Starrett®

Precision, Quality, Innovation

BAND SAW BLADES

Bi-Metal

Carbide Tipped

Carbide Grit

Carbon

Portaband

Diamond Grit

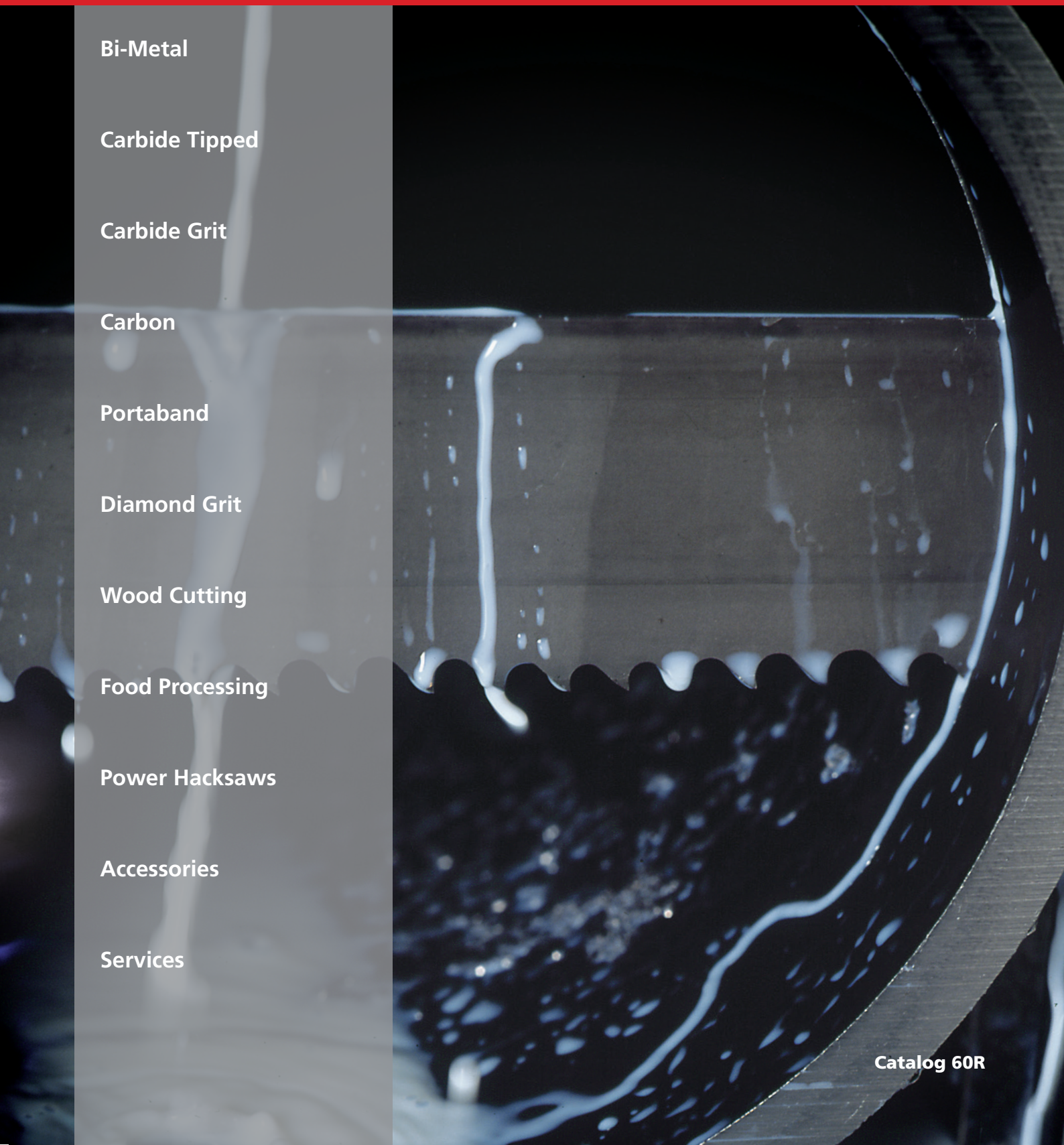
Wood Cutting

Food Processing

Power Hacksaws

Accessories

Services



Catalog 60R

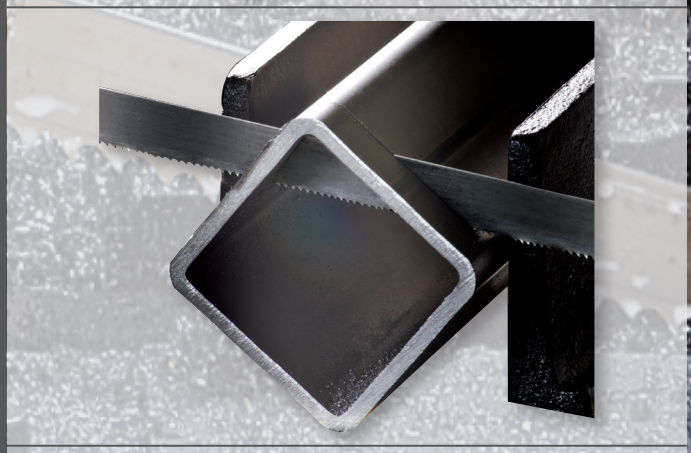
PRECISION, QUALITY, INNOVATION

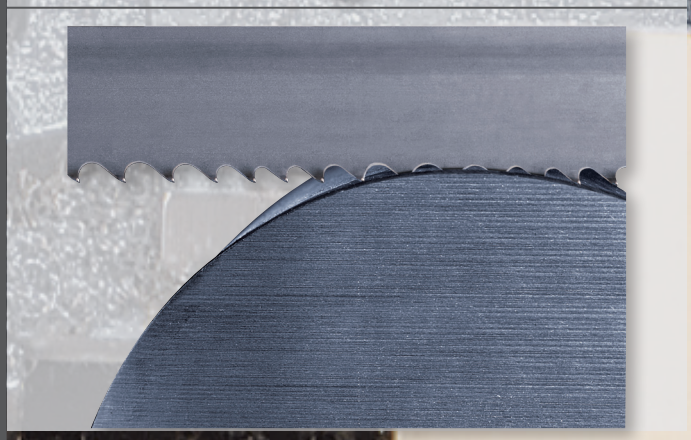
For more than 135 years, manufacturers, builders and craftsmen worldwide have depended upon saws and precision tools from The L.S. Starrett Company to ensure the consistent quality of their manufacturing processes.

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.



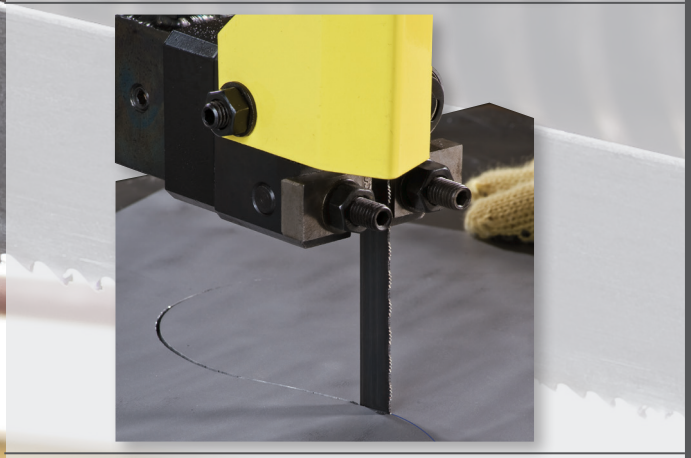


BAND SAW BLADES

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.

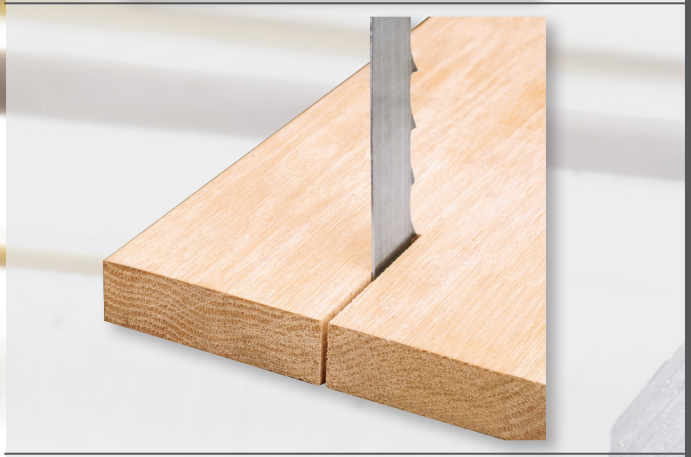
33



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.

35



WOOD CUTTING

A selection of carbon and bi-metal 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.

45

POWER HACKSAWS

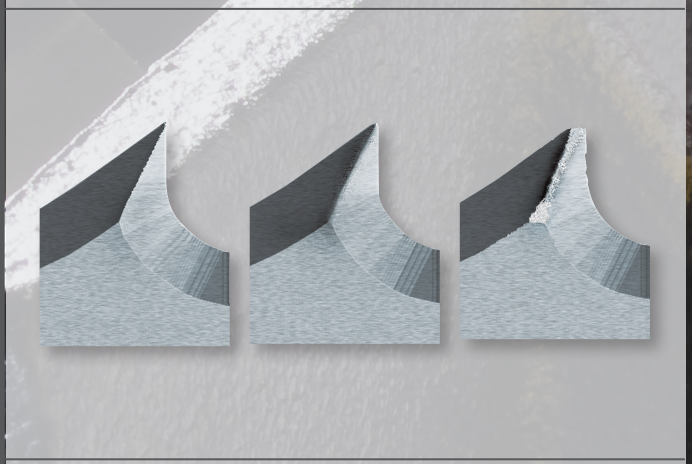
The Bi-Metal or Solid High-Speed Steel (HSS) Power Hacksaw blades are manufactured by Starrett, available in metric and inch.

51

RECOMMENDATIONS

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

57



ACCESSORIES

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

60

RESOURCES

Find information on the Starrett website, PDF documents, and the new PowerCalc App to get the best performance from your band saw blade.

