#### APPLICATIONS

- Fresh or frozen meat with bone or boneless
- Suitable for butcher shops, supermarkets, meatpacking, case ready facilities and secondary cutting operations
- Best for seafood processing and other high corrosion environments
- Ideal for the medical and science industries

#### MEAT TYPES

- Seafood and fish
- Fresh, frozen, bone-in and boneless
- Beef, pork, lamb and goat
- Poultry

| Width x Thickness |           | Pitch/Rake | Material No. |
|-------------------|-----------|------------|--------------|
| in                | mm        |            |              |
| 5/8 x .018        | 16 x 0.46 | 4/HK-P-A   | 94321        |
|                   |           | 6/SK-S-A   | 94322        |
|                   |           | 10/RG-S-A  | 94327        |

HK - Hook tooth profile | P - Positive rake | A - Alternate set | S - Straight (zero) rake  
SK - Skip tooth profile | RG - Regular tooth profile

Available in 100' (30m), 250' (75m), 500' (150m), random length coils and welded bands  
All coils supplied within plus or minus 10% of ordered size.

Special products on request

**Starrett®**

**Meatkutter™  
Stainless Steel**

5/8 x .018"  
16 x 0.46mm **X6** OP21221688

# FOOD PROCESSING

## CARCASSKUTTER™ PREMIUM CKP



### FEATURES

- Polished high-carbon steel
- Precision ground, hardened, and annealed teeth
- 3 or 4 teeth per inch and excellent balance of width and thickness
- Engraved laser-etched identification
- USDA approved

### BENEFITS

- Highly durable blades with stronger teeth
- Fast, aggressive, straight, accurate cuts with less kerf loss per cut
- Optimum blade flexibility for longer operation
- Guarantee of origin and traceability

### APPLICATIONS

- Carcass splitting of cattle, pig, lamb and goat
- Designed for kill/harvest and further carcass cutting applications
- Ideal for abattoirs, slaughterhouses, meatpacking, processing plants and cold storage facilities

### MEAT TYPES

- Animal carcass cuts
- Beef, pork, lamb, goat and bison

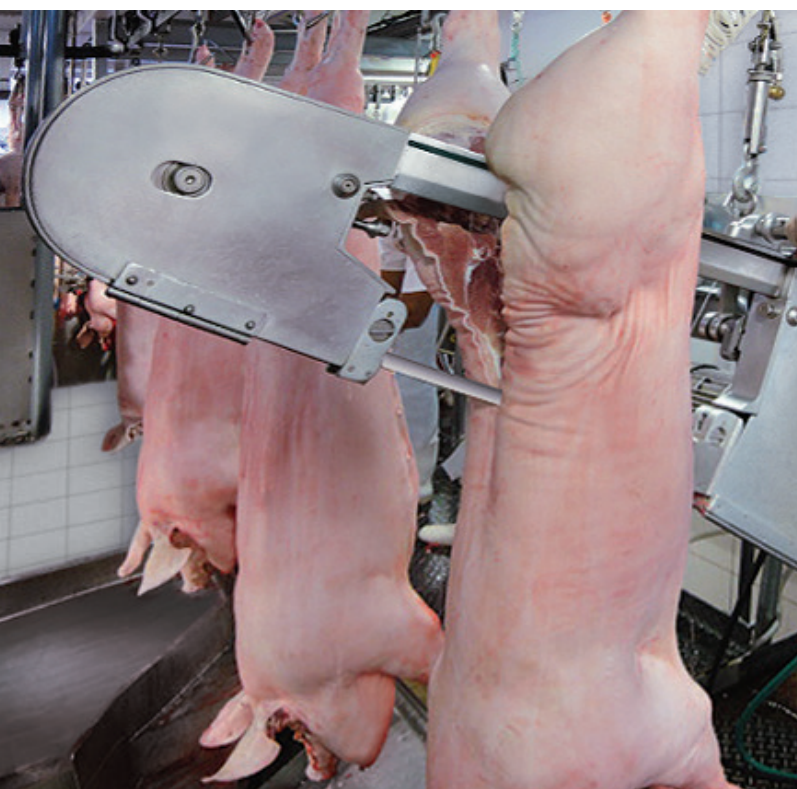


| Width x Thickness |           | Pitch/Rake | Material No. |
|-------------------|-----------|------------|--------------|
| in                | mm        |            |              |
| 3/4 x .022        | 19 x 0.55 | 3/HK-P-A   | 94370        |
|                   |           | 4/HK-P-A   | 94371        |

HK - Hook tooth profile | P - Positive rake | A - Alternate set

Available in 100' (30m), 250' (75m), 500' (150m), random length coils and welded bands  
All coils supplied within plus or minus 10% of ordered size.

Special products on request







# FOOD PROCESSING

## MEATKUTTER™ FROZEN MKF



### FEATURES

- High carbon steel with polished finish
- Precision ground, hardened teeth
- Variety of width, thickness, and teeth per inch (TPI)
- Engraved laser-etched identification
- USDA approved

### BENEFITS

- Highly durable blades with stronger teeth
- Fast and precise cuts. Longer operation and increased yield
- Accurate, balanced, sharp and fast cutting action with less kerf loss per cut
- Guarantee of origin and traceability

### APPLICATIONS

- Designed to cut frozen proteins as low as -4°F (-20°C)
- Frozen fish, frozen meat and fish blocks
- Suitable for butcher shops, meatpacking and case ready facilities
- Ideal for fish and seafood processors, supermarkets and cold storage facilities

### MEAT TYPES

- Frozen fish and seafood
- Frozen poultry
- Frozen beef, pork, lamb and goat



| Width x Thickness |           | Pitch/Rake | Material No. |
|-------------------|-----------|------------|--------------|
| in                | mm        |            |              |
| 5/8 x .014        | 16 x 0.35 | 3/HK-P-A   | 94360        |
| 5/8 x .016        | 16 x 0.41 | 3/HL-P-A   | 94367        |
| 5/8 x .020        | 16 x 0.50 | 3/HK-P-A   | 94361        |
|                   |           | 4/HK-P-A   | 94362        |
| 3/4 x .022        | 19 x 0.55 | 3/HK-P-A   | 94363        |
| 1 x .023          | 27 x 0.60 | 3/HK-P-A   | 94364        |
| 1 x .032          | 27 x 0.80 | 3/HL-P-A   | 94357        |
| 1-1/4 x .032      | 34 x 0.80 | 2/HK-P-A   | 94365        |
| 2 x .035          | 50 x 0.90 | 1.3/HK-P-A | 94366        |

HK - Hook tooth profile | P - Positive rake | A - Alternate set | HL - Hook, low profile

Available in 100' (30m), 250' (75m), 500' (150m), random length coils and welded bands

All coils supplied within plus or minus 10% of ordered size.

