

Starrett®

Precision, Quality, Innovation

BAND SAW BLADES

Bi-Metal

Carbide

Carbon

Portaband

Diamond Grit

Wood Cutting

Food Processing

Power Hacksaws

Services

Catalog 60



PRECISION, QUALITY, INNOVATION

For more than 130 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 continue 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, as well as PowerCalc, an online program that assists in the correct choice of the band saw blade.

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.

17

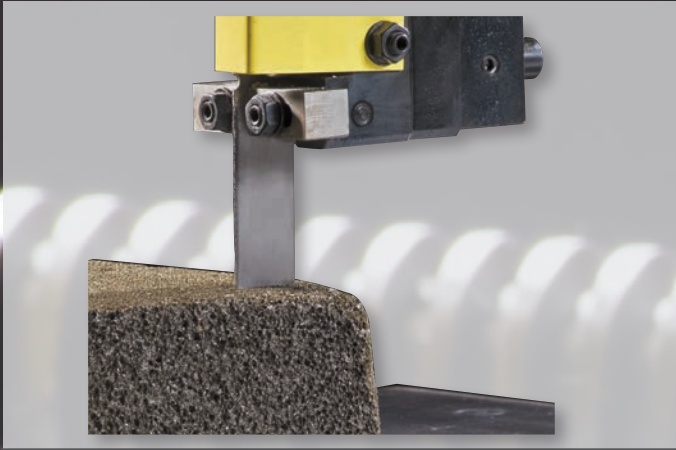
CARBIDE

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



DIAMOND GRIT

Band saw blade coated with diamond grains is ideal for cutting abrasive materials with precision and excellent finish.

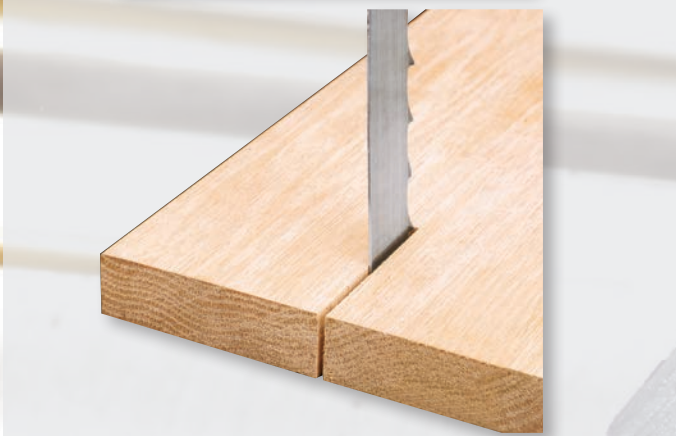
34



CARBON

Suitable for horizontal and vertical machines with manual or gravity fed. 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.

56

ACCESSORIES

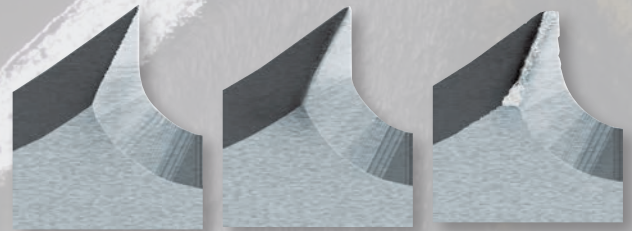
Pocket Laser Tachometer kit with case, Band Saw Blade Tension Gage and Band Saw Blade Alignment Gage.

58

RESOURCES

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

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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