61

BAND SAW BLADES

FACTORIES AROUND THE WORLD

1-Athol, Massachusetts, USA

2-Laguna Hills, California, USA

3-Waite Park, Minnesota, USA

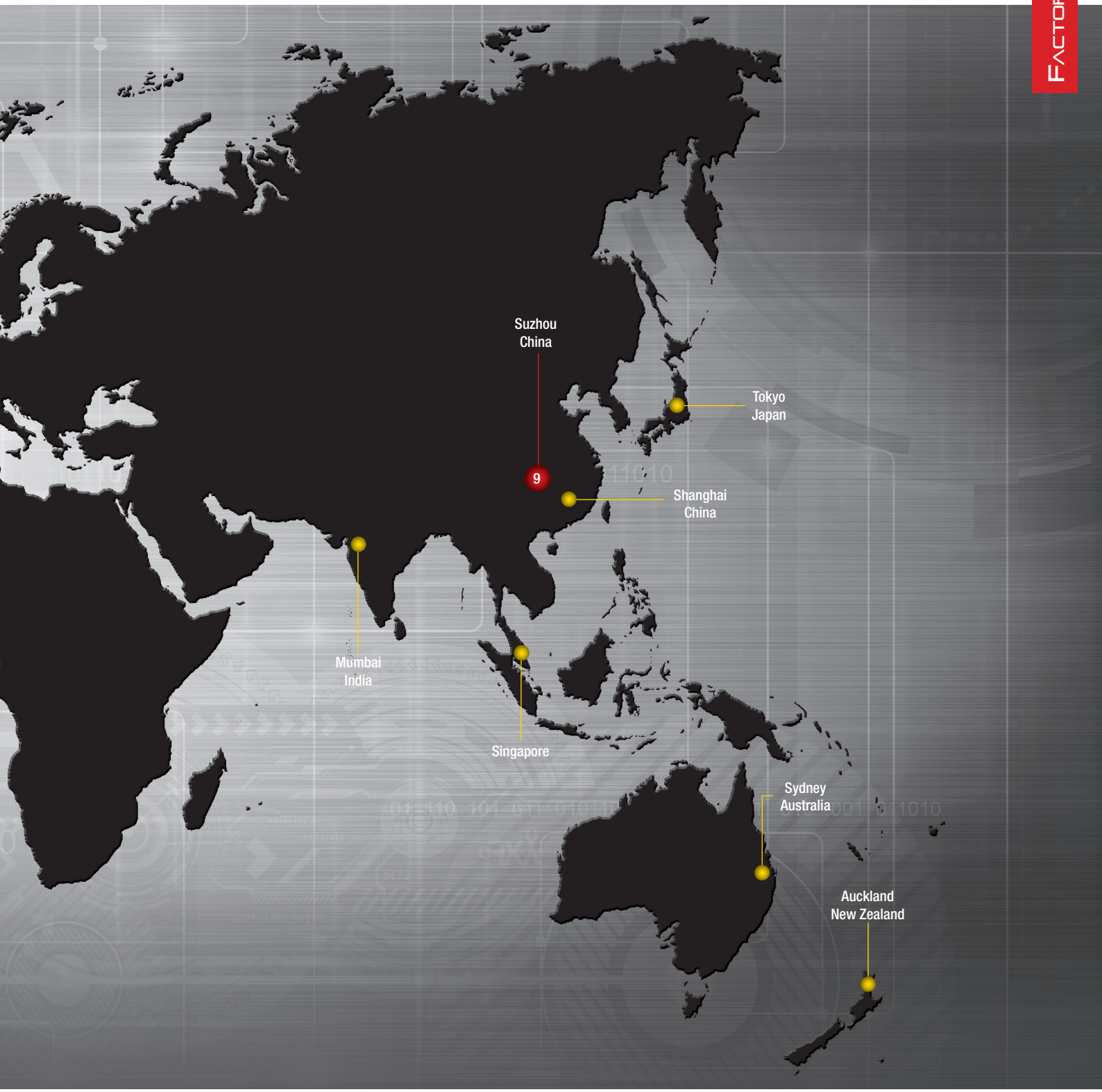
4-Cleveland, Ohio, USA

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

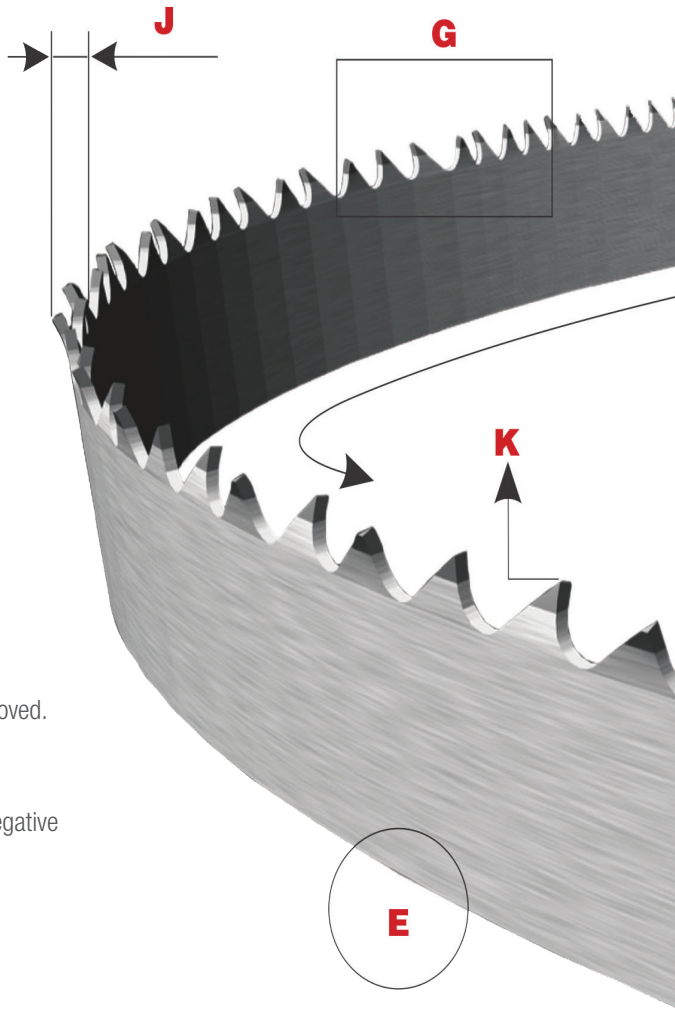
Surface of the tooth where the chip is formed. The tooth can have a positive, negative or straight angle. (Rake)

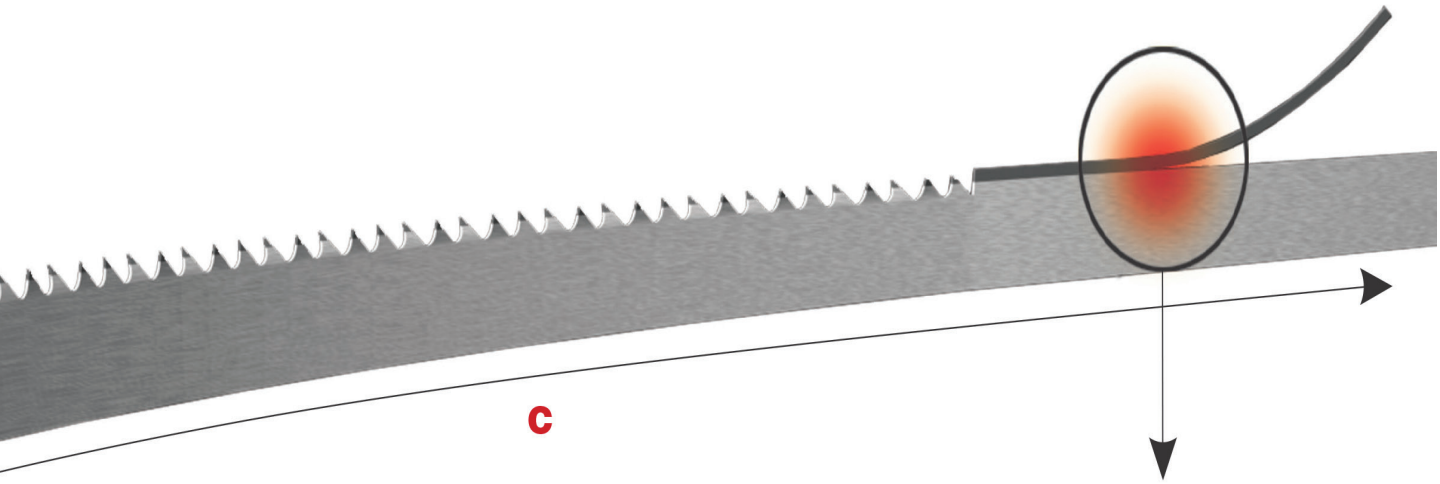
J-TOOTH SET

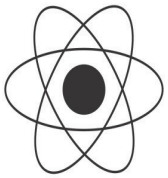
The side bending of the teeth to allow blade clearance through the cut.

K-BACK ANGLE

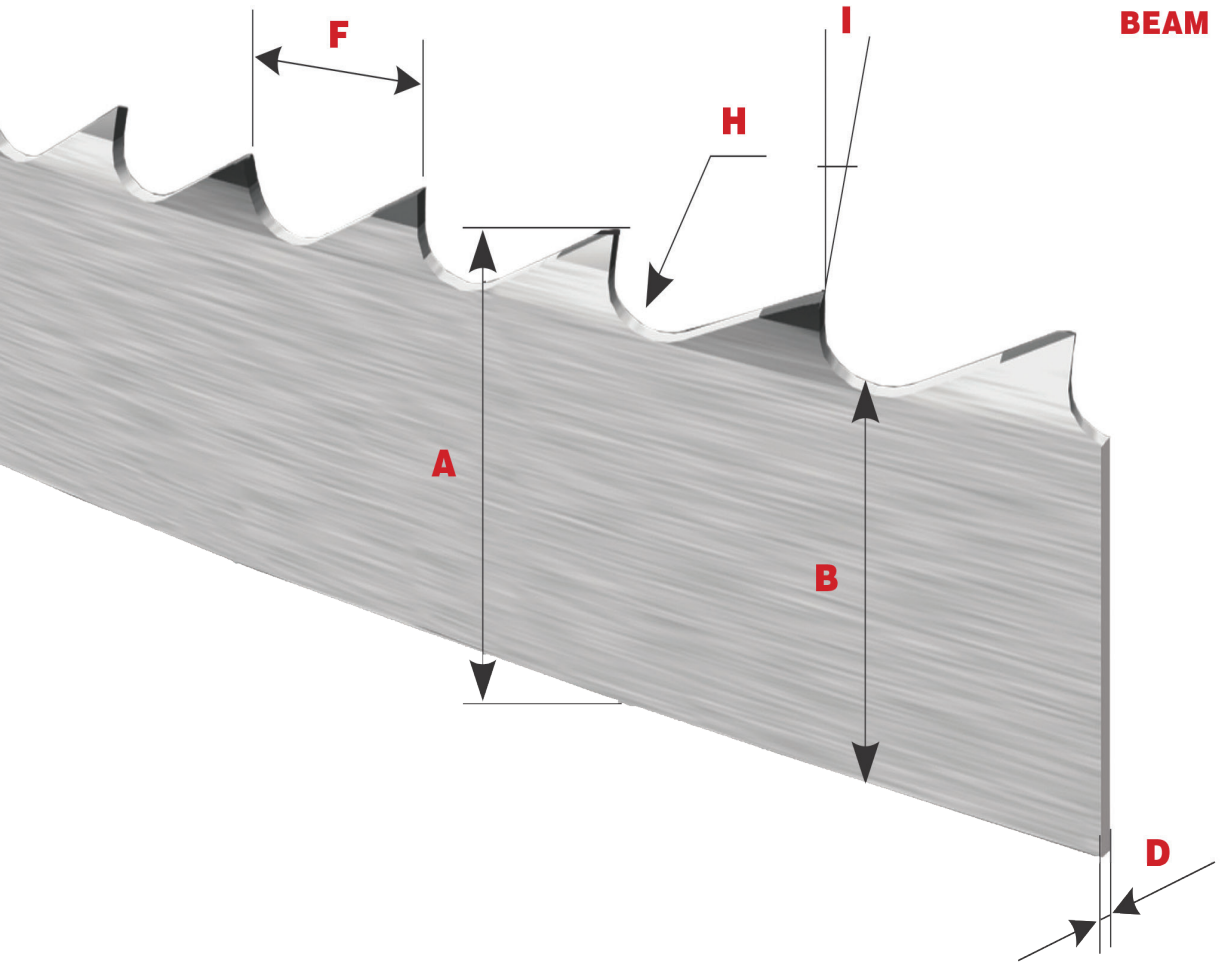
Angle formed by the back of the teeth and a parallel line to the tip of the same.







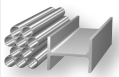
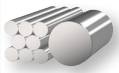
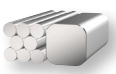
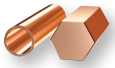
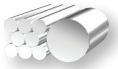
ELECTRON
BEAM



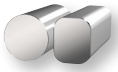
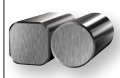
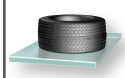
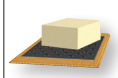
Choosing the Right Blade

1 QUICK GUIDE

★★★
★★
★
Performance

		Ferrous							
		 Aluminum	 Tubes and Profiles	 Carbon Steel	 Carbon Steel Alloys	 Cast Iron	 Copper Alloys	 High-speed steel	 Stainless Steel
Bi-Metal	TENNAX™- PRO Page 19		★★★						
	Primalloy™ Page 20				★★★	★★★	★★★	★★★	★★
	Intenss™ PRO-VTH Page 21				★★			★★	★★★
	Intenss™ PRO Page 22	★★	★★	★★★	★★★	★★	★★	★★	★★
	Intenss™ PRO-DIE Page 23	★★	★★	★★★	★★★	★★	★★	★★	★★
	Intenss™ Page 24	★★	★★	★★	★	★★	★		
	Univerz™ Page 25	★	★★	★					
Carbide	Advanz™ MC7 Page 28	★★		★★★	★★★	★★	★★	★★★	★★★
	Advanz™ MC5 Page 29	★★★		★★	★★	★★★	★★★	★★★	★★
	Advanz™ TS Page 30	★		★★	★★	★	★	★	★
	Advanz™ CS** Page 31								
	Advanz™ FS* Page 32	★★★				★★★	★★★		
	Advanz™ CG Page 33								
Diamond	Advanz™ DG Page 34								
Carbon	Duratec™ SFB Page 36	★	★	★					
	Duratec™ FC Page 38								
	Band Knives Page 39								

*Foundry-Gates and Risers
**Induction or Case Hardened

Ferrous				Non-Ferrous	
 Tool Steel - Hot Work	 Tool Steel - Cold Work	 Nickel and Titanium Alloys	 Steel with Hardness Above 45HRC	 Composite Materials and Abrasives	 Foam, Paper, Plastic and Rubber
★★★	★★★	★★			
★★	★★	★★★			
★★	★★	★			
★★	★★	★			
★★★	★★★	★★★	★★★		
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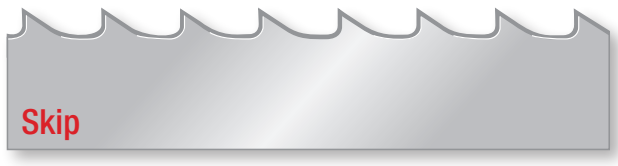
				★★	
					★★★

Choosing the Right Blade

2 TOOTH SHAPES

	Contant Pitch	Variable Pitch	
 Intenss	☐	■ .8-1.3 to 14-18	**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	☐	■ 1-1.2 to 4-6	**Intenss™ PRO-VTH** • Variable tooth height providing pulsating action • Easy penetration • Ideal for cutting hard and difficult to machine materials
 TENNAX™- PRO	☐	■ 2-3 to 10-14	**TENNAX™- PRO** • Increased resistance to wear and tooth breakage • Positive Rake angle • Ideal for cutting pipes, tubes and structural profiles
 Regular	■ 6 to 32	■ 2-3 to 14-18	**Intenss/Duratec™ SFB/Duratec™ FC/Univerz™** • Neutral angle • Shock resistant • Excellent choice for a wide range of cuts • Suitable for all types of machines
 Hook	■ 2 to 6	☐	**Duratec™ SFB/Intenss™ PRO-DIE** • Positive Rake angle, extremely aggressive • Faster cuts • Suitable for cutting ferrous and non-ferrous metals
 Skip	■ 3 to 6	☐	**Duratec™ SFB** • Neutral angle • Shock resistant • Suitable for cutting ferrous and non-ferrous metals
 Advanz™ FS and TS	■ 1 to 3	■ .9-1.1 to 3-4	**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
 With GULLET CONTINUOUS	■	☐	**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.