Special products on request

# FOOD PROCESSING

## MEATKUTTER™ FROZEN BI-METAL MKB



### FEATURES

- Bi-metal high-speed steel band saw blade
- Hardened teeth and backing
- Exclusive positive rake angle
- Special tooth set

### BENEFITS

- Greater durability compared to conventional blades
- Fast, clean cuts
- Accurate cuts with less food waste
- Easy cutting

### APPLICATIONS

- Designed to cut frozen proteins as low as -76°F (-60°C)
- Large fish
- Suitable for meat packing, portioning, secondary cutting operations and cold storage facilities
- Ideal for fish and seafood processing

### MEAT TYPES

- Large fish
- Frozen fish and seafood
- Frozen poultry
- Frozen beef, pork, lamb and goat

| Width x Thickness |           | Pitch/Rake | Material No. |
|-------------------|-----------|------------|--------------|
| in                | mm        |            |              |
| 1-1/4 x .035      | 34 x 0.90 | 3/HK-P-A   | 94380        |

HK - Hook tooth profile | P - Positive rake | A - Alternate set

Available in 100' (30m), 250' (75m), 500' (150m), random length coils and individually wrapped welded bands

All coils supplied within plus or minus 10% of ordered size.

Special products on request







POWER HACKSAWS

# POWER HACKSAWS

## BI-METAL HSS-BS

CUTTING EDGE OF HIGH-SPEED STEEL

### FEATURES

- Available in metric and inch
- Hardened and tempered high-speed steel teeth
- Tough alloy steel back resistant to shock and breakage

### BENEFITS

- Alloy back resists fatigue under the most adverse conditions

### APPLICATIONS

- Ideal for all general steel cutting
- Works well in a wide variety of applications, including interrupted cuts



CUTTING CHART FOR POWER HACKSAW BLADES-BS AND RS

| Cross Section to be Cut     | Material Thickness          |                                            |                                              |                           | Bow Speeds in Strokes per Minute ** |
|-----------------------------|-----------------------------|--------------------------------------------|----------------------------------------------|---------------------------|-------------------------------------|
|                             | Up to 3/4" (20mm)<br>Pitch* | From 3/4" to 1-1/2"<br>(From 20mm to 40mm) | From 1-1/2" to 3-1/2"<br>(From 40mm to 90mm) | Above 3-1/2" (Above 90mm) |                                     |
| Low Carbon Steel            | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 70-90                               |
| Medium Carbon Steel         | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 60-80                               |
| High Carbon Steel           | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 55-70                               |
| Carbon Low Alloy Steel      | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 65-80                               |
| Carbon High Alloy Steel     | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 45-60                               |
| Easy to machine steel       | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 80-100                              |
| Tool Steel                  | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 55-70                               |
| Low-Alloy High-speed steel  | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 50-60                               |
| High-Alloy High-speed steel | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 45-55                               |
| Cast Iron Class 20          | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 70-80                               |
| Cast Iron Class 40          | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 65-75                               |
| Cast Iron Class 60          | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 40-55                               |
| Malleable Cast Iron         | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 65-75                               |
| Austenitic Cast Iron        | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 40-55                               |
| Inconel and Monel           | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 40-55                               |
| Stainless Steels            | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 50-60                               |
| Copper                      | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 95-140                              |
| Bronze                      | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 85-105                              |
| Brass                       | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 90-110                              |
| Aluminum                    | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 100-140                             |

\*The blade should be tensioned correctly.

\*Since you have two options for each thickness range, use a finer pitch (more teeth per inch) for thinner sections and coarser pitches (fewer teeth per inch) for thick sections.

\*\* For materials with width higher than 3", decrease at least 20% of cutting rates.





## POWER HACKSAWS

### BI-METAL HSS-BS

CUTTING EDGE OF HIGH-SPEED STEEL

| Cat. No. | EDP   | Length x Width x Thickness |                      | TPI (TP/25mm) | Pinhole Diameter |
|----------|-------|----------------------------|----------------------|---------------|------------------|
|          |       | in                         | mm                   |               |                  |
| BS1210-5 | 40097 | 12 x 1-1/8 x .050          | 300 x 28 x 1.25      | 10            | 8.5mm            |
| BS1214-5 | 40098 |                            |                      | 14            |                  |
| BS1410-5 | 40099 | 14 x 1-1/8 x .050          | 350 x 28 x 1.25      | 10            |                  |
| BS1414-5 | 40100 |                            |                      | 14            |                  |
| BS1406-6 | 40101 | 14 x 1-3/8 x .062          | 350 x 35 x 1.6       | 6             | 10.75mm          |
| BS1410-6 | 40102 |                            |                      | 10            |                  |
| BS1406-7 | 40105 | 14 x 1-5/8 x .075          | 350 x 41 x 2         | 6             |                  |
| BS1706-6 | 40113 | 17 x 1-3/8" x .062"        | 425mm x 35mm x 1.6mm | 6             | 8.5mm            |
| BS1710-6 | 40114 |                            |                      | 10            |                  |
| BS1806-6 | 40115 | 18" x 1-3/8" x .062"       | 450mm x 35mm x 1.6mm | 6             | 10.75mm          |
| BS1810-6 | 40116 |                            |                      | 10            |                  |
| BS1804-7 | 40118 | 18 x 1-5/8 x .075          | 450 x 41 x 2         | 4             |                  |
| BS1806-7 | 40119 |                            |                      | 6             |                  |

Blades from 12" (300mm) to 20" (500mm) length packaged and sold 5 blades per plastic tube.

