



Eberle 08.24

1836.01

# Made for performance.

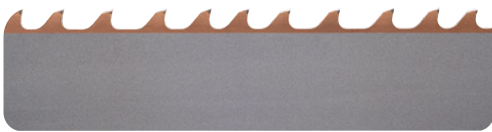
Band saw blades made in Germany.

# Carbide-tipped Blades

for extreme cutting applications

**Legend:**

- Square Steel:**
  - square bar
  - flat bar
  - bundle single-layer
- Round Steel:**
  - round bar
  - bundle single-layer
- Tube:**
  - thick-walled



## CT-flex® nano coated

**Features:**

- Multichip® geometry
- TiAlN-coating
- heat and wear resistant cutting edge
- pre-honed tooth edges

**Applications:**

- stainless, acid-resistant, hardening martensitic steel
- nickel-based alloys
- ≤ 65 HRC

\*on request



## CT-flex® 4000

**Features:**

- CT4 geometry
- excellent performance
- short cycle times
- very smooth running blade

**Applications:**

- extremely hard-to-cut materials
- ≤ 65 HRC



## CT-flex® 3000

**Features:**

- CT3 geometry
- excellent performance
- short cycle times
- high stability

**Applications:**

- hard-to-cut materials
- ≤ 65 HRC

**Work pieces:**

**Tooth top view:**

in	Teeth per inch (tpi)						mm
	.75/1.25	1/1.3	1.4/2	2/3	3/4		
1 1/2 × .050			TR	TR	TR*		41 × 1,30
2 × .063		TR*	TR	TR			54 × 1,60
2 5/8 × .063	TR*	TR*	TR				67 × 1,60
3 1/8 × .063	TR		TR*				80 × 1,60

**Work pieces:**

**Tooth top view:**

in	Teeth per inch (tpi)						mm
	.75/1.25	1/1.3	1.4/2	2/3	3	3/4	
3/4 × .035					TR		20 × 0,90
1 × .035				TR	TR	TR	27 × 0,90
1 1/4 × .042				TR	TR	TR	34 × 1,10
1 1/2 × .050			TR	TR		TR	41 × 1,30
2 × .063	TR	TR	TR	TR			54 × 1,60
2 5/8 × .063	TR	TR	TR				67 × 1,60
3 1/8 × .063	TR		TR				80 × 1,60

**Work pieces:**

**Tooth top view:**

in	Teeth per inch (tpi)				mm
	.75/1.25	1/1.3	1.4/2	2/3	
1 1/4 × .042				TR	34 × 1,10
1 1/2 × .050			TR	TR	41 × 1,30
2 × .063	TR	TR	TR		54 × 1,60
2 5/8 × .063	TR	TR	TR		67 × 1,60
3 1/8 × .063	TR		TR		80 × 1,60



## CT-flex® CHM

### Features:

- Multichip® geometry
- superior performance
- negative rake angle
- extreme wear resistance

### Applications:

- case hardened and chrome plated materials
- ≤ 65 HRC



## CT-flex® ALU

### Features:

- reduced feed force
- resists pinching
- optimized for manual feed
- minor material loss and improved chip formation due to reduced kerf width of 2.00 mm

\*optional kerf width of 2.00 mm or 2.50 mm

### Applications:

- Aluminum and Aluminum alloys
- large plates and large blocks of Aluminum
- foundry applications
- non-ferrous metals



## CT-flex® Pro

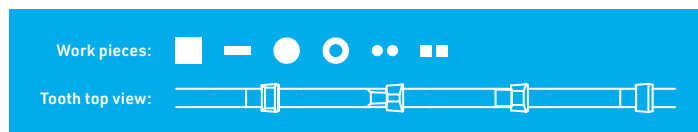
### Features:

- triple chip tooth geometry
- set tooth
- vibration resistant

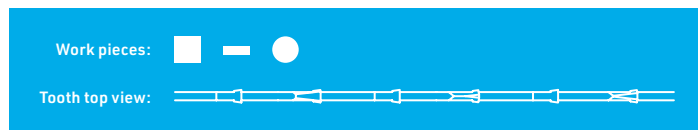
### Applications:

- corrosion and acid-resistant steels
- nickel-based alloys
- ≤ 65 HRC

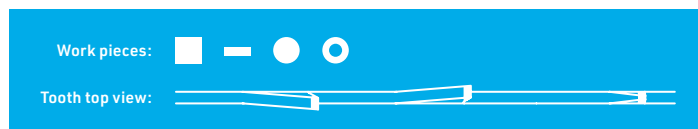
ST = set tooth



in	Teeth per inch (tpi)					mm
	3	3/4				
1 × .035			TRN			27 × 0,90
1 1/4 × .042		TRN	TRN			34 × 1,10
1 1/2 × .050			TRN			41 × 1,30



in	Teeth per inch (tpi)					mm
	.75/1.25	1/1.3	1.4/2	2/3	3/4	
1 × .035				TR	TR	27 × 0,90
1 1/4 × .042				TR	TR	34 × 1,10
1 1/2 × .050			TR	TR	TR	41 × 1,30
2 × .063	TR*	TR*	TR*			54 × 1,60
2 5/8 × .063	TR*	TR*	TR*			67 × 1,60
3 1/8 × .063	TR*					80 × 1,60



in	Teeth per inch (tpi)					mm
	.75/1.25	1.4/2	2/3	3	3/4	
1 × .035				ST	ST	27 × 0,90
1 1/4 × .042			ST		ST	34 × 1,10
1 1/2 × .050		ST	ST			41 × 1,30
2 × .063		ST				54 × 1,60
2 5/8 × .063	ST					67 × 1,60

# Bimetal Blades

for high-performance cutting

**Square Steel**

- square bar
- flat bar
- bundle single-layer
- bundle multiple-layer

**Round Steel**

- round bar
- bundle single-layer
- bundle round bars

**Tube**

- thin-walled
- thick-walled
- bundle tubes

**Profile**

- beams
- special profiles



## nanoflex<sup>®</sup> VTX coated

**Features:**

- TiAlN-coating
- special alloyed micro-resistant cutting edge
- increased tooth hardness
- variable tooth height with strong positive rake angle

**Applications:**

- corrosion and acid-resistant steel
- nickel-based alloys
- tempered steel
- ≤ 50 HRC

Work pieces:

Tooth top view:

in	Teeth per inch (tpi)						mm
	.65/1.25	.75/1.25	1.1/1.5	1.4/2	2/3	3/4	
1 × .035						CHT	27 × 0,90
1 1/4 × .042					CHT	CHT	34 × 1,10
1 1/2 × .050				CHT	CHT	CHT	41 × 1,30
2 × .050				CHT	CHT		54 × 1,30
2 × .063			CHT	CHT	CHT		54 × 1,60
2 5/8 × .063	CHT	CHT	CHT	CHT			67 × 1,60
3 1/8 × .063	CHT	CHT	CHT	CHT			80 × 1,60



## nanoflex<sup>®</sup> Black coated

**Features:**

- TiAlN-coating
- prehoned edges
- short cycle times
- excellent wear resistance

**Applications:**

- Aluminum
- mild steels
- alloys
- stainless steels
- ≤ 50 HRC

Work pieces:

Tooth top view:

in	Teeth per inch (tpi)						mm
	.65/1.25	.75/1.25	1.1/1.5	1.4/2	2/3	3/4	
1 1/2 × .050				DCS	DCS	DCS	41 × 1,30
2 × .063			CSP	DCS	DCS	DCS	54 × 1,60
2 5/8 × .063	DCS	CSP	DCS				67 × 1,60
3 1/8 × .063	DCS	CSP	DCS				80 × 1,60



NEW TPI  
27' 2/3

## duoflex<sup>®</sup> VTX

**Features:**

- variable, positive tooth geometry
- enhanced chip division
- increased precision and stability
- micro-wear resistant cutting edge

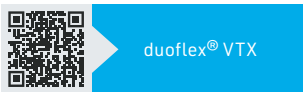
**Applications:**

- large to very large work pieces
- corrosion and acid resistant steels
- heat-treated steels
- nickel-based alloys

Work pieces:

Tooth top view:

in	Teeth per inch (tpi)						mm
	.65/1.25	.75/1.25	1.1/1.5	1.4/2	2/3	3/4	
1 × .035					CHT	CHT	27 × 0,90
1 1/4 × .042					CHT	CHT	34 × 1,10
1 1/2 × .050				CHT	CHT	CHT	41 × 1,30
2 × .050				CHT	CHT		54 × 1,30
2 × .063			CHT	CHT	CHT		54 × 1,60
2 5/8 × .063	CHT	CHT	CHT	CHT			67 × 1,60
3 1/8 × .063	CHT	CHT	CHT	CHT			80 × 1,60







## duoflex® PT Plus

### Features:

- aggressive and stable cutting edge
- impressive performance
- increased chip space volume for solid materials
- chip former for optimal chip flow