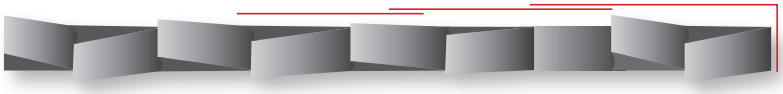
Variable Pitch

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

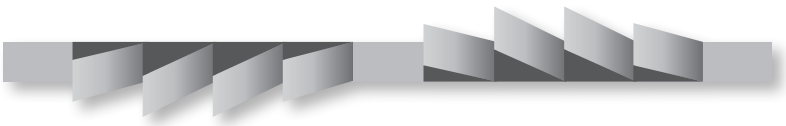
Raker

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.



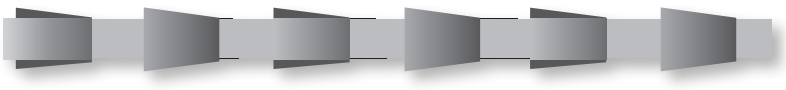
Alternate

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.



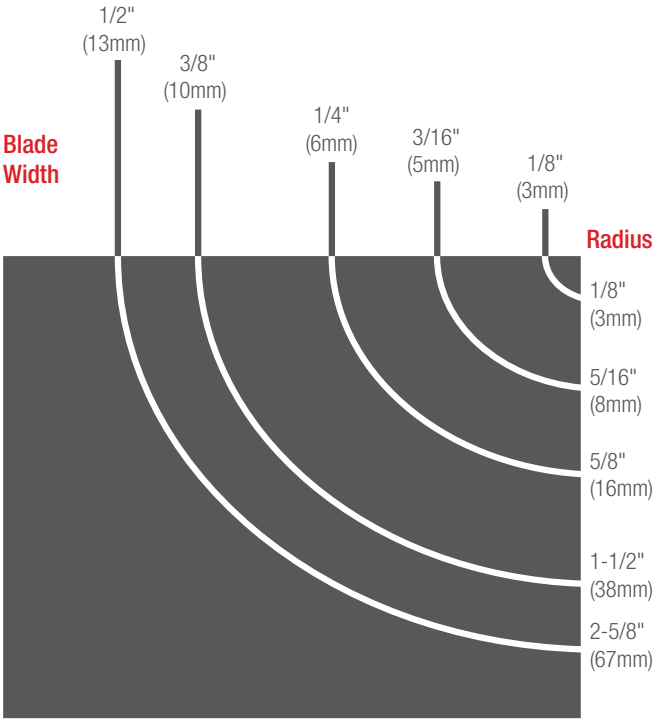
Trapezoid

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	Outside diameter of tube or maximum profile section length (in)												
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.

Technical Assistance

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.

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www.starrett.com | sales@starrett.com

PRECISION MAKES THE DIFFERENCE

PowerCalc

Starrett PowerCalc Band Saw Selector is an application that runs on any mobile device. PowerCalc selects the best band saw blade for the specified cutting application.

Specify

- Band saw machine being used to make the cut
- Shape and composition of the material to be cut
- Details regarding any bundling of the material
- Whether or not it will be a cooled cut

PowerCalc automatically displays:

- Recommended Starrett saw blade
- Blade break-in information
- Cooling recommendations
- Cutting time and speed recommendations

Starrett®

(978) 249-3551 • starrett.com

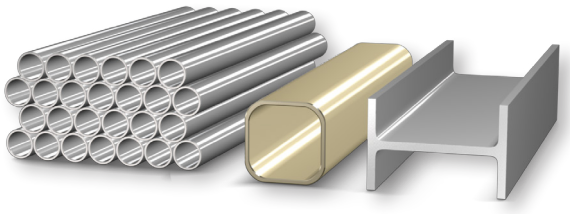
The PowerCalc App is available on the following sites:

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

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 in	Width x Thickness 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
		10-14/TX-P-H	99577
1-1/4 x .042	34 x 1.10	2-3/TX-P-H	99578
		3-4/TX-P-H	99579
		4-6/TX-P-H	99580
		5-8/TX-P-H	99581
		6-10/TX-P-H	99582
1-1/2 x .050	41 x 1.30	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 I P - Positive rake I 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™

Starrett® Primalloy™

Features

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

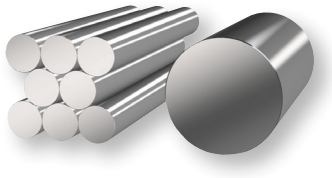
Benefits

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 in	Width x Thickness mm	Pitch/Rake	Material No.
1-1/4 x .042	34 x 1.10	2-3/IP-P-R	99801
1-1/2 x .050	41 x 1.30	1.4-2/IP-P-R	99803
		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 - Intenss™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)

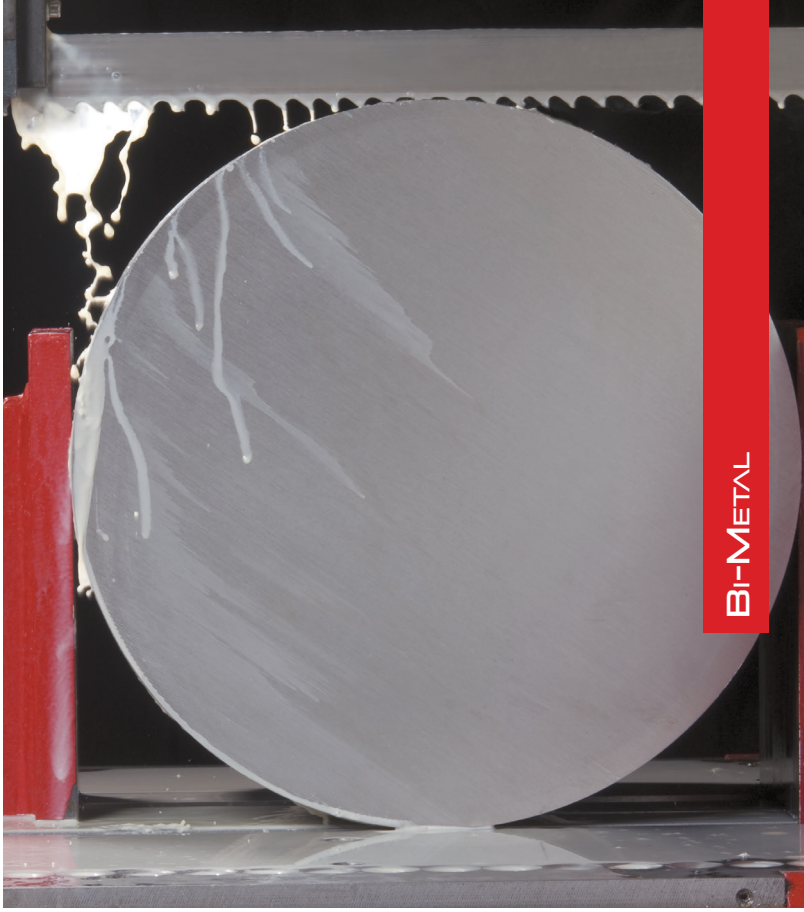
The Starrett Primalloy Band Saw product line applies a proprietary Extended Life Treatment (EXT) to its alloy steel backing material. This process, in addition to controlled blast peening, enhances the fatigue life of the blade. The EXT applied during the peening operation adds increased residual stress 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

Intenss™ PRO-VTH

bi-metal unique®

Starrett® Intenss™ PRO-VTH



Features

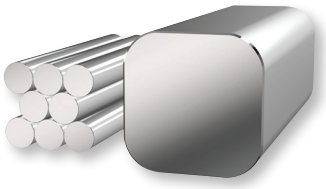
- Uniquely designed tooth edge with variable height and set
- Positive rake, ground teeth

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



Width x Thickness in	mm	Pitch/Rake	Material No.
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 063		1-1.2/IP-P-R	99993

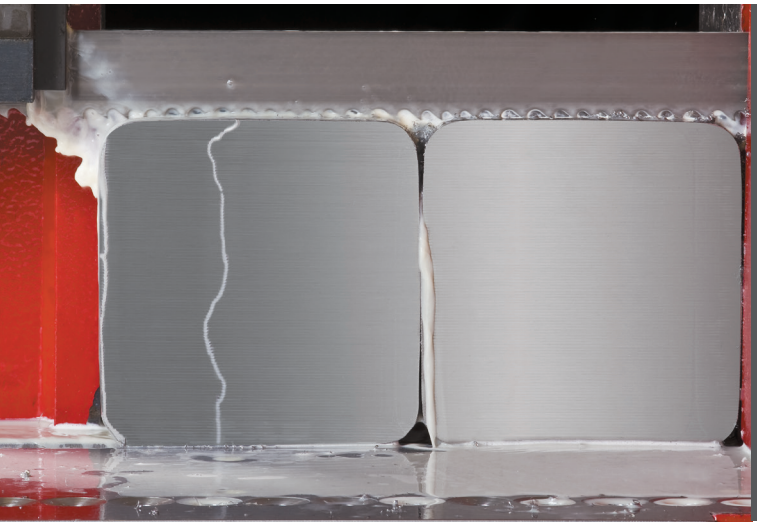
IP - Intenss™ tooth profile | P - Positive rake | R - raker set

*bi-metal unique® 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®

Bi-Metal

Intenss™ PRO

bi-metal unique®

Starrett® Intenss™ PRO

Features

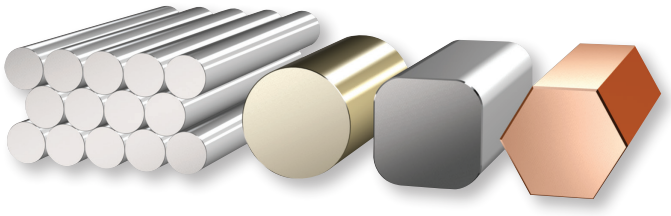
- Complete line with a full range of widths and pitches to suit a variety of cutting needs
- Unique tooth geometry provides intense production cutting in ferrous and non-ferrous metals

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 in	mm	Pitch/Rake	Material No.
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*
		3-4/IP-P-R	99906*
		4-6/IP-P-R	99907*
		5-8/IP-P-R	99908*
		6-10/IP-P-R	99318*
		3/P	99484
1-1/4 x .042	34 x 1.10	2-3/IP-P-R	99912
		3-4/IP-P-R	99913
		4-6/IP-P-R	99914
		5-8/IP-P-R	99915
		6-10/IP-P-R	99500
1-1/2 x .050	41 x 1.30	1-1.2/IP-P-R	99917
		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 x .063	54 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
		4-6/IP-P-R	99962
2-5/8 x .063	67 x 1.60	.8-1.3/IP-P-R	99934
		1-1.2/IP-P-R	99937
		1.4-2/IP-P-R	99941
		2-3/IP-P-R	99965
		3-4/IP-P-R	99938
3-1/8 x.063	80 x 1.60	.8-1.3/IP-P-R	99942
		1-1.2/IP-P-R	99943
		1.4-2/IP-P-R	99947

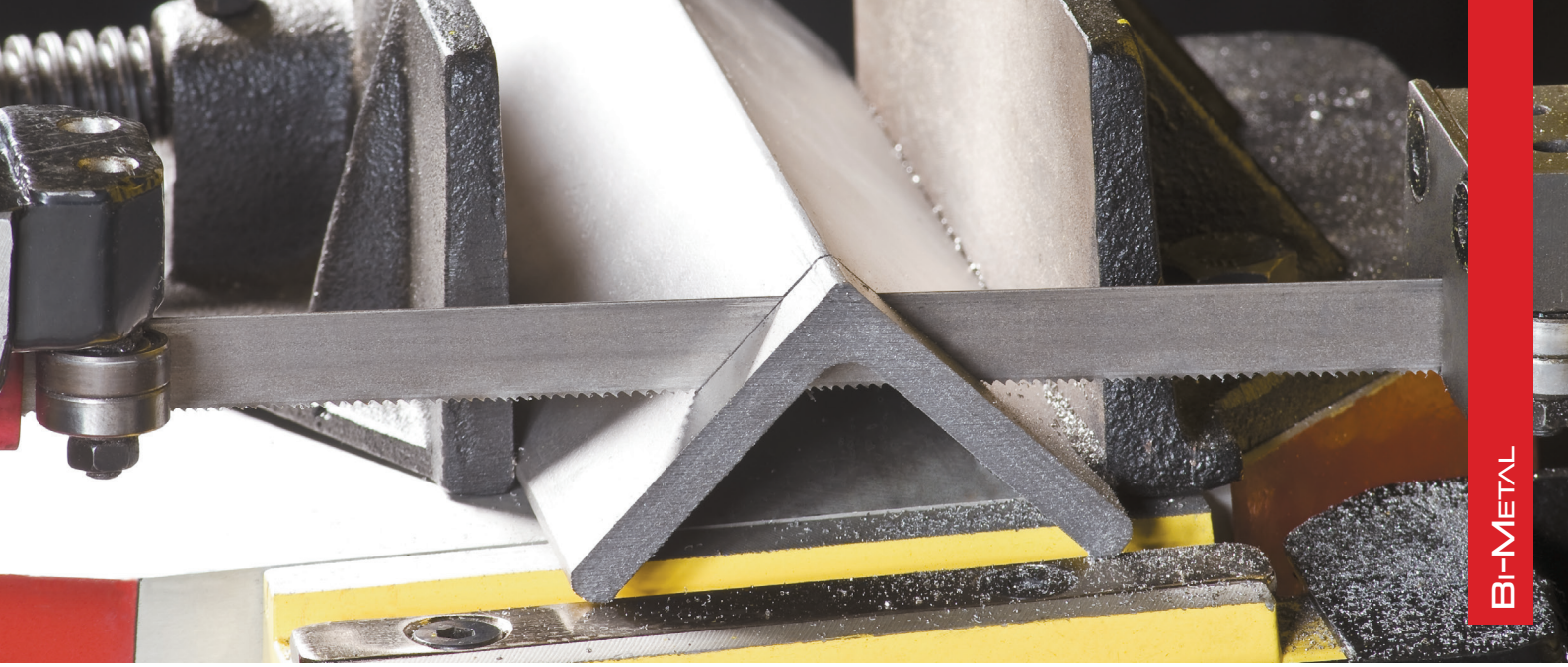
IP - Intenss™ tooth profile | P - Positive rake | R - Raker set