Blades from 21" (525mm) or wider, packaged and sold 1 blade per sleeve.

# POWER HACKSAWS

## HIGH-SPEED STEEL-RS

### HIGH-SPEED STEEL

#### FEATURES

- Available in metric and inch
- Fully hardened molybdenum high-speed steel

#### BENEFITS

- Long wear life and top performance
- Withstands heavier feed pressures providing faster cutting

#### APPLICATIONS

- Ideal for cutting a wide range of materials



CUTTING CHART FOR POWER HACKSAW BLADES-BS AND RS

| Cross Section to be Cut     | Material Thickness          |                                            |                                              |                           | Bow Speeds in Strokes per Minute ** |
|-----------------------------|-----------------------------|--------------------------------------------|----------------------------------------------|---------------------------|-------------------------------------|
|                             | Up to 3/4" (20mm)<br>Pitch* | From 3/4" to 1-1/2"<br>(From 20mm to 40mm) | From 1-1/2" to 3-1/2"<br>(From 40mm to 90mm) | Above 3-1/2" (Above 90mm) |                                     |
| Low Carbon Steel            | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 70-90                               |
| Medium Carbon Steel         | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 60-80                               |
| High Carbon Steel           | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 55-70                               |
| Carbon Low Alloy Steel      | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 65-80                               |
| Carbon High Alloy Steel     | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 45-60                               |
| Easy to machine steel       | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 80-100                              |
| Tool Steel                  | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 55-70                               |
| Low-Alloy High-speed steel  | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 50-60                               |
| High-Alloy High-speed steel | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 45-55                               |
| Cast Iron Class 20          | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 70-80                               |
| Cast Iron Class 40          | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 65-75                               |
| Cast Iron Class 60          | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 40-55                               |
| Malleable Cast Iron         | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 65-75                               |
| Austenitic Cast Iron        | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 40-55                               |
| Inconel and Monel           | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 40-55                               |
| Stainless Steels            | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 50-60                               |
| Copper                      | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 95-140                              |
| Bronze                      | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 85-105                              |
| Brass                       | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 90-110                              |
| Aluminum                    | 14-10                       | 10-6                                       | 6-4                                          | 4-2-1/2                   | 100-140                             |

\*The blade should be tensioned correctly.

\*Since you have two options for each thickness range, use a finer pitch (more teeth per inch) for thinner sections and coarser pitches (fewer teeth per inch) for thick sections.

\*\* For materials with width higher than 3", decrease at least 20% of cutting rates.





# POWER HACKSAWS

## HIGH-SPEED STEEL-RS

### HIGH-SPEED STEEL

| Cat. No. | EDP   | Length x Width x Thickness |                 | TPI       | Pinhole  |
|----------|-------|----------------------------|-----------------|-----------|----------|
|          |       | in                         | mm              | (TP/25mm) | Diameter |
| RS1210-5 | 40046 | 12 x 1 x .050              | 300 x 25 x 1.25 | 10        | 8.5mm    |
| RS1214-5 | 40047 |                            |                 | 14        |          |
| RS1410-5 | 40049 |                            |                 | 10        |          |
| RS1414-5 | 40050 | 14 x 1 x .050              | 350 x 25 x 1.25 | 14        |          |
| RS1406-6 | 40051 |                            |                 | 6         |          |
| RS1410-6 | 40052 |                            |                 | 10        |          |
| RS1610-6 | 40058 | 16 x 1-1/4 x .062          | 400 x 32 x 1.25 | 10        | 10.75mm  |
| RS1706-6 | 40062 | 17 x 1-1/4 x .062          | 425 x 32 x 1.6  | 6         |          |
| RS1710-6 | 40063 |                            |                 | 10        |          |
| RS1806-6 | 40064 |                            |                 | 6         |          |
| RS1810-6 | 40065 | 18 x 1-1/4 x .062          | 450 x 32 x 1.6  | 10        |          |
| RS1804-7 | 40067 | 18 x 1-1/2 x .075          | 450 x 38 x 2    | 4         | 10.75mm  |
| RS1806-7 | 40068 |                            |                 | 6         |          |
| RS1804-8 | 40070 |                            |                 | 4         |          |
| RS1806-8 | 40071 | 18 x 1-3/4 x .088          | 450 x 45 x 2.25 | 6         |          |
| RS2104-8 | 40075 |                            |                 | 4         |          |
| RS2106-8 | 40076 |                            |                 | 6         |          |
| RS2404-0 | 40081 | 24 x 2 x .100              | 600 x 50 x 2.5  | 4         | 11.25mm  |
| RS3004-0 | 40083 | 30 x 2-1/2 x .100          | 750 x 63 x 2.5  | 4         | 16.75mm  |

Blades from 12" (300mm) to 20" (500mm) length packaged and sold 5 blades per plastic tube.  
Blades from 21" (525mm) or wider, packaged and sold 1 blade per sleeve.