### Applications:

- pipes
- profiles
- solid materials
- bundle cuts
- ≤ 44 HRC

\*optional: nanoflex® PT Plus coated



## duoflex® PT

### Features:

- strong positive tooth geometry
- variable setting widths
- reduced vibration and tooth breakage

### Applications:

- pipes and profiles
- tubes
- ≤ 44 HRC



## duoflex® M42

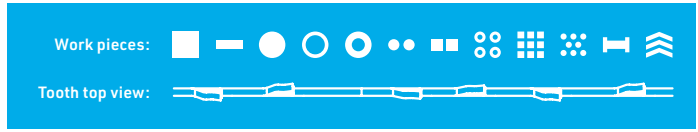
### Features:

- vibration resistant tooth edge
- zero and positive rake angles

### Applications:

- variable and constant tooth pitches for universal applications
- mild steels
- structural steels
- alloys
- ≤ 44 HRC

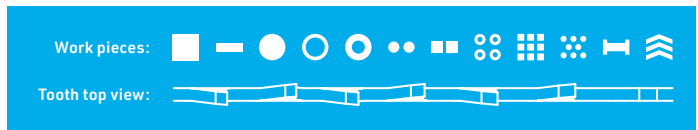
in	Teeth per inch (tpi)														mm		
	3	4	6	8	10	14	.75/ 1.25	1.4/2	2/3	3/4	4/6	5/8	6/10	8/12		10/14	14/18
1/4 × .035		CW	CW		N	N									N		6 × 0,90
3/8 × .035		CW	CW		N	N									N		10 × 0,90
1/2 × .025		CW	CW		N	N							N	N	N	N	13 × 0,65
1/2 × .035		CW	CW	CW	N	N	N						N	N	N		13 × 0,90
3/4 × .035					N	N					CS	N	N	N	N	N	20 × 0,90
1 × .035	DCS	CS	N						DCS	DCS	CS/ DCS	N/CS	N	N	N		27 × 0,90
1 1/4 × .042								DCS	DCS	DCS	CS	N	N	N			34 × 1,10
1 1/2 × .050								DCS	DCS	DCS	CS	N					41 × 1,30
2 × .050								DCS	DCS	DCS	CS						54 × 1,30
2 × .063								DCS	DCS	DCS	CS						54 × 1,60
2 5/8 × .063								DCS	DCS	DCS	DCS						67 × 1,60
3 1/8 × .063								DCS	DCS								80 × 1,60



in	Teeth per inch (tpi)						mm
	2/3	3/4	4/6				
1 × .035		CPS	CPS	CPS			27 × 0,90
1 1/4 × .042		CPS	CPS	CPS			34 × 1,10
1 1/2 × .050		CPS*	CPS*	CPS*			41 × 1,30
2 × .050		CPS	CPS				54 × 1,30
2 × .063		CPS*	CPS*	CPS*			54 × 1,60
2 5/8 × .063		CPS*	CPS*				67 × 1,60



in	Teeth per inch (tpi)						mm
	2/3	3/4	4/6	5/8	8/12		
3/4 × .035						CST	20 × 0,90
1 × .035		CST	CST	CST	CST	CST	27 × 0,90
1 1/4 × .042		CST	CST	CST	CST		34 × 1,10
1 1/2 × .050		CST	CST	CST	CST		41 × 1,30
2 × .063		CST	CST	CST			54 × 1,60
2 5/8 × .063		CST	CST				67 × 1,60