*bi-metal unique® 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

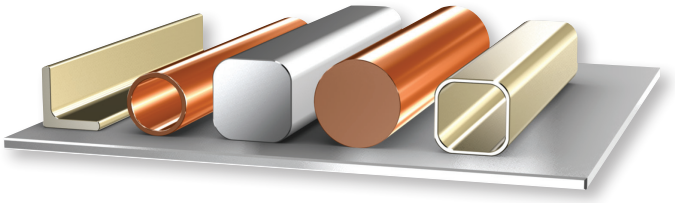
- Split Chip Advantage Technology
- Multiple cutting edges-Multi Edge Performance

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 in	mm	Pitch/Rake	Material No.
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
3/8 x .025	10 x 0.65	8-12/IP-P-R	99122
		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
1/2 x .020	13 x 0.50	14-18/RG-S-R	99190*

RG - Regular tooth profile I S - Straight (Zero) rake I R - Raker set I W - Wavy set
IP - Intenss™ tooth profile I HH - Hook high tooth profile I 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 in	mm	Pitch/Rake	Material No.
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	3/HL-P-R	99138
		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 I S - Straight (Zero) rake I R - Raker set I W - Wavy set
IP - Intenss™ tooth profile I HH - Hook high tooth profile I P Positive rake

*bi-metal unique® Technology

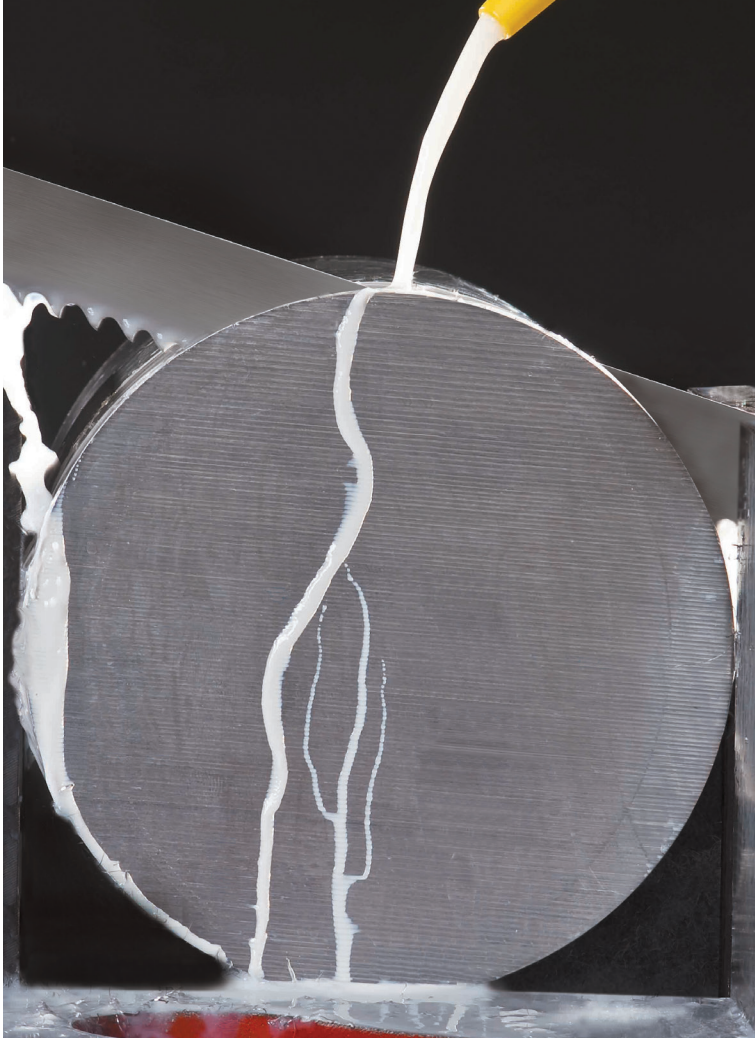
All sizes available in 100' (30m) and 250' (75m) coils or welded bands.
All coils supplied within plus or minus 10% of ordered size.

Special products on request.

Bi-Metal

INTENSS™

bi-metal unique®



Features

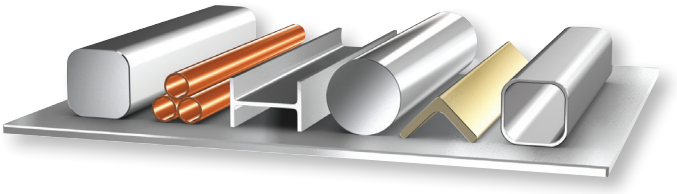
- Strong tooth geometry
- M42 high-speed steel teeth combined with a fatigue resistant backing

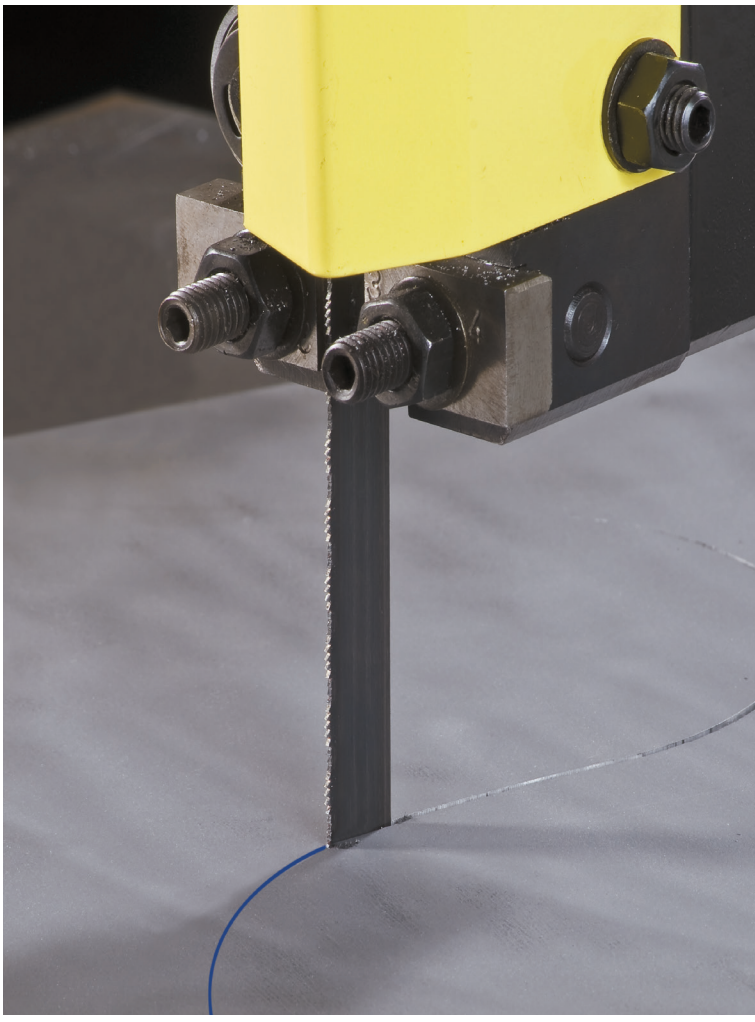
Benefits

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

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

*bi-metal unique® 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.

UNIVERZ™

bi-metal unique®

FEATURES

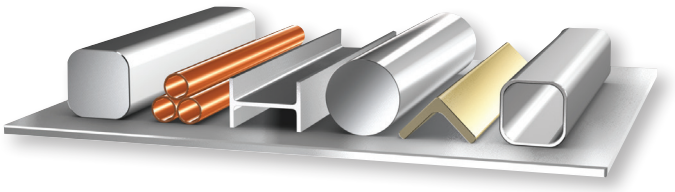
- Split Chip Advantage Technology
- Multiple cutting edges-Multiple Edge Performance
- Blade thickness: 0.020"

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 in	mm	Pitch/Rake	Material No.
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 I S - Straight (Zero) rake I R - Raker set I 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®

Features

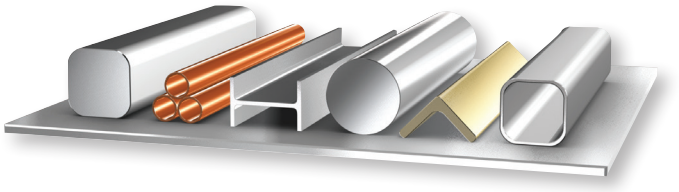
- Split Chip Advantage Technology
- Multiple cutting edges-Multiple Edge Performance
- Blade thickness: 0.020”

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

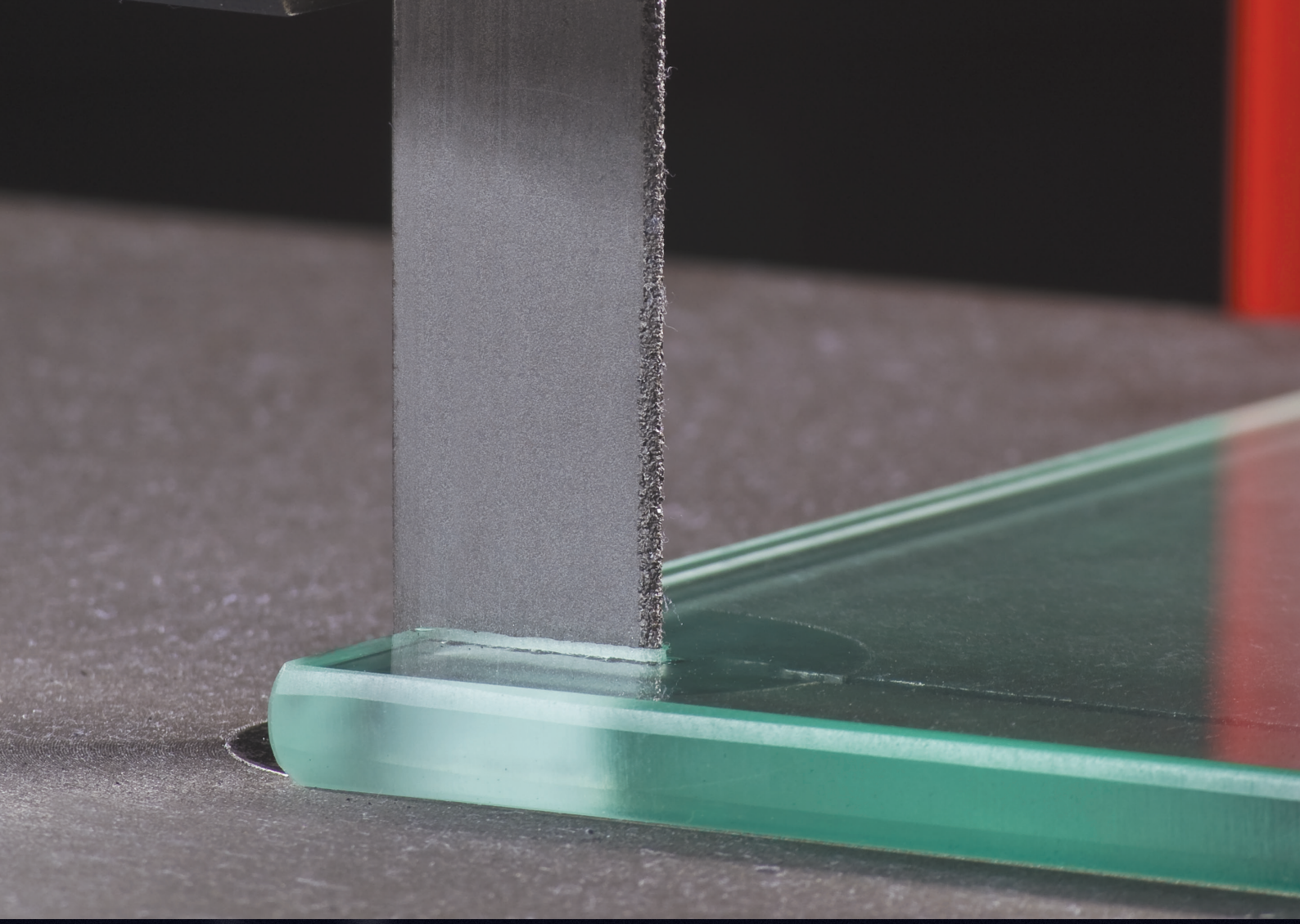
- Ideal for metal workshops, construction and hobbyists
- Steel, iron, aluminum