| Cat. No.                                                                           | EDP   | Length x Width x Thickness |                  | TPI       | Pinhole   |
|------------------------------------------------------------------------------------|-------|----------------------------|------------------|-----------|-----------|
|                                                                                    |       | in                         | mm               | (TP/25mm) | Diameter  |
| Metric High-speed steel Power Hacksaw Blades (for KASTO and other metric machines) |       |                            |                  |           |           |
| RS400-6                                                                            | 40180 | 16 x 1-1/4 x .075          | 400 x 32 x 2     | 6         | 10.5mm    |
| RS400-10                                                                           | 40181 |                            |                  | 10        |           |
| RS450-4                                                                            | 40182 |                            |                  | 4         |           |
| RS450-6                                                                            | 40183 | 18 x 1-1/2 x .075          | 450 x 38 x 2     | 6         |           |
| RS450-10                                                                           | 40184 |                            |                  | 10        |           |
| RS500-6                                                                            | 16171 |                            |                  | 6         |           |
| RS500-10                                                                           | 16172 | 20 x 1-3/4 x .075          | 500 x 45 x 2     | 10        | 10.5mm    |
| RS550-4                                                                            | 40173 |                            |                  | 4         |           |
| RS550-10                                                                           | 40185 |                            |                  | 10        |           |
| RS575-4                                                                            | 40175 | 23 x 2 x .100              | 575 x 50 x 2.5   | 4         |           |
| RS575-6                                                                            | 40176 |                            |                  | 6         |           |
| RS600-4                                                                            | 16173 |                            |                  | 4         |           |
| RS600-6                                                                            | 16174 | 24 x 2 x .100              | 600 x 50 x 2.5   | 6         | 10.5mm    |
| RS650-4                                                                            | 40186 |                            |                  | 4         |           |
| RS650-6                                                                            | 40187 |                            |                  | 6         |           |
| RS700-4                                                                            | 40188 | 28 x 2-3/16 x .100         | 700 x 55 x 2.5   | 4         | 10.5mm    |
| RS700-6                                                                            | 40189 |                            |                  | 6         |           |
| RS850-4                                                                            | 16175 |                            |                  | 4         |           |
| RS900-2.1/2A                                                                       | 68716 | 36 x 4-1/2 x .138          | 900 x 114 x 3.5  | 2-1/2 TPI | 2-1/2 TPI |
| RS1000-2 1/2                                                                       | 16177 | 40 x 5 x .138              | 1000 x 126 x 3.5 |           |           |

Blades from 12" (300mm) to 20" (500mm) length packaged and sold 5 blades per plastic tube.  
Blades from 21" (525mm) or wider, packaged and sold 1 blade per sleeve.





PRECISION MAKES THE DIFFERENCE



## NO CONTACT IS THE SOLUTION.

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RECOMMENDATIONS AND RESOURCES

# RECOMMENDATIONS

## BLADE BREAK-IN

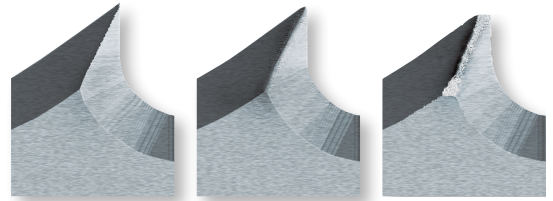
Using the right break-in procedures for a bi-metal blade ensures longer blade life, faster cuts for a longer period of time and consistent performance. Conversely, blade life can be significantly compromised if the proper break-in procedures are not followed.

### Softer material such as carbon steel and aluminum:

- A. Run the normal surface feet per minute (SFPM).
- B. Adjust the feed pressure to 50% the normal cutting rate for 50-100 square inches (323-645 sq.cm).
- C. Increase to 100% cutting rate.
- D. Avoid vibration.

### Harder materials such as nickel-based alloys like inconel, hardened steels, tool steels and stainless steels:

- A. Run the normal surface feet per minute (SFPM).
- B. Adjust the feed pressure to 75% of the normal cutting rate for 25-75 square inches (161-484 sq.cm).
- C. Gradually increase cutting rate to reach 100% after 50 square inches (323 sq.cm).
- D. Avoid vibration.



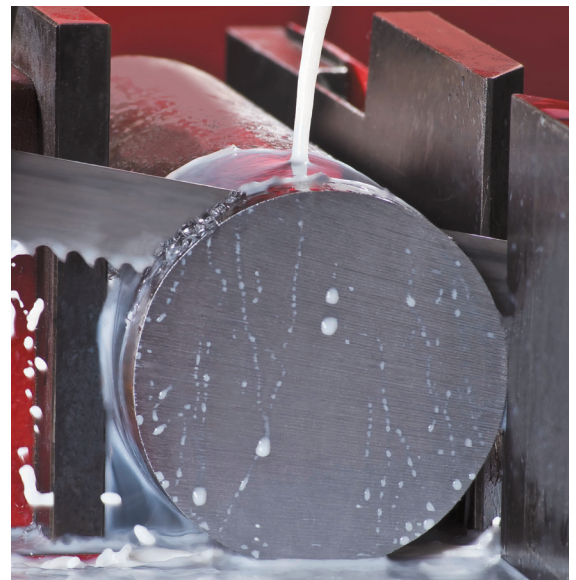
New blade with razor sharp teeth

Tooth correctly broken in

Tooth incorrectly broken in



Start to cut material at reduced cutting rate



After break-in when the blade has fully entered the work-piece, increase the feed rate over a series of cuts until the recommended cutting rate is achieved.



# RECOMMENDATIONS

## BAND SAW BLADE INSTALLATION GUIDELINES

Always follow the machine manufacturer's instruction and recommendations for blade changes and the safe operation for the band saw machine. Starrett nor its employees shall not be held responsible for the accuracy or completeness of these guidelines.

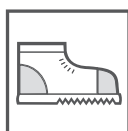
The general information contained in the guidelines is intended to assist in the proper installation of band saw blades.

Proper blade installation achieves more efficient blade performance.

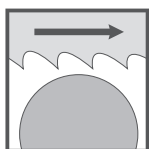
- Wear gloves when handling band saw blade



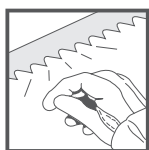
- Use eye protection, safety shoes, and hearing protection



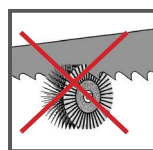
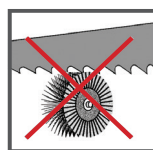
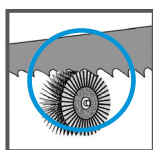
- Select appropriate blade for cutting application
- Unfold blade properly. Do not throw. Throwing the blade will result in tooth damage that will reduce saw blade performance
- Install blade with saw teeth pointing in proper direction



- Apply appropriate tension to the blade
- Be aware of pinch points and keep hands and clothing clear of rotating blade



- Adjust guide arms to appropriate positions to workpiece
- Adjust blade guides for proper blade support
- Adjust chip brush to fully engage saw blade teeth to ensure proper chip removal