Factories and Distribution Centers



Starrett Distribution Centers and Offices



5-Mount Airy, North Carolina, USA



6-Columbus, Georgia, USA



7-Itu, São Paulo, Brazil



8-Jedburgh, Scotland



9-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

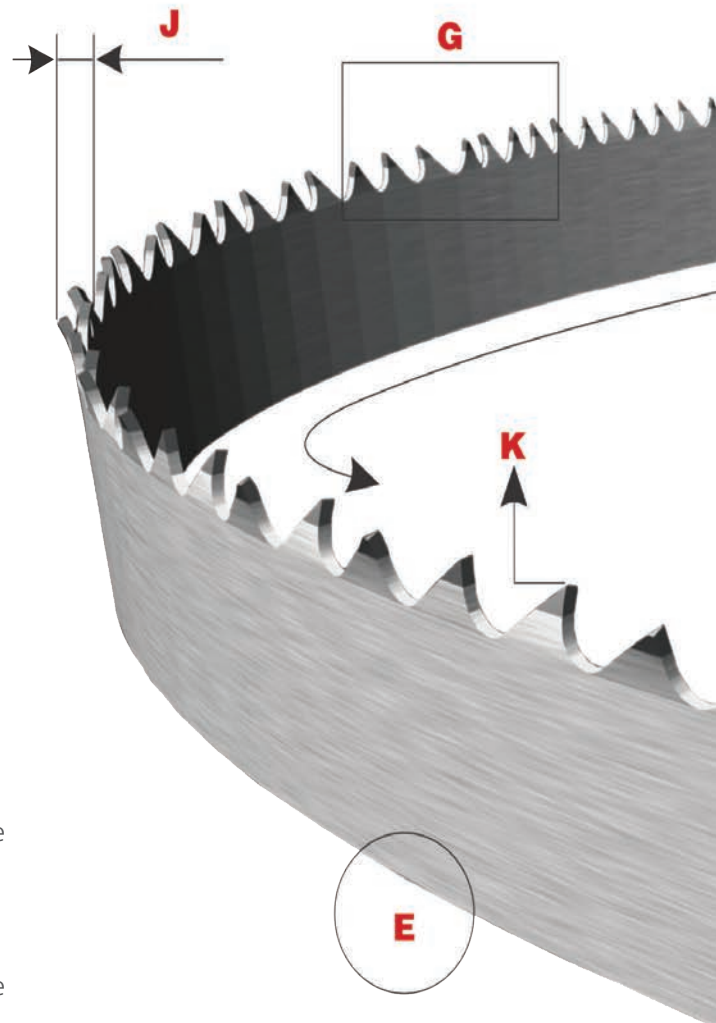
Surface of the tooth where the chip is formed. The tooth can have a positive, negative or straight angle. (Rake)