Cat. No.	EDP	Length in	Length cm	Width x Thickness in	Width x Thickness mm	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 I S - Straight (Zero) rake I R - Raker set I W - Wavy set

*All products feature bi-metal unique® Technology



CARBIDE / DIAMOND GRIT

CARBIDE

ADVANZ™ MC7

AVAILABLE WITH AMP TECHNOLOGY

Starrett® Advanz™ MC7

FEATURES

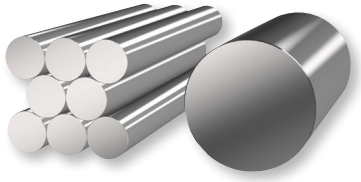
- Exclusive Starrett tooth geometry
- Carbide tipped
- Progressively ground trapezoidal tooth design
- Utilizes a progressive four tooth grind creating seven distinct chips
- Positive rake angle
- Submicron carbide (HV1600)

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

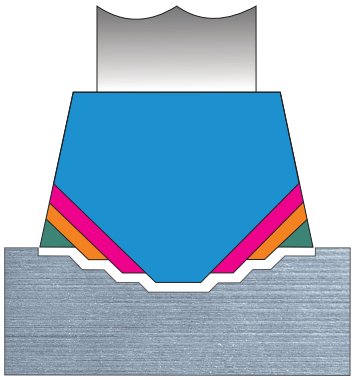


Width x Thickness			
in	mm	Pitch/Rake	Material No.
1-1/4 x .042	34 x 1.10	2-3/SC-P-T	92573
1-1/2 x .050	41 x 1.30	1.4-2/SC-P-T	92575
		2-3/SC-P-T	92581
2 x .063	54 x 1.60	1.4-2/SC-P-T	92578
		2-3/SC-P-T	92582
2-5/8 x .063	67 x 1.60	.9-1.1/SC-P-T	92583
		1.4-2/SC-P-T	92584
3-1/8 X 0.63	80 X 1.60	.9-1.1/SC-P-T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

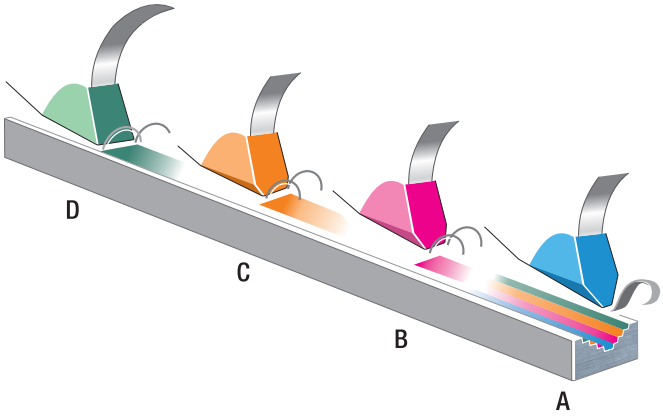
P - Positive rake I SC - Septuple chip I T - Trapezoid set

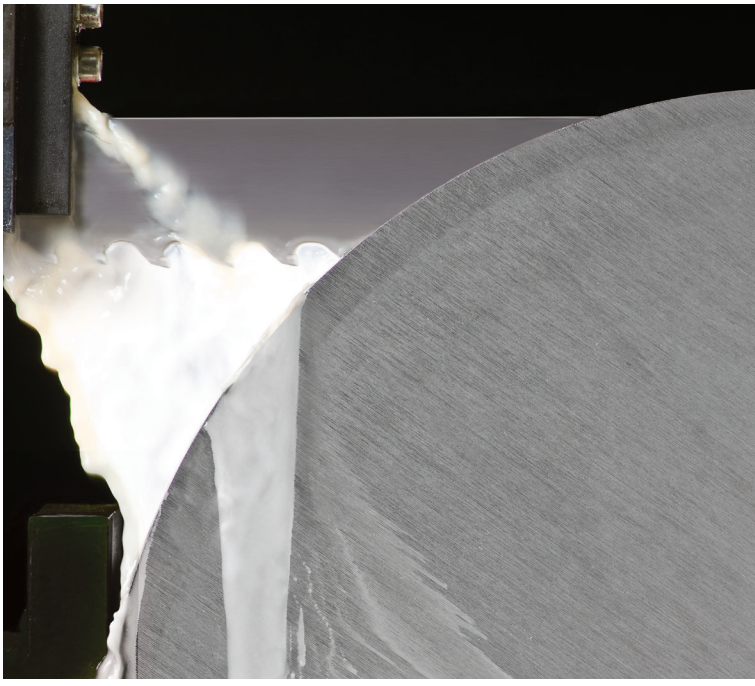
Furnished in welded bands.

Special products on request.



MC7 (Seven Multiple Chips)





CARBIDE

ADVANZ™ MC5

AVAILABLE WITH AMP TECHNOLOGY

Starrett® Advanz™ MC5

FEATURES

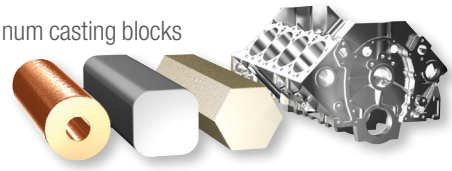
- Exclusive Starrett tooth geometry
- Carbide tipped
- Ground tooth produces 5 chips
- Utilizes a multiple chip grind with a high/low tooth sequence
- Positive rake angle
- Submicron carbide (HV1600)

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

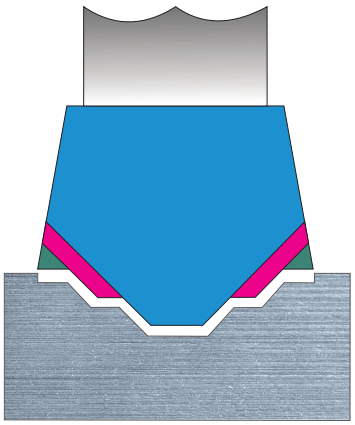


Width x Thickness in	mm	Pitch/Rake	Material No.
1-1/4 x .042	34 x 1.10	2-3/QC-P-T	92572
1-1/2 x .050	41 x 1.30	1.4-2/QC-P-T	92574
		2-3/QC-P-T	92586
2 x .063	54 x 1.60	1.4-2/QC-P-T	92577
		2-3/QC-P-T	92580
2-5/8 x .063		.9-1.1/QC-P-T	92533
		1.4-2/QC-P-T	92598
3-1/8 x .063	80 x 1.60	1.4-2/QC-P-T	92585

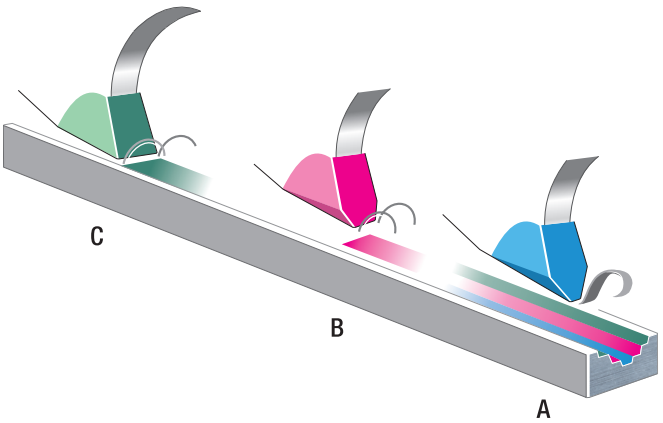
P - Positive rake | QC - Quintuple chip | T - Trapezoid set

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

FEATURES

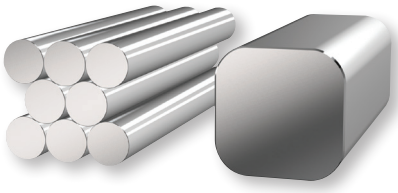
- Carbide tipped teeth
- Triple chip tooth geometry
- Aggressive Rake angle

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			
in	mm	Pitch/Rake	Material No.
1/2 x .035	13 x 0.90	3/TC-P-T	92593
3/4 x .035	19 x 0.90	3-4/TC-P-T	92503
		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
1-1/2 x .050	41 x 1.30	1.4-2/TC-P-T	92521
		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			
in	mm	Pitch/Rake	Material No.
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

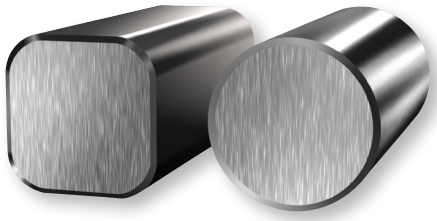
- Carbide tipped teeth
- Triple chip tooth geometry
- Negative Rake angle

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

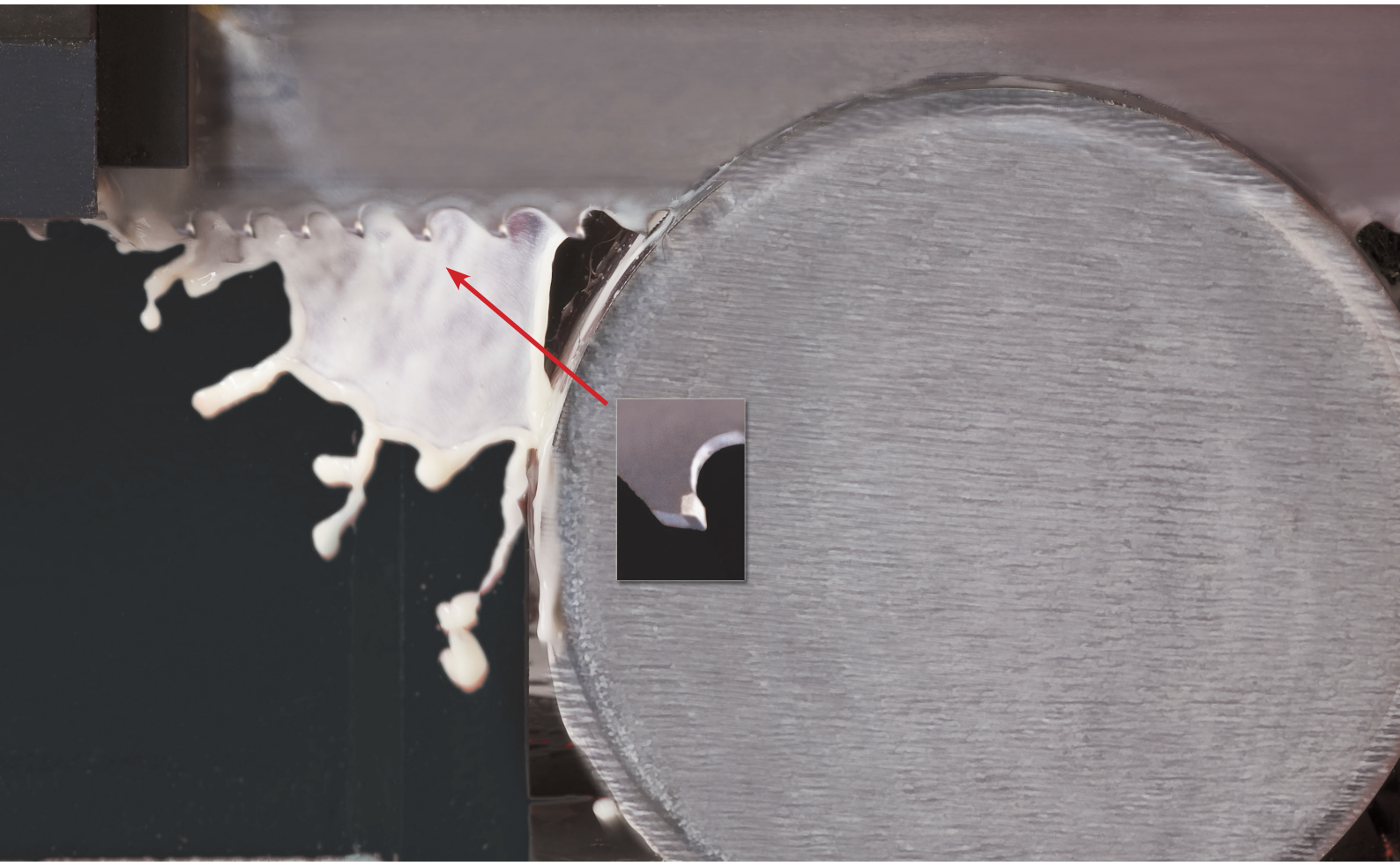


Width x Thickness		Pitch/Rake	Material No.
in	mm		
1 x .035	27 x 0.90	3-4/TC-N-T	92564
1-1/4 x .042	34 x 1.10	3-4/TC-N-T	92565
1-1/2 x .050	41 x 1.30	2-3/TC-N-T	92576
		3-4/TC-N-T	92570
2 x .063	54 x 1.60	2-3/TC-N-T	92592

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

Furnished in welded bands.