- Check hydraulic fluid levels when applicable
- Ensure appropriate cutting fluid placement and mix ratios as applicable per machine, cutting fluid, and blade manufacturer's recommendations

## FOLLOW THESE INSTRUCTIONS CAREFULLY

- Follow all the safety instructions shown in the band saw machine operator's manual and on the machine labels. Recognize and read safety and warning signs such as Danger, Warning and Caution
- Follow the saw blade installation instructions on the specific make and model of the band saw machine requiring a blade change

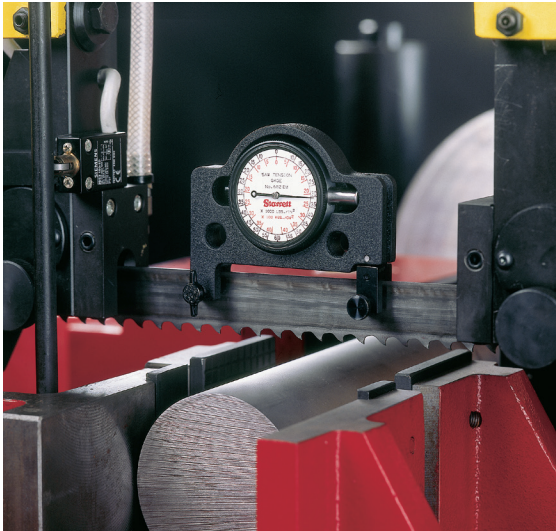
## BASIC BLADE CHANGE GUIDELINES

- Remove any chips from saw guides and band wheels
- Position chip brush away from saw
- Relieve saw blade tension and remove blade

## ACCESSORIES

### POCKET LASER TACHOMETER KIT WITH CASE No. S7793Z

- Powerful tachometer with 32 functions for measurements with or without contact
- From 200.000 RPM (optical measurement) to 20.000 RPM
- Measurement with contact up to 20.000 RPM
- Measurement with contact 2.000 m/min.(linear speed)
- Different measurement units: RPM, cm, inches, feet, yards etc

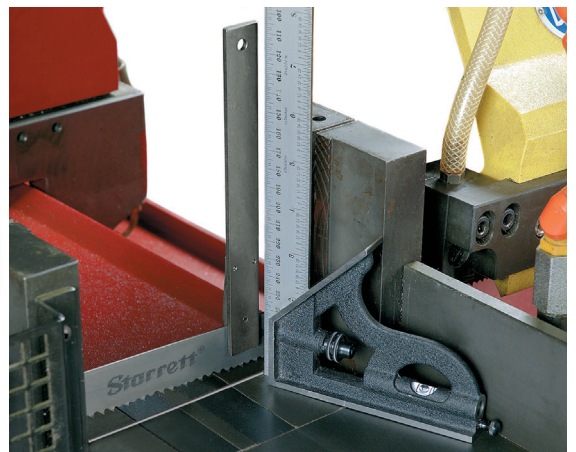
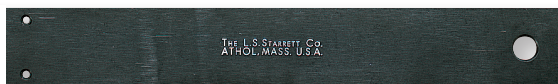


### SAW TENSION GAGE FOR BAND SAW BLADES No. 682EMZ

- Check for proper tension in either English or metric
- Graduated in kg/cm<sup>2</sup> (0 to 4.000) and in pounds/in<sup>2</sup> (0 to 60.000)
- Supplied in a case with instructions

### BAND SAW BLADE ALIGNMENT GAGE No. PT92925

This gage enables you to make sure your blade is running square to the cut.





# STARRETT RESOURCES

## STARRETT WEBSITE

STARRETT.COM

Browse the full range of Starrett products, locate Starrett authorized distributors, and download product datasheets, white papers, user manuals and other informational documentation on the Starrett website.

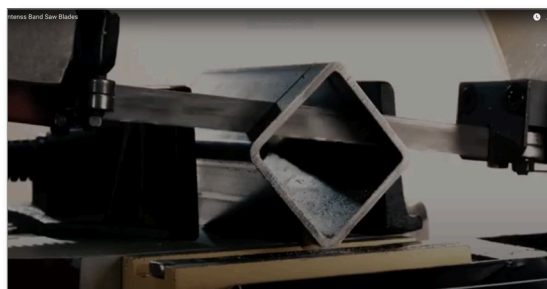
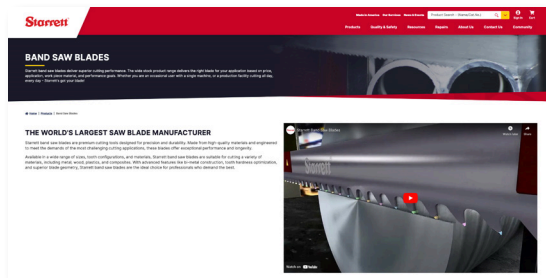
## FIND STARRETT ON YOUTUBE

YOUTUBE.COM/LSSTARRETT

Learn more about band saw blades and other Starrett products by watching a variety of videos available on the Starrett YouTube page.

### Videos include:

- Instructional
- Product Information
- Tradeshows and Events

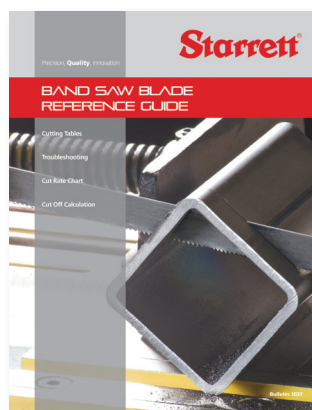


## BAND SAW BLADE REFERENCE GUIDE BULLETIN 1037

The Band Saw Reference Guide provides basic charts and tables to help users achieve the best results with Starrett band saw blades.