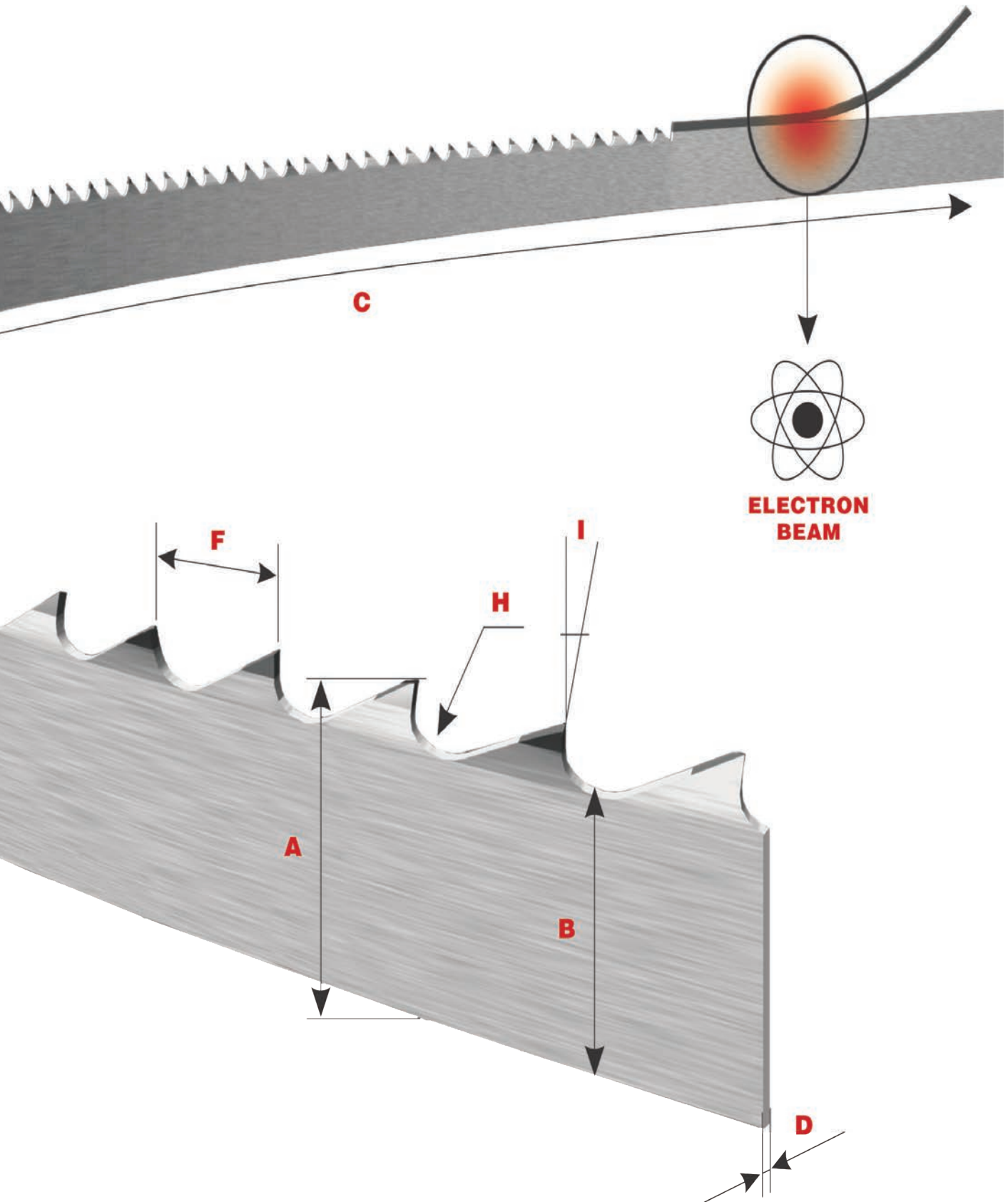
J-TOOTH SET

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 CORRECT BLADE

1 Quick Guide











FERROUS



	Aluminium	Tubes and Profiles	Carbon Steel	Carbon Steel Alloys	Cast Iron	Copper Alloys
BI-METAL				☆☆☆	☆☆☆	☆☆☆
Primalloy™ NEW Page 18				☆☆☆	☆☆☆	☆☆☆
Intenss™ PRO-VTH Page 19				☆☆		
Intenss™ PRO Page 20	☆☆	☆☆	☆☆☆	☆☆☆	☆☆	☆☆
Versatix™ MP Page 21		☆☆☆				
Powerband M-42 Page 22	☆☆	☆☆	☆☆	☆	☆☆	☆
Intenss™ PRO-DIE Page 23	☆☆	☆☆	☆☆	☆☆		☆
Univerz™ Page 24	☆	☆☆	☆			
CARBIDE						
Advanz™ MC7 NEW Page 28	☆☆		☆☆☆	☆☆☆	☆☆	☆☆
Advanz™ MC5 NEW 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 NEW Page 36	☆	☆	☆			
Duratec™ FC Page 38						
Band Knives Page 39						

*Foundry-Gates and Risers

**Induction or Case Hardened

FERROUS						NON-FERROUS	
High Speed Steel	Stainless Steel	Tool Steel - Hot work	Tool Steel - Cold Work	Nickel and Titanium Alloys	Steel with hardness above 45 HRC	Composite materials and abrasives	Foam, Paper, Plastic, and Rubber
							
★★★	★★	★★★	★★★	★★			
★★	★★★★	★★	★★	★★★★			
★★	★★	★★	★★	★			
★	★★	★	★	★			
★★★★	★★★★	★★★★	★★★★	★★★★	★★★★		
★★	★★	★★	★★	★★	★★		
★	★	★	★	★★	★★		
					★★★★		
					★★★★	★★★★	
						★★★★	
							★★★★
						★★	
							★★★★

CHOOSING THE CORRECT BLADE

2 Tooth Shapes



Contant Pitch



Variable Pitch



.8-1.3 to 14-18



1-2 to 4-6



2-3 to 6-10



6 to 32



8-12 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

Versatix™ MP

- Extremely robust, shockproof
- Positive Rake angle
- Ideal for cutting tubes and profiles

Powerband M-42 / 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™ MCS / 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 CORRECT 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.