Special products on request.



CARBIDE

ADVANZ™ FS

Starrett® Advanz™ FS

FEATURES

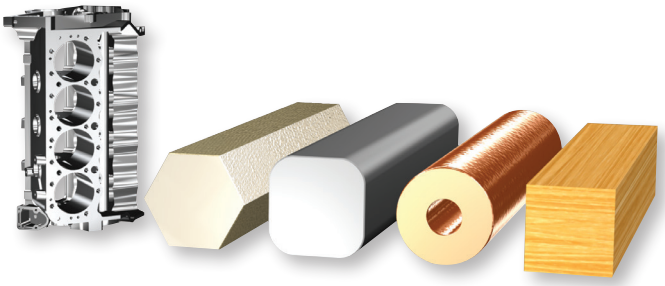
- Carbide tipped teeth
- Triple chip tooth geometry
- Positive Rake angle

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



Width x Thickness			
in	mm	Pitch/Rake	Material No.
3/4 x .035	19 x 0.90	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

Advanz™ CG

Features

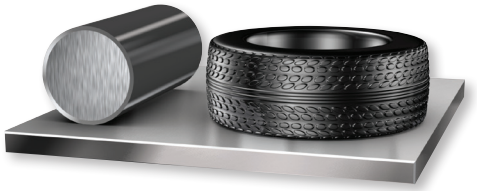
- With continuous or gulleted cutting edge
- High fatigue resistance

Benefits

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

Applications

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



Width x Thickness in	Width x Thickness mm	Form	Grit	Material No.
1/4 x .020	6 x 0.50	Gullet	Medium	95401
3/8 x .025	10 x 0.65	Gullet	Medium	95403
		Gullet	Medium/Coarse	95404
		Continuous	Medium	95406
1/2 x .020	13 x 0.50	Continuous	Medium	95414
1/2 x .025	13 x 0.65	Gullet	Medium	95407
		Gullet	Medium/Coarse	95408
		Continuous	Medium	95410
3/4 x .032	19 x 0.80	Gullet	Medium	95416
		Gullet	Medium/Coarse	95417
		Gullet	Coarse	95418
		Continuous	Medium	95419
		Continuous	Coarse	95421
1 x .035	25 x 0.90	Gullet	Medium/Coarse	95422
		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

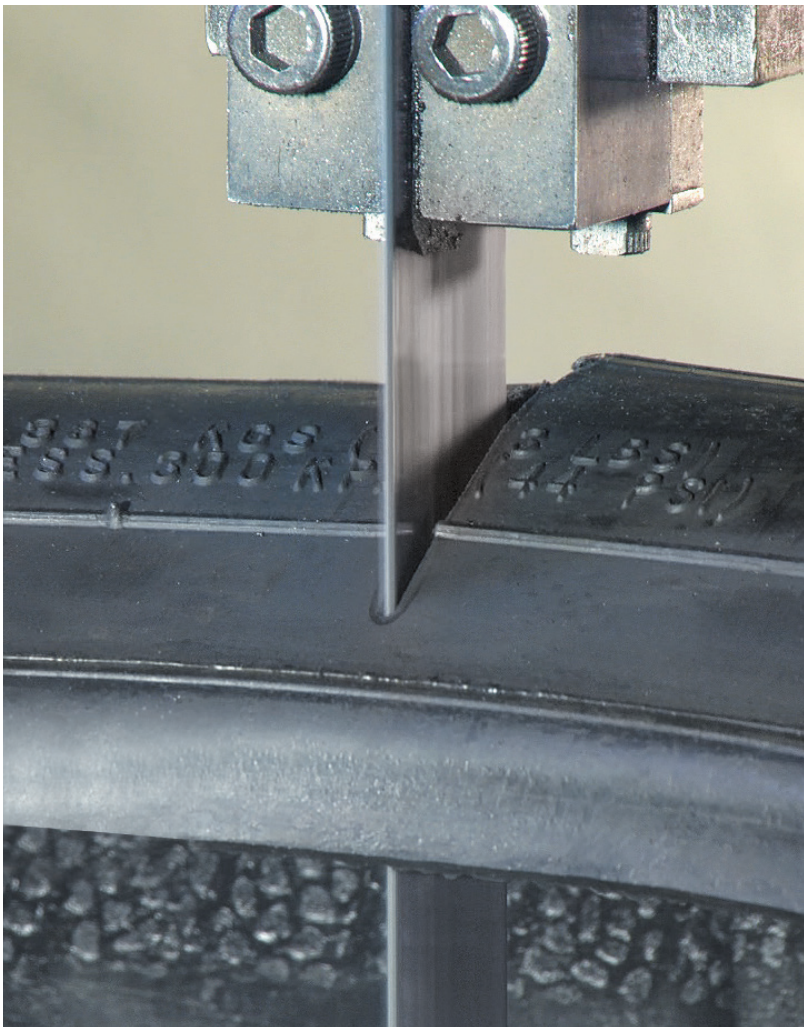
Furnished in welded bands. 100' and 250' coils.

Special products on request.

Cat. No.	EDP	Length in	Length cm	Width x Thickness in	Width x Thickness mm	Pitch/Rake
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



Diamond Grit

Advanz™ DG

Starrett® Advanz™ DG

Features

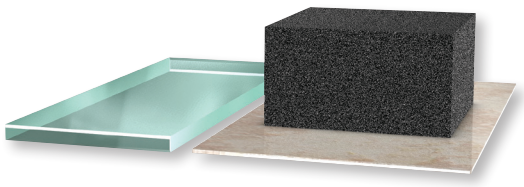
- Cutting edge coated with diamond grains
- Continuous cutting edge
- High strength body

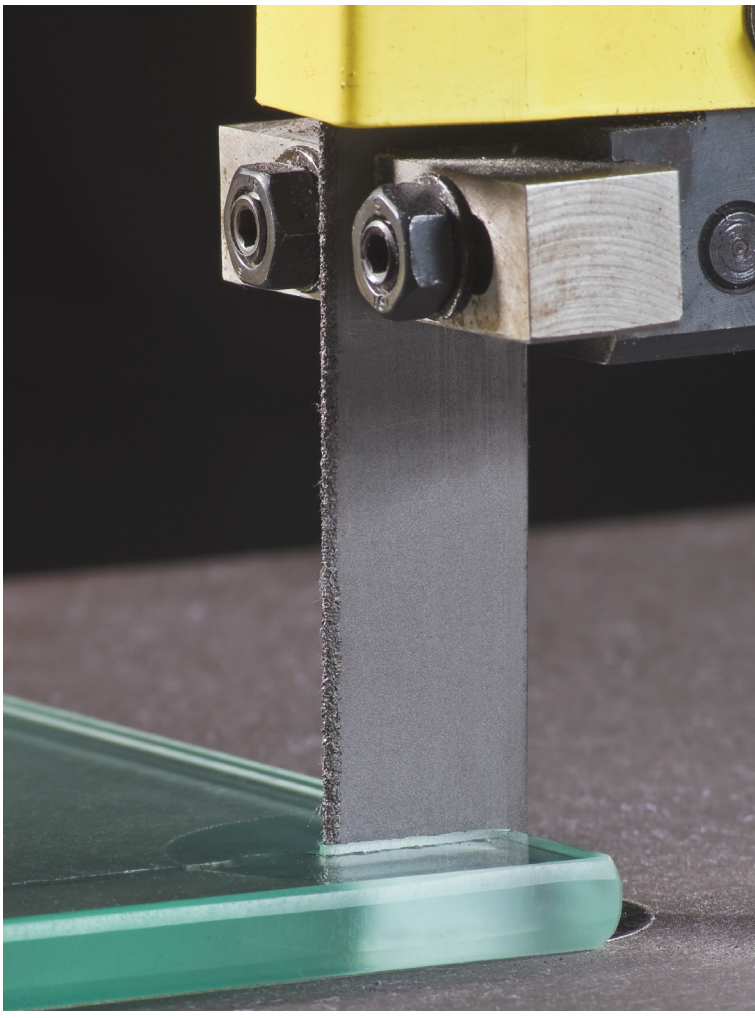
Benefits

- 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

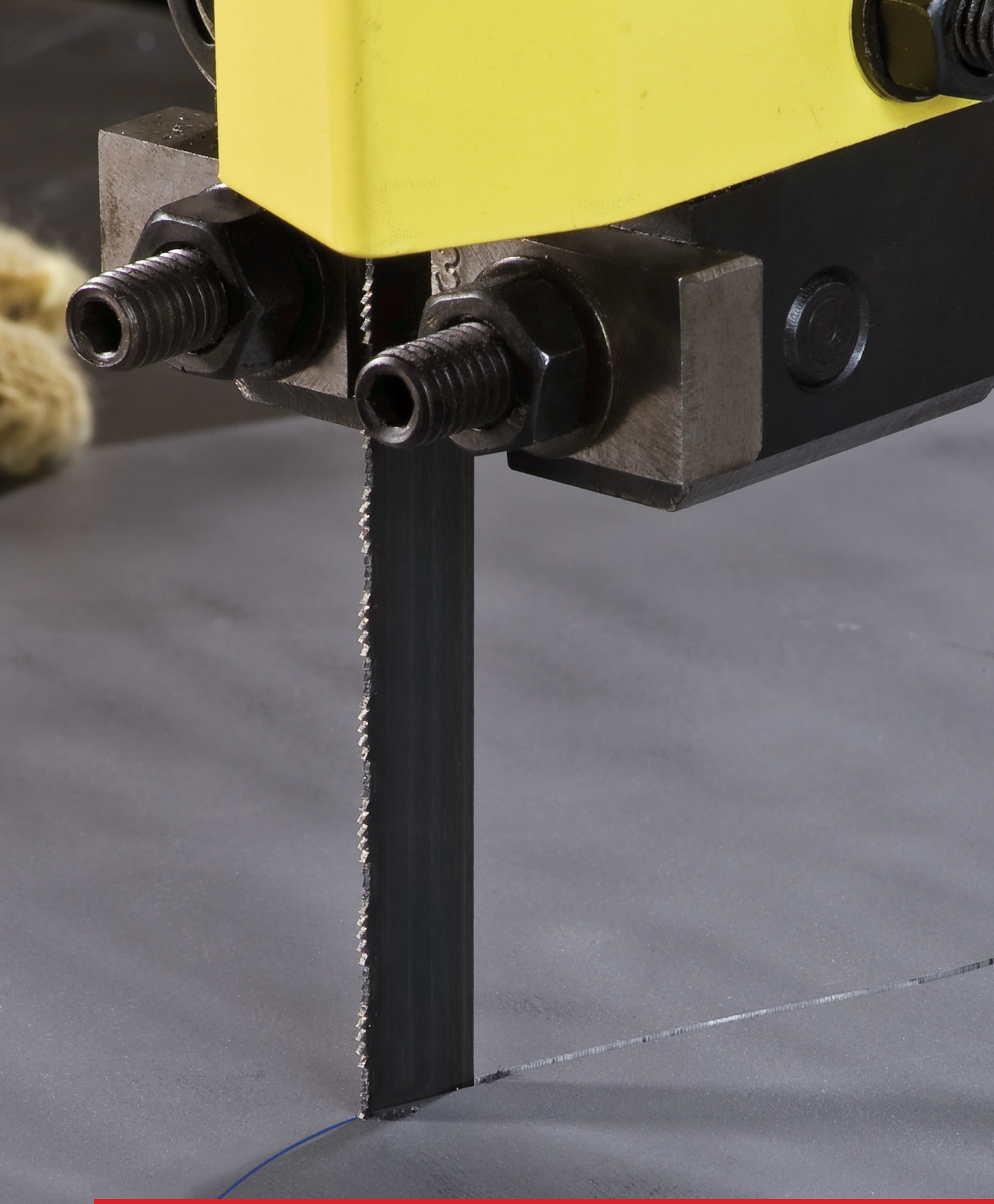




Width x Thickness		Form	Grit	Material No.
in	mm			
1/2 x .020	13 x 0.50	Continuous	Medium 60/85 Diamond Grit	95123

Furnished in welded bands.

Special products on request.