### Charts include:

- Cutting Table for Bi-Metal Band Saw Blades
- Troubleshooting
- Cut Rate Chart
- Cut-Off Calculations



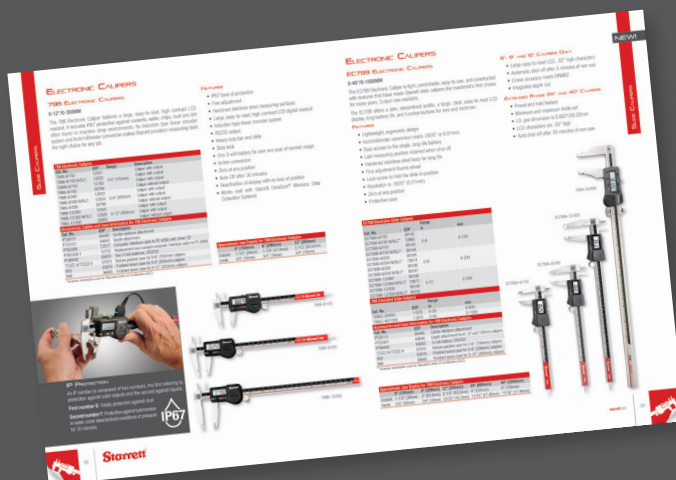
The Band Saw Blade Reference Guide is available as a PDF at [starrett.com](http://starrett.com).

