

Flex-Back Band Saw Blades

For Wood and Metal Cutting

Flex-Back, made from carbon steel with a flexible back, is recommended for general purpose cutting at an attractive cost on easy-to-machine nonferrous metal. It has an excellent fatigue factor to give long life on machines running at a high Surface Feet Per Minute (SFM), cutting nonferrous metal and wood (not recommended above 10,000 SFM [3,000m]). Its flexible feature is also suitable for absorbing contour cutting stresses.

Benefits

- ◆ Economical, general purpose cutting
- ◆ Can be welded on standard welding equipment
- ◆ The greatest variety of widths, thicknesses and tooth shapes to suit any purpose
- ◆ Ideal for both contour and straight cutting

Applications

- ◆ Light duty, vertical and horizontal machines
- ◆ Furniture, composition board
- ◆ Low alloy, nonferrous metal
- ◆ Plastics of numerous types
- ◆ Nonferrous foundry materials

Blades are furnished welded in convenient lengths all ready to use. Coils are also furnished in 100' (30m) lengths and 250' and 500' (76 and 152m) random lengths as listed.

Rake

Cuts these shapes

Positive



Straight (Zero)



Shape

Regular – Conventional tooth for general purpose sawing, zero rake.



Hook – 10° positive rake for fast cutting of nonferrous metals and non-metallics.



Skip – Zero rake, widely spaced teeth and shallow gullets for cutting large sections.



Specifications

Width x Thickness		Tooth Shape	Pitch & Rake**	EDP No.		
Inch	mm			100' (30m) Coil	250' (76m) Coil	500' (152m) Coil
1/16" x .025"	1.6 x 0.65mm	Regular	24S	10001		
1/8" x .025"	3 x 0.65mm		14S	10004		
			18S	10005		
3/16" x .014"	4.8 x 0.35mm	Regular	8S	15007	15017	
			14S	15008	15018	
3/16" x .025"	4.8 x 0.65mm	Skip	4S-K	10073	10182	
		Regular	10S	10007	10124	
			14S	10008	10125	

**KEY: P = Positive Rake S = Straight (Zero) Rake W = Wavy Set, Zero Rake



Pitch: Constant – Usually for general purpose cutting.

Cross Section To Be Cut		Use Pitch
Inch	mm	
Up to 5/16"	8mm	Use 32 Pitch (Anything Thinner than 1/8" Cross Section Should Be Angled to the Blade)
5/32"-1/2"	4-13mm	24
7/32"-5/8"	6-16mm	18
1/4"-7/8"	6.4-22mm	14
3/8"-1 1/4"	9.5-35mm	10
1/2"-1 1/2"	13-40mm	8
1"-2"	25-50mm	6
1 1/2"-3"	38-75mm	4
2"-4"	50-100mm	3

(Continued on next page.)

Flex-Back Band Saw Blades (continued)

Specifications

Width x Thickness		Tooth Shape	Pitch & Rake**	EDP No.		
Inch	mm			100' (30m) Coil	250' (76m) Coil	500' (152m) Coil
1/4" x .014"	6.5 x 0.35mm	Skip	6S-K	15009	15019	
		Regular	14S	15011	15021	
1/4" x .025"	6.5 x 0.65mm	Hook	4P-HP	10098	10207	
		Skip	4S-K	10074	10183	
			6S-K	10076	10185	
		Hook	6P-HP	15803	15804	
		Regular	6S	13828	13846	
			10S	13829	13847	
			14S	13830	13848	
			18W	10015	10130	
	24W	12898	12899			
	32W	10055	10166			
1/4" x .032"	6.5 x 0.80mm	Hook*	WP-4P-HP	12594	12603	
3/8" x .014"	10 x 0.35mm	Skip	6S-K	15013	15023	
		Regular	14S	15014	15024	
3/8" x .025"	10 x 0.65mm	Hook*	3P-LP	10100	10209	10314
		Skip	4S-K	10079	10189	10293
		Hook	4P-HP	10101	10210	10315
			6P-HP	15806	15807	15808
		Regular	6S	13831	13849	13867
			8S	13832	13850	13868
			10S	13833	13851	13869
			14S	13834	13852	13870
	18W	10020	10135	10244		
	24W	12904	12905	12906		
3/8" x .032"	10 x 0.80mm	Hook*	WP-3P-HP	12595	12604	12613
		Hook*	WP-4P-HP	12597	12606	12615
1/2" x .020"	13 x 0.50mm	Regular	10S	10024	10139	10248
			14S	13836	13854	13872
			18W	10028	10143	10252
			24W	10057	10171	10275

*Especially good on wood.

**KEY: P = Positive Rake HP = High Profile Teeth WP = Woodpecker
 S = Straight (Zero) Rake LP = Low Profile Teeth
 W = Wavy Set, Zero Rake K = Skip

NOTE: 250' and 500' (76, 152m) coils are shipped random length, which may vary plus or minus 10%.

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