CARBON

CARBON

DURATEC™ SFB

FEATURES

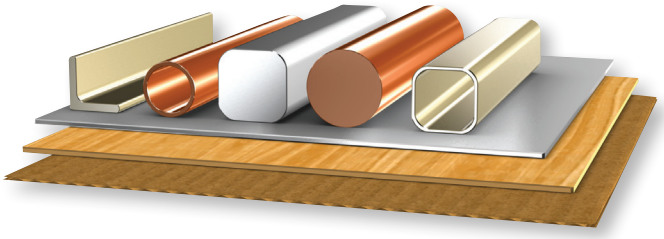
- Made from special high carbon steel
- Flexible back

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 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
3/8 x .025	10 x 0.65	3/HL-P-R	91230
		4/SK-S-R	91240
		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
3/8 x .035	10 x 0.90	3/HL-P-R	91930
1/2 x .025	13 x 0.65	3/HL-P-R	91330
		4/SK-S-R	91340
		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 I SK - Skip tooth profile I S - Straight (Zero) rake I R - Raker set I W - Wavy set
HL - Hook Low tooth profile I HH - Hook High tooth profile I 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 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
3/4 x .032	19 x 0.80	3/SK-S-R	91510
		3/HL-P-R	91515
		4/SK-S-R	91529
		4/RG-S-R	91530
		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
1 x .035	25 x 0.90	2/HL-P-R	91670
		3/SK-S-R	91680
		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 I SK - Skip tooth profile I S - Straight (Zero) rake I R - Raker set I W - Wavy set
HL - Hook Low tooth profile I HH - Hook High tooth profile I 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

Width x Thickness 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 I S - Straight (Zero) rake I BC - Bearcat tooth profile I 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

Band Knives

Features

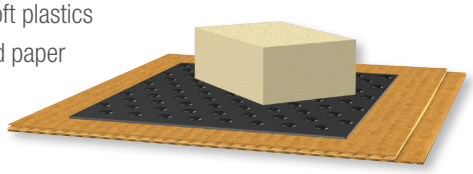
- Available with straight, scallop or wavy tooth cutting edges and a single or double edge bevel
- Made of high-carbon steel and stainless steel
- Razor edge

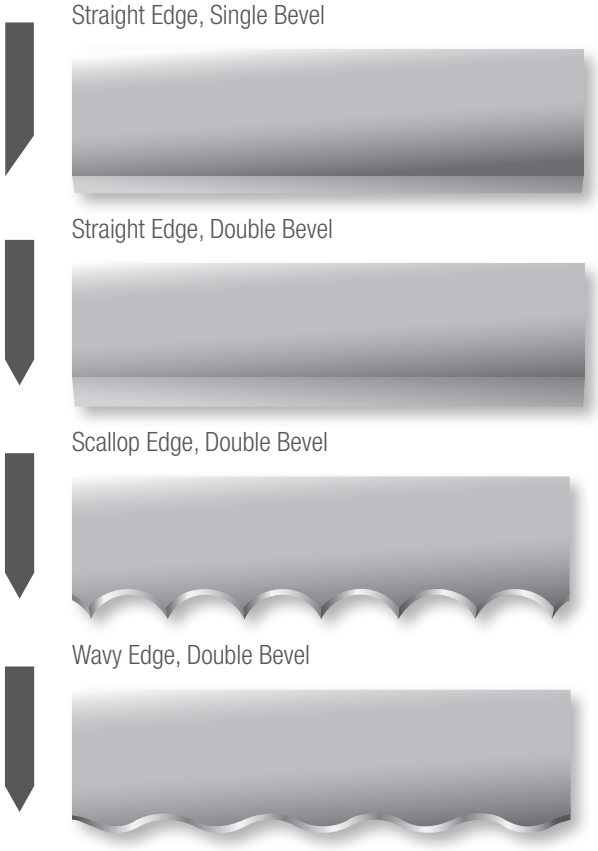
Benefits

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

Applications

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





Width x Thickness in	mm	Edge and Bevel	Material No.
3/8 x .022	10 x 0.55	SC-DB	93126
1/2 x .018	13 x 0.46	SC-DB	93188
1/2 x .022	13 x 0.55	ST-SB	93135
		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
3/4 x .022	19 x 0.55	ST-DB	93609
		SC-DB	93637
		WV-DB	93715
3/4 x .028	19 x 0.70	SC-DB	93629
		WV-DB	93717
1 x .025	25 x 0.60	ST-DB	93794
		SC-DB	93806
1 x .035	25 x 0.90	ST-DB	93796
		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.

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WOOD CUTTING

Wood Cutting

Woodpecker™ Premium

Features

- A selection of blades ideal for a variety of woodworking applications
- Includes blades as thin as .020" for jobs such as contour cutting fine hardwoods to thicker blades for tough tasks including pallet work
- Hardened spring tempered back and ground, precision set teeth with positive tooth angles
- Thin kerf available
- Longer life and faster cutting with less feed
- High production rates and increased yields
- Can be re-sharpened

Width x Thickness in	mm	Pitch/Rake	Material No.
1/4 x .020	6.5 x 0.50	6/SK-S-R	91992
3/8 x .022	10 x 0.55	4/HK-P-R	91996
		6/HK-P-R	91997
1/2 x .022	13 x 0.55	3/HK-P-R	92000
		4/HK-P-R	92001
		6/HK-P-R	92002
5/8 x .022	16 x 0.55	3/HK-P-R	92003
		4/HK-P-R	92004
3/4 x .028	19 x 0.71	3/HK-P-R	92007
1 x .023	25 x 0.58	3/HK-P-R	92010
1 x .035	25 x 0.90	1.3/HK-P-R	92035
		2/HK-P-R	92036
1-1/4 x .035	32 x 0.90	1.3/HK-P-R	92043
1-1/4 x .042	32 x 1.10	1.1/HK-P-R	92017
		1.3/HK-P-R	92018
		5-8/RG-S-R	92046
1-1/2 x .042	38 x 1.10	1.1/HK-P-R	92022
2 x .042	50 x 1.10	1.1/HK-P-R	92026
2-9/16 x .042	65 x1.10	1.1/HK-P-R	92030

HK - Hook tooth profile | P - Positive rake | R - Raker set
SK - Skip tooth profile | RG - Regular 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

Bi-Metal Woodpecker™ Pro

Bi-Metal

Features

- Manufactured from high-speed steel M42 containing 8% cobalt
- Specifically designed for all types of hardwoods and pallet dismantling applications
- Electron beam welded bi-metal construction optimizes cost per cut ratio
- Rockwell tooth hardness C67-69 ensures longer blade life

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

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

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.

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FOOD PROCESSING

Food Processing

Meatkutter™ Premium

MKP

Specifications

- Polished high carbon steel
- Hardened, ground teeth
- Hardened back

Features

- USDA approved
- Accurate, balanced, sharp and fast cutting action with less kerf loss per cut.
- Accurate cuts with less effort
- Laser-etched blade identification guarantees product quality and satisfaction

Meat Types

- Fresh, frozen, bone-in and boneless
- Broilers and turkeys
- Seafood

Applications

- Suitable for kill/harvest and further process operations.
- Fresh/Frozen and prepared food

Width x Thickness 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 .0.55	3/HK-P-A	94318
		4/HK-P-A	94319

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

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

Specifications

- Stainless steel AISI 420
- Ground teeth

Features

- USDA approved
- Rust-proof
- Accurate, balanced, sharp and fast cutting action with less kerf loss per cut
- Laser-etched blade identification guarantees product quality and satisfaction

Meat Types

- Fresh, frozen, bone-in and boneless
- Broilers and turkeys
- Seafood

Applications

- Suitable for kill/harvest and further process operations
- Fresh/Frozen and prepared food

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

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

Food Processing

CarcassKutter™ Premium

CKP

Specifications

- Polished high carbon steel
- Hardened, ground teeth
- Hardened back

Features

- USDA approved
- Accurate, balanced, sharp and fast cutting action with less kerf loss per cut
- Laser-etched blade identification guarantees product quality and satisfaction

Carcass Types

- Animal carcass cuts
- Cattle
- Swine/Hogs

Applications

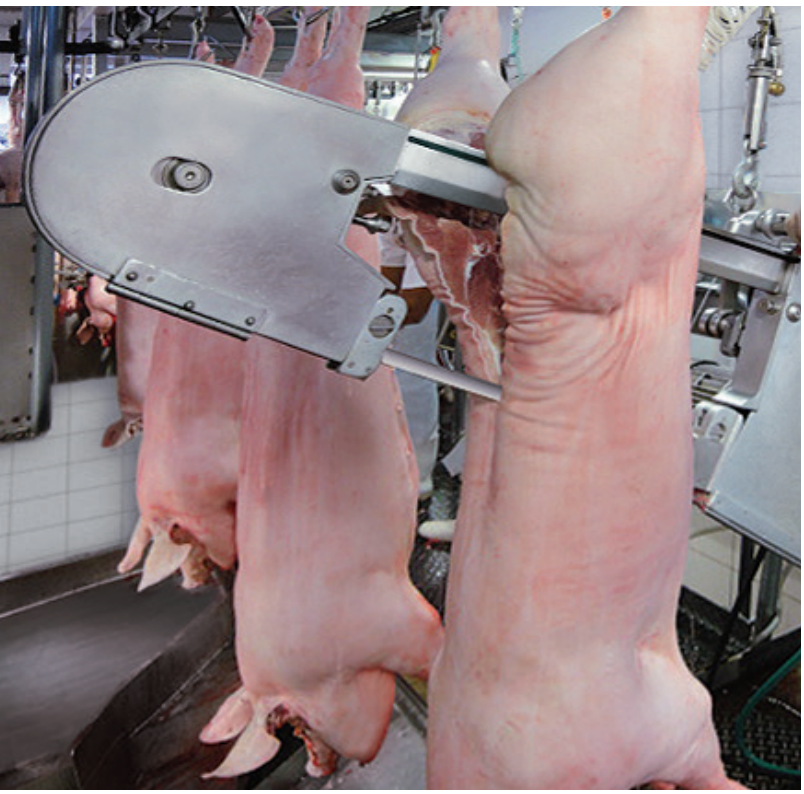
- Suitable for kill/harvest and further process operations
- Fresh/Frozen and prepared food
- Cold storage facilities
- Meat packing and processing plants

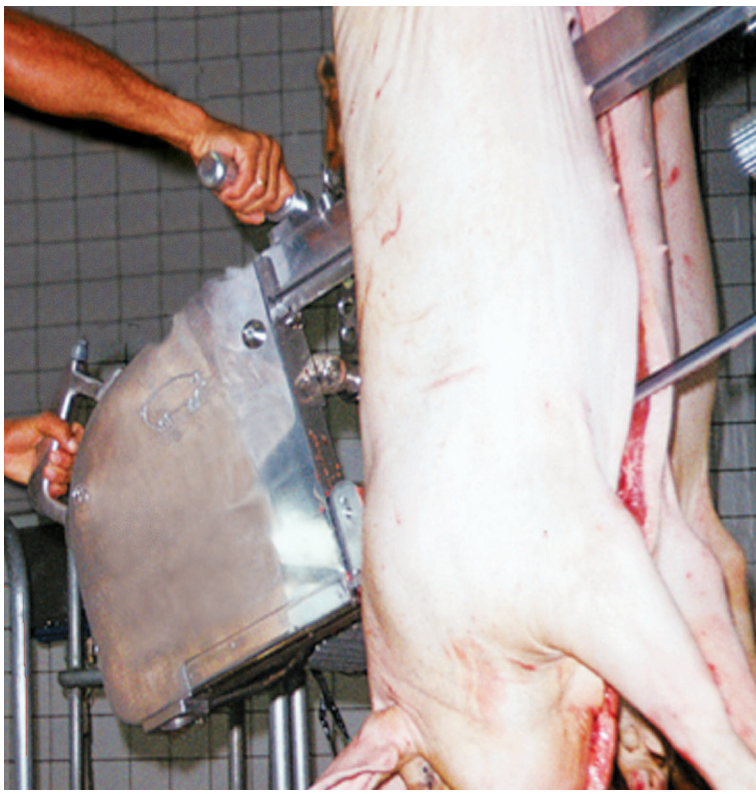
Width x Thickness in	mm	Pitch/Rake	Material No.
3/4 x .022	19 x 0.55	3/HK-P-A	94370
		4/HK-P-A	94371

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

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

Special products on request





Food Processing

Meatkutter™ Frozen

MKF

Specifications

- Polished high carbon steel
- Hardened, ground teeth
- Laser-etched blade for easy origin identification and traceability
- Variety of widths and teeth (as shown on the right)

Features

- USDA approved
- Accurate, balanced, sharp and fast cutting action with less kerf loss per cut
- Excellent cutting precision

Meat Types

- Fish
- Frozen meat up to -4˚F (-20˚ C)

Applications

- Meat packing industries

Width x Thickness in	mm	Pitch/Rake	Material No.
5/8 x .014	16 x 0.35	3/HK-P-A	94360
		3/HL-P-A	94367
5/8 x .016	16 x 0.41	3/HL-P-A	94368
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

Specifications
- Bi-metal high-speed steel band saw blade
- Hardened teeth and back

Features
- Greater durability compared to conventional blades
- Fast, clean cuts
- Clean, accurate cuts with less waste

Meat Types
- Frozen fish up to -76°F (-60° C)
- Large fish

Applications
- Suitable for meat packing, portioning and seafood processing

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 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

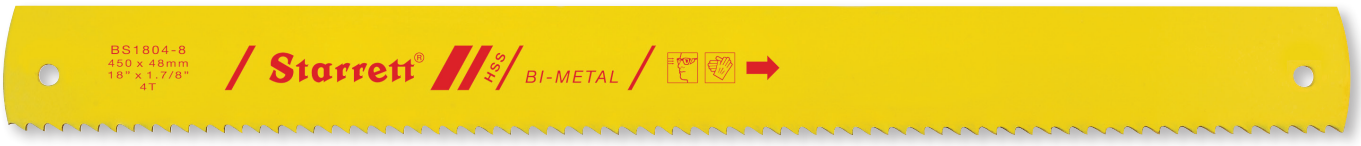
- Available in metric and inch
- Hardened and tempered high-speed steel teeth
- Tough alloy steel back resistant to shock and breakage