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# BAND SAW BLADES

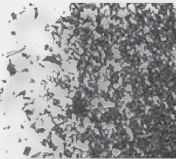
## CUTTING RATE CHART

| CUTTING RATE IN SQUARE INCHES PER MINUTE |            |      |      |      |      |      |      |      |     |     |     |     |     |     |     |     |     |     |     |
|------------------------------------------|------------|------|------|------|------|------|------|------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| Bar Diameter                             | Area (in²) | 1    | 2    | 3    | 4    | 5    | 6    | 7    | 8   | 9   | 10  | 11  | 12  | 13  | 14  | 15  | 16  | 17  | 18  |
| Minutes Per Cut:                         |            |      |      |      |      |      |      |      |     |     |     |     |     |     |     |     |     |     |     |
| 1.00                                     | 0.79       | .79  | .39  | .26  | .20  | .16  | .13  | .11  | .10 | .09 | .08 | .07 | .07 | .06 | .06 | .05 | .05 | .05 | .04 |
| 1.25                                     | 1.23       | 1.2  | .61  | .41  | .31  | .25  | .20  | .18  | .15 | .14 | .12 | .11 | .10 | .09 | .09 | .08 | .08 | .07 | .07 |
| 1.50                                     | 1.77       | 1.8  | .88  | .59  | .44  | .35  | .29  | .25  | .22 | .20 | .18 | .16 | .15 | .14 | .13 | .12 | .11 | .10 | .10 |
| 1.75                                     | 2.41       | 2.4  | 1.2  | .80  | .60  | .48  | .40  | .34  | .30 | .27 | .24 | .22 | .20 | .19 | .17 | .16 | .15 | .14 | .13 |
| 2.00                                     | 3.14       | 3.1  | 1.6  | 1.0  | .79  | .63  | .52  | .45  | .39 | .35 | .31 | .29 | .26 | .24 | .22 | .21 | .20 | .18 | .17 |
| 2.25                                     | 3.98       | 4.0  | 2.0  | 1.3  | 1.0  | .80  | .66  | .57  | .50 | .44 | .40 | .36 | .33 | .31 | .28 | .27 | .25 | .23 | .22 |
| 2.50                                     | 4.91       | 4.9  | 2.5  | 1.6  | 1.2  | 1.0  | .82  | .70  | .61 | .55 | .49 | .45 | .41 | .38 | .35 | .33 | .31 | .29 | .27 |
| 2.75                                     | 5.94       | 5.9  | 3.0  | 2.0  | 1.5  | 1.2  | 1.0  | .85  | .74 | .66 | .59 | .54 | .49 | .46 | .42 | .40 | .37 | .35 | .33 |
| 3.00                                     | 7.07       | 7.1  | 3.5  | 2.4  | 1.8  | 1.4  | 1.2  | 1.0  | .88 | .79 | .71 | .64 | .59 | .54 | .50 | .47 | .44 | .42 | .39 |
| 3.25                                     | 8.30       | 8.3  | 4.1  | 2.8  | 2.1  | 1.7  | 1.4  | 1.2  | 1.0 | .92 | .83 | .75 | .69 | .64 | .59 | .55 | .52 | .49 | .46 |
| 3.50                                     | 9.62       | 9.6  | 4.8  | 3.2  | 2.4  | 1.9  | 1.6  | 1.4  | 1.2 | 1.1 | 1.0 | .87 | .80 | .74 | .69 | .64 | .60 | .57 | .53 |
| 3.75                                     | 11.04      | 11.0 | 5.5  | 3.7  | 2.8  | 2.2  | 1.8  | 1.6  | 1.4 | 1.2 | 1.1 | 1.0 | .92 | .85 | .79 | .74 | .69 | .65 | .61 |
| 4.00                                     | 12.57      | 12.6 | 6.3  | 4.2  | 3.1  | 2.5  | 2.1  | 1.8  | 1.6 | 1.4 | 1.3 | 1.1 | 1.0 | 1.0 | .90 | .84 | .79 | .74 | .70 |
| 4.25                                     | 14.19      | 14.2 | 7.1  | 4.7  | 3.5  | 2.8  | 2.4  | 2.0  | 1.8 | 1.6 | 1.4 | 1.3 | 1.2 | 1.1 | 1.0 | .95 | .89 | .83 | .79 |
| 4.50                                     | 15.9       | 15.9 | 8.0  | 5.3  | 4.0  | 3.2  | 2.7  | 2.3  | 2.0 | 1.8 | 1.6 | 1.4 | 1.3 | 1.2 | 1.1 | 1.1 | 1.0 | .94 | .88 |
| 4.75                                     | 17.72      | 17.7 | 8.9  | 5.9  | 4.4  | 3.5  | 3.0  | 2.5  | 2.2 | 2.0 | 1.8 | 1.6 | 1.5 | 1.4 | 1.3 | 1.2 | 1.1 | 1.0 | 1.0 |
| 5.00                                     | 19.64      | 19.6 | 9.8  | 6.5  | 4.9  | 3.9  | 3.3  | 2.8  | 2.5 | 2.2 | 2.0 | 1.8 | 1.6 | 1.5 | 1.4 | 1.3 | 1.2 | 1.2 | 1.1 |
| 5.25                                     | 21.65      | 21.6 | 10.8 | 7.2  | 5.4  | 4.3  | 3.6  | 3.1  | 2.7 | 2.4 | 2.2 | 2.0 | 1.8 | 1.7 | 1.5 | 1.4 | 1.4 | 1.3 | 1.2 |
| 5.50                                     | 23.76      | 23.8 | 11.9 | 7.9  | 5.9  | 4.8  | 4.0  | 3.4  | 3.0 | 2.6 | 2.4 | 2.2 | 2.0 | 1.8 | 1.7 | 1.6 | 1.5 | 1.4 | 1.3 |
| 5.75                                     | 25.97      | 26.0 | 13.0 | 8.7  | 6.5  | 5.2  | 4.3  | 3.7  | 3.2 | 2.9 | 2.6 | 2.4 | 2.2 | 2.0 | 1.9 | 1.7 | 1.6 | 1.5 | 1.4 |
| 6.00                                     | 28.27      | 28.3 | 14.1 | 9.4  | 7.1  | 5.7  | 4.7  | 4.0  | 3.5 | 3.1 | 2.8 | 2.6 | 2.4 | 2.2 | 2.0 | 1.9 | 1.8 | 1.7 | 1.6 |
| 6.25                                     | 30.68      | 30.7 | 15.3 | 10.2 | 7.7  | 6.1  | 5.1  | 4.4  | 3.8 | 3.4 | 3.1 | 2.8 | 2.6 | 2.4 | 2.2 | 2.0 | 1.9 | 1.8 | 1.7 |
| 6.50                                     | 33.18      | 33.2 | 16.6 | 11.1 | 8.3  | 6.6  | 5.5  | 4.7  | 4.1 | 3.7 | 3.3 | 3.0 | 2.8 | 2.6 | 2.4 | 2.2 | 2.1 | 2.0 | 1.8 |
| 6.75                                     | 35.78      | 35.8 | 17.9 | 11.9 | 8.9  | 7.2  | 6.0  | 5.1  | 4.5 | 4.0 | 3.6 | 3.3 | 3.0 | 2.8 | 2.6 | 2.4 | 2.2 | 2.1 | 2.0 |
| 7.00                                     | 34.48      | 38.5 | 19.2 | 12.8 | 9.6  | 7.7  | 6.4  | 5.5  | 4.8 | 4.3 | 3.8 | 3.5 | 3.2 | 3.0 | 2.7 | 2.6 | 2.4 | 2.3 | 2.1 |
| 7.25                                     | 41.28      | 41.3 | 20.6 | 13.8 | 10.3 | 8.3  | 6.9  | 5.9  | 5.2 | 4.6 | 4.1 | 3.8 | 3.4 | 3.2 | 2.9 | 2.8 | 2.6 | 2.4 | 2.3 |
| 7.50                                     | 44.18      | 44.2 | 22.1 | 14.7 | 11.0 | 8.8  | 7.4  | 6.3  | 5.5 | 4.9 | 4.4 | 4.0 | 3.7 | 3.4 | 3.2 | 2.9 | 2.8 | 2.6 | 2.5 |
| 7.75                                     | 47.17      | 47.2 | 23.6 | 15.7 | 11.8 | 9.4  | 7.9  | 6.7  | 5.9 | 5.2 | 4.7 | 4.3 | 3.9 | 3.6 | 3.4 | 3.1 | 2.9 | 2.8 | 2.6 |
| 8.00                                     | 50.27      | 50.3 | 25.1 | 16.8 | 12.6 | 10.1 | 8.4  | 7.2  | 6.3 | 5.6 | 5.0 | 4.6 | 4.2 | 3.9 | 3.6 | 3.4 | 3.1 | 3.0 | 2.8 |
| 8.25                                     | 53.46      | 53.5 | 26.7 | 17.8 | 13.4 | 10.7 | 8.9  | 7.6  | 6.7 | 5.9 | 5.3 | 4.9 | 4.5 | 4.1 | 3.8 | 3.6 | 3.3 | 3.1 | 3.0 |
| 8.50                                     | 56.75      | 56.7 | 28.4 | 18.9 | 14.2 | 11.3 | 9.5  | 8.1  | 7.1 | 6.3 | 5.7 | 5.2 | 4.7 | 4.4 | 4.1 | 3.8 | 3.5 | 3.3 | 3.2 |
| 8.75                                     | 60.13      | 60.1 | 30.1 | 20.0 | 15.0 | 12.0 | 10.0 | 8.6  | 7.5 | 6.7 | 6.0 | 5.5 | 5.0 | 4.6 | 4.3 | 4.0 | 3.8 | 3.5 | 3.3 |
| 9.00                                     | 63.62      | 63.6 | 31.8 | 21.2 | 15.9 | 12.7 | 10.6 | 9.1  | 8.0 | 7.1 | 6.4 | 5.8 | 5.3 | 4.9 | 4.5 | 4.2 | 4.0 | 3.7 | 3.5 |
| 9.25                                     | 67.20      | 67.2 | 33.6 | 22.4 | 16.8 | 13.4 | 11.2 | 9.6  | 8.4 | 7.5 | 6.7 | 6.1 | 5.6 | 5.2 | 4.8 | 4.5 | 4.2 | 4.0 | 3.7 |
| 9.50                                     | 70.88      | 70.9 | 35.4 | 23.6 | 17.7 | 14.2 | 11.8 | 10.1 | 8.9 | 7.9 | 7.1 | 6.4 | 5.9 | 5.5 | 5.1 | 4.7 | 4.4 | 4.2 | 3.9 |
| 9.75                                     | 74.66      | 74.7 | 37.3 | 24.9 | 18.7 | 14.9 | 12.4 | 10.7 | 9.3 | 8.3 | 7.5 | 6.8 | 6.2 | 5.7 | 5.3 | 5.0 | 4.7 | 4.4 | 4.1 |
| 10.00                                    | 78.54      | 78.5 | 39.3 | 26.2 | 19.6 | 15.7 | 13.1 | 11.2 | 9.8 | 8.7 | 7.9 | 7.1 | 6.5 | 6.0 | 5.6 | 5.2 | 4.7 | 4.6 | 4.4 |