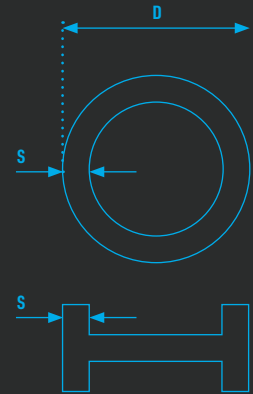


# Cutting Recommendations

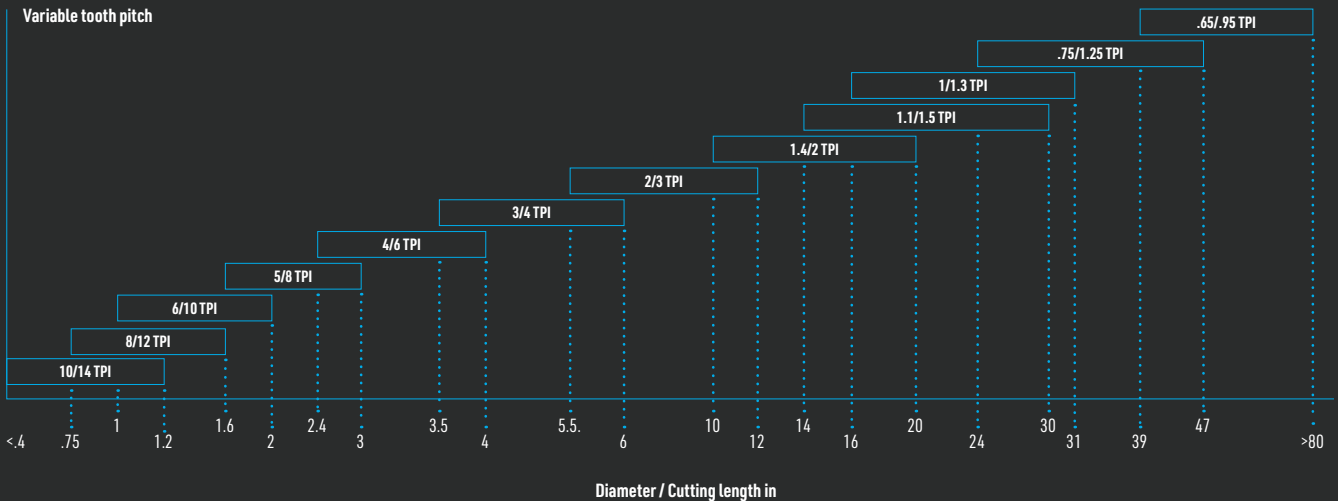
Find the right saw blade for your individual application

## Cutting recommendations for tubes and profiles

D in	.75	1.5	2.4	3	4	6	8	12	16	20	>28
S in	Teeth per inch (tpi)										
.08	14	14	14	14	10/14	10/14	10/14	10/14	8/12	8/12	6/10
.12	14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	6/10	6/10	6/10
.15	14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6
.20	14	10/14	10/14	8/12	6/10	6/10	5/8	4/6	4/6	4/6	4/6
.25	14	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6	4/6	4/6
.3	14	8/12	6/10	6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6
.4		6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4
.5		6/10	5/8	4/6	4/6	4/6	4/6	3/4	3/4	3/4	3/4
.6				4/6	4/6	3/4	3/4	3/4	3/4	2/3	2/3
.75				4/6	4/6	3/4	3/4	3/4	3/4	2/3	2/3
1.2				3/4	3/4	3/4	2/3	2/3	2/3	2/3	1.4/2
2						2/3	2/3	2/3	2/3	1.4/2	1.4/2
3							2/3	1.4/2	1.4/2	1.4/2	1/1.3
4								1.4/2	1.4/2	1/1.3	.75/1.25
6										.75/1.25	.75/1.25
>10										.75/1.25	.75/1.25



## Cutting recommendations for solid material



## Tooth forms



### N-TOOTH | neutral rake angle

- short-chip materials
- small work pieces



### CS-TOOTH | positive rake angle

- long-chip, tough materials
- universal application



### DCS-TOOTH | positive rake angle

- heavy duty, high alloyed work pieces
- large cross-sections



### CPS-TOOTH | positive rake angle

- austenitic materials
- nickel-based alloys



### CPS-TOOTH | positive rake angle

- short- and long chip materials
- profiles, pipes, solid materials
- single, bundle and layer cutting



### CST-TOOTH | positive rake angle

- short-chip materials
- profiles, tubes, bundles



### CW-TOOTH | positive rake angle

- low-alloy materials, Aluminum
- mold construction, contours



### CHT-TOOTH | variable, extremely positive rake angle

- hard-to-cut materials
- heat-treated steels
- large to very large work pieces



### TR-TOOTH | variable rake angle

- heavy duty work pieces
- high cutting performance

## Made for your satisfaction.

### Put your trust in our experience

Our international distribution network is based on longterm partnerships with top-notch sawing specialists, who help solve your specific questions on various applications.

To place an order, please contact either your regional Eberle Distribution Center (EDC), local distributor/salesman or get in touch with our headquarters in Augsburg.

### Current trade shows

See our trade show schedule directly linked to the event and to Google maps on our website: [www.eberle-augsburg.com](http://www.eberle-augsburg.com)

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### Technical advice

Should you have any questions about band saw applications or ways to optimize sawing processes, Eberle's expert team will provide competent support.

# Eberle

| Made for more

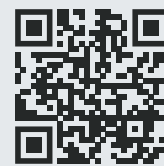
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We look forward to your call.



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