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 Up to 3/4" (20mm) Pitch*	From 3/4" to 1-1/2" (From 20mm to 40mm)	From 1-1/2" to 3-1/2" (From 40mm to 90mm)	Above 3-1/2" (Above 90mm)	Bow Speeds in Strokes per Minute **
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 finaer 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 in	mm	TPI (TP/25mm)	Pinhole Diameter
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	
BS1410-6	40102			10	
BS1406-7	40105	14 x 1-5/8 x .075	350 x 41 x 2	6	10.75mm
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	
BS1804-8	40121	18 x 1-7/8 x .088	450 x 47 x 2.25	4	
BS1806-8	40122			6	
BS2104-8	40126	21 x 1-7/8 x .088	525 x 47 x 2.25	4	
BS2106-8	40127			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 Up to 3/4" (20mm) Pitch*	From 3/4" to 1-1/2" (From 20mm to 40mm)	From 1-1/2" to 3-1/2" (From 40mm to 90mm)	Above 3-1/2" (Above 90mm)	Bow Speeds in Strokes per Minute **
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 finaer 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 in	mm	TPI (TP/25mm)	Pinhole 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	14 x 1 x .050	350 x 25 x 1.25	10	
RS1414-5	40050			14	
RS1406-6	40051	14 x 1-1/4 x .062	350 x 32 x 1.6	6	
RS1410-6	40052			10	
RS1610-6	40058	16 x 1-1/4 x .062	400 x 32 x 1.25	10	
RS1706-6	40062	17 x 1-1/4 x .062	425 x 32 x 1.6	6	
RS1710-6	40063			10	
RS1806-6	40064	18 x 1-1/4 x .062	450 x 32 x 1.6	6	10.75mm
RS1810-6	40065			10	
RS1804-7	40067	18 x 1-1/2 x .075	450 x 38 x 2	4	
RS1806-7	40068			6	
RS1804-8	40070	18 x 1-3/4 x .088	450 x 45 x 2.25	4	
RS1806-8	40071			6	
RS2104-8	40075	21 x 1-3/4 x .088	450 x 45 x 2.25	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 in	mm	TPI (TP/25mm)	Pinhole 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	18 x 1-1/2 x .075	450 x 38 x 2	4	
RS450-6	40183			6	
RS450-10	40184			10	
RS500-6	16171	20 x 1-3/4 x .075	500 x 45 x 2	6	
RS500-10	16172			10	
RS550-4	40173	22 x 1-3/4 x .075	550 x 45 x 2	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	24 x 2 x .100	600 x 50 x 2.5	4	
RS600-6	16174			6	
RS650-4	40186	26 x 2-3/16 x .100	650 x 55 x 2.5	4	
RS650-6	40187			6	
RS700-4	40188	28 x 2-3/16 x .100	700 x 55 x 2.5	4	
RS700-6	40189			6	
RS850-4	16175	34 x 2-3/8 x .118	850 x 60 x 3	4	
RS900-2 1/2	68716	36 x 4-1/2 x .138	900 x 114 x 3.5	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.

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RECOMMENDATIONS AND RESOURCES

Recommendations

Blade Break-In

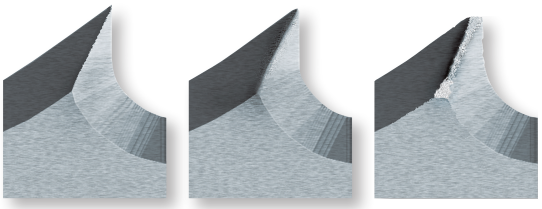
Using the right break-in procedures for a bi-metal blade ensures longer blade life, faster cuts for a longer period of time and consistent performance. Conversely, blade life can be significantly compromised if the proper break-in procedures are not followed.

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.

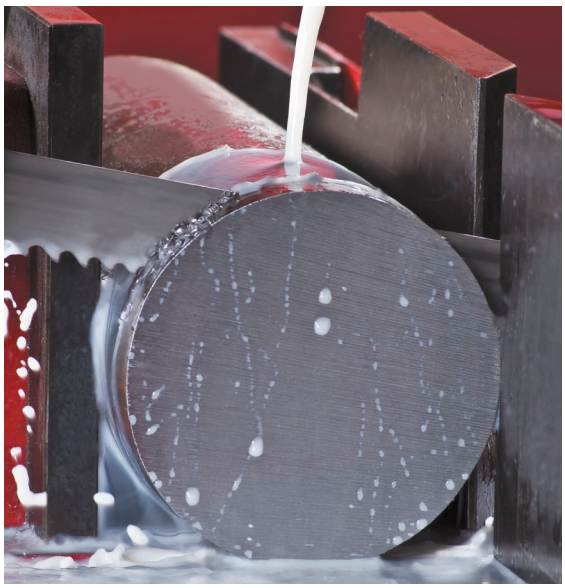
Harder materials such as nickel-based alloys like inconel, hardened steels, tool steels and stainless steels:

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.

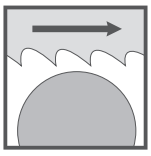
Proper blade installation achieves more efficient blade performance.

- Wear gloves when handling band saw blade

- Use eye protection, safety shoes, and hearing protection

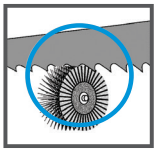
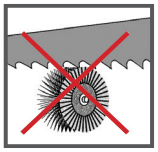
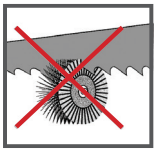


- Select appropriate blade for cutting application
- Unfold blade properly. Do not throw. Throwing the blade will result in tooth damage that will reduce saw blade performance
- Install blade with saw teeth pointing in proper direction



- 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

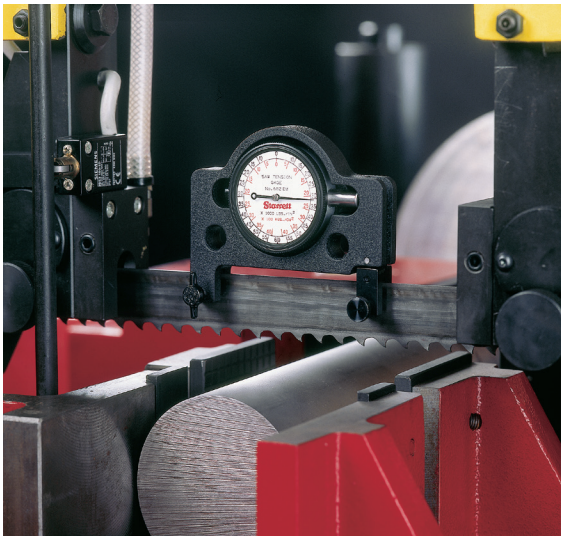
Basic Blade Change Guidelines

- 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

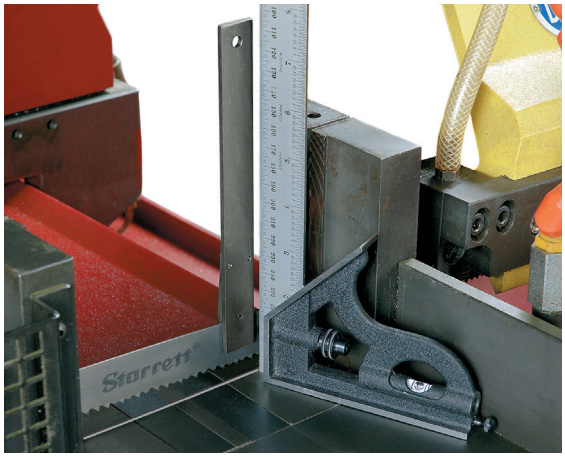


Saw Tension Gage For Band Saw Blades No. 682EMZ

- Check for proper tension in either English or metric
- Graduated in kg/cm² (0 to 4.000) and in pounds/in² (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.

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.

PowerCalc App

The PowerCalc App helps users choose the right Starrett band saw blade for their application on a smartphone. The PowerCalc App is free and easy to install on any smartphone or mobile device.

The PowerCalc App is available on the following sites:

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
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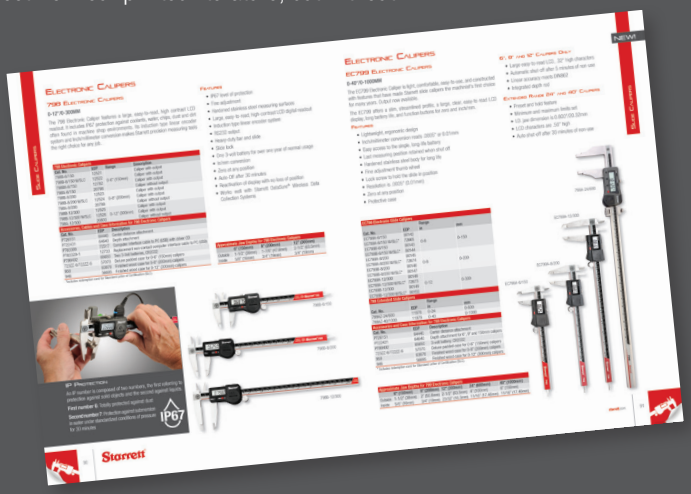

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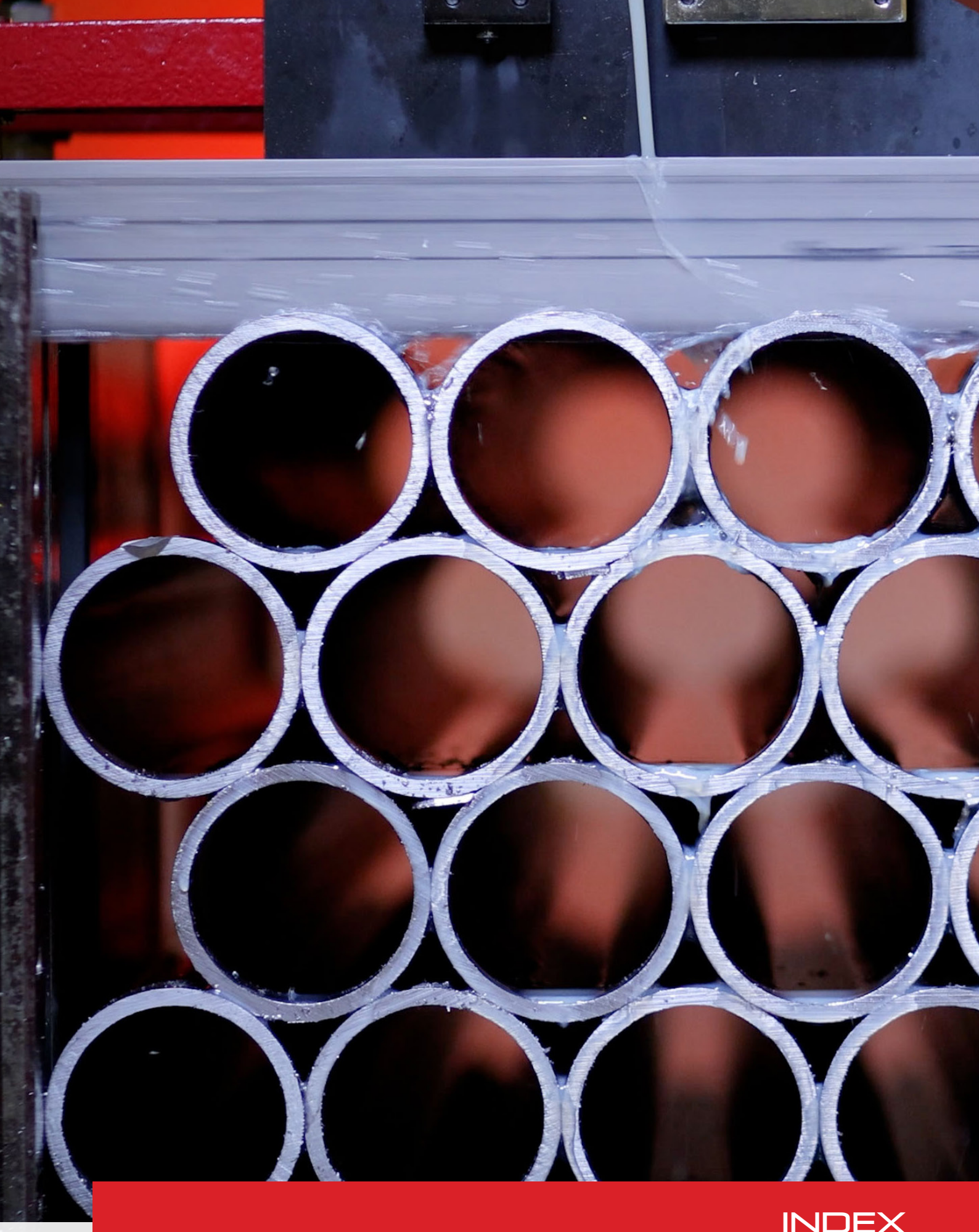

INDEX

A

B

C

D

F

P

R

T

W

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

Product Demonstration

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BAND SAW BLADES

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