# BAND SAW BLADES

## CUTTING RATE CHART

| READING THE CHIPS                                                                  |                         |               |             |            |                                                            |
|------------------------------------------------------------------------------------|-------------------------|---------------|-------------|------------|------------------------------------------------------------|
| Chip Formation                                                                     | Chip Condition          | Chip Color    | Blade Speed | Blade Feed | Other                                                      |
|   | Thin and Tightly Curled | Silver        | Correct     | Decrease   | Refer to Machining Recommendations for Correct Tooth Pitch |
|   | Powdered                | Silver        | Decrease    | Increase   |                                                            |
|   | Thick and Short         | Blue or Brown | Decrease    | Decrease   | Check Cutting Fluid                                        |
|  | Thin and Curly          | Silver        | Correct     | Correct    |                                                            |

### Recommended Tension for Starrett Band Saw Blades

| Blade Width                                | English             | Metric                           |
|--------------------------------------------|---------------------|----------------------------------|
| Bi-Metal and Carbide Tip: 1-1/2" and Wider | 30,000 - 40,000 PSI | 2,100 - 2,800 Kg/cm <sup>2</sup> |
| Bi-Metal and Carbide Tip: Thru 1-1/4" Wide | 25,000 - 35,000 PSI | 1,800 - 2,500 Kg/cm <sup>2</sup> |
| Duratec™ SFB                               | 15,000 - 20,000 PSI | 1,000 - 2,500 Kg/cm <sup>2</sup> |

The above tension ranges are supplied as a guide for normal average cutting conditions. Insufficient blade tension can affect the cutting efficiency of the blade. Excessive tension may cause breakage of band saw blades.

As a general rule of thumb, the higher end of the tension range should be used when the guide arms are further apart and the lower end of the range should be used when the guide arms are closer together.



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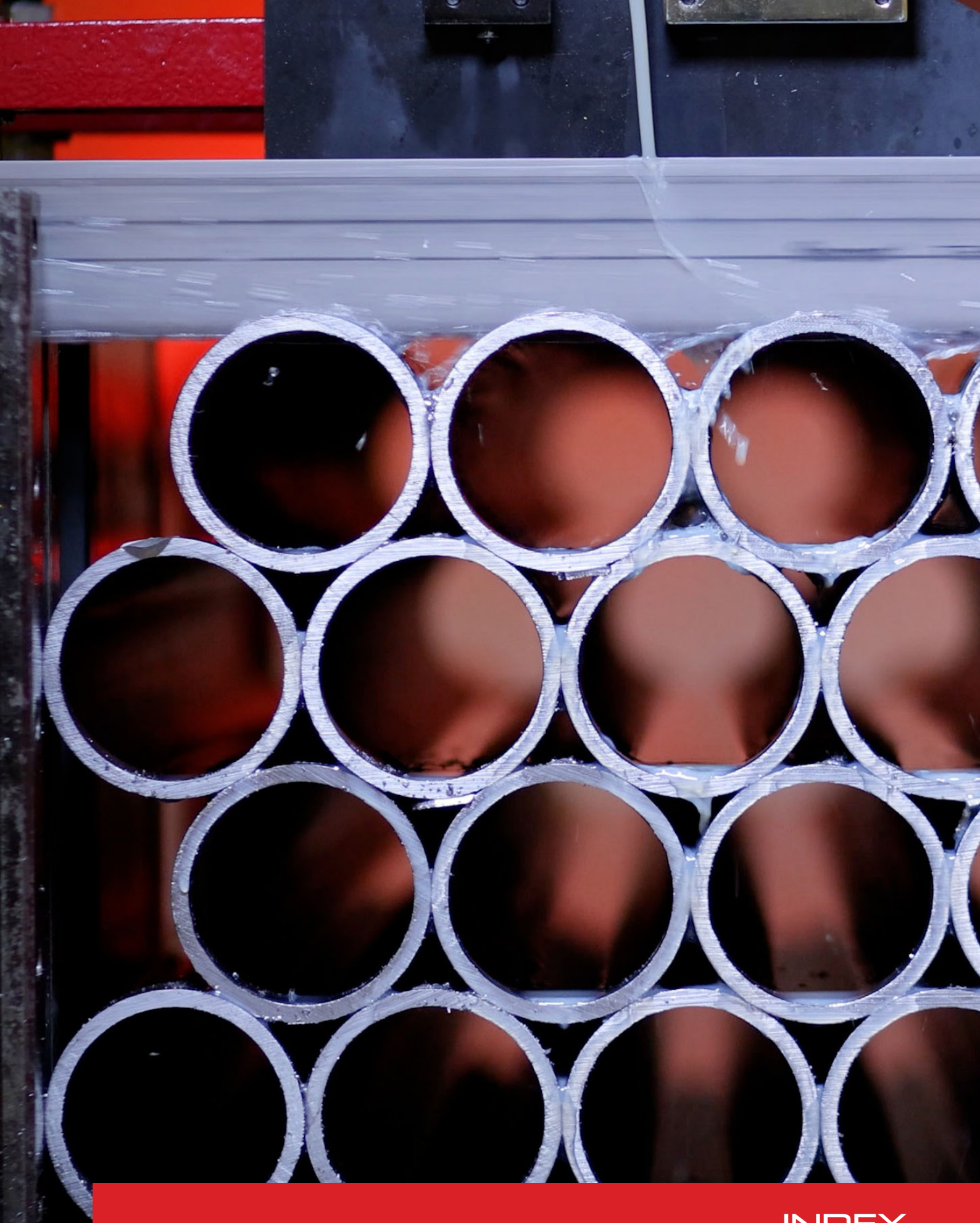
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