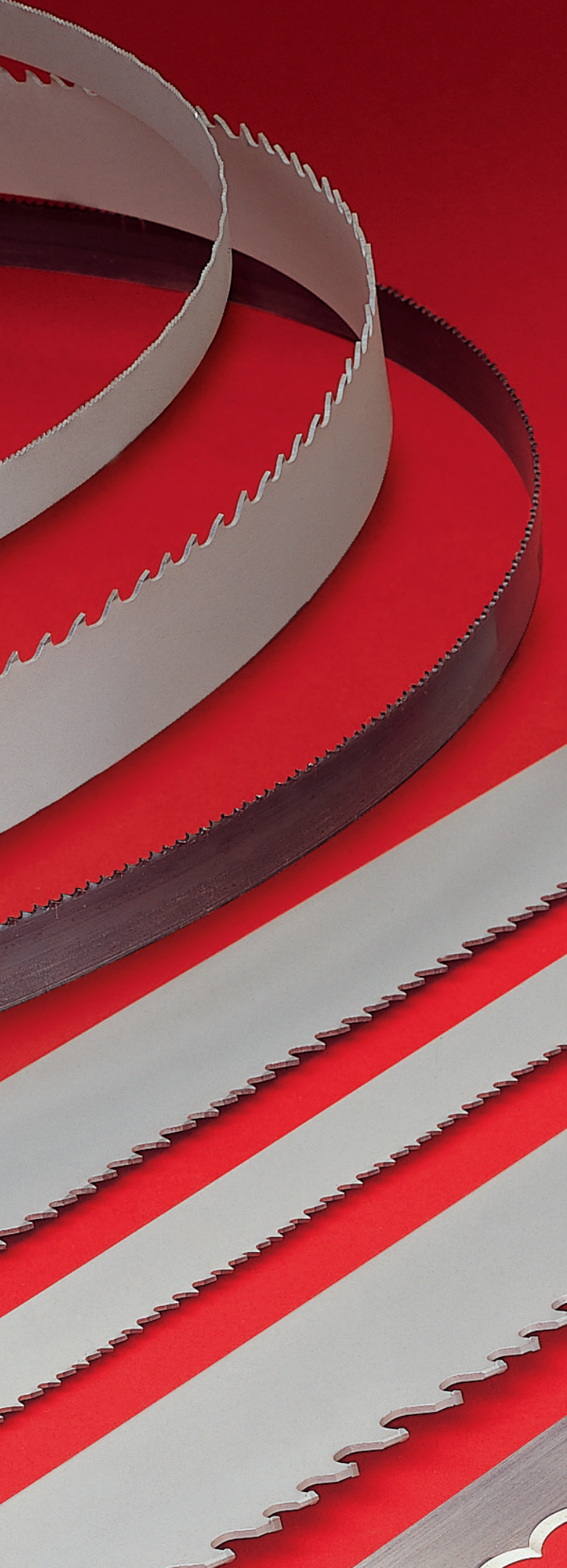
Wavy

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



Trapezoid

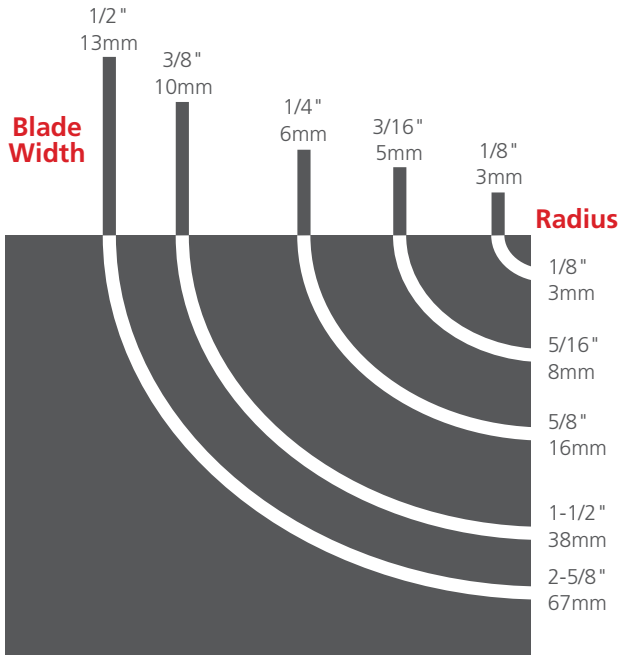
Special carbide cylinder, welded to an alloy backer, then precision ground with a high/low tooth form.



CHOOSING THE CORRECT 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. (Choose a finer pitch if finish is most important.)

Section to be Cut (Inch)	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 (Inch)	Outside diameter of tube or maximum profile section length (Inch)												
	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	4-6	3-4	3-4	3-4	3-4	3-4	3-4	2-3	2-3	2-3
5/8"			4-6	4-6	3-4	3-4	3-4	3-4	3-4	2-3	2-3	2-3	2-3
3/4"			4-6	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	3-4	2-3	2-3	2-3	1.4-2	1.4-2
2"						3-4	3-4	3-4	2-3	2-3	1.4-2	1.4-2	1-1.2
2-3/8"								3-4	2-3	2-3	1.4-2	1.4-2	1-1.2

CHOOSING THE CORRECT BLADE

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.





POWERCALC

Starrett PowerCalc Band Saw Selector is a web-based application that runs on any Windows® operating system. 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

Access starrett.com/powercalc to increase productivity in the cutting process.



BI-METAL BAND SAW BLADES

NEW! BI-METAL

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

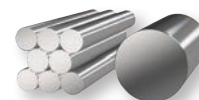
High content of Cobalt and Vanadium guarantee:

- 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.
Inches	mm		
1 x .035	25 x 0.90	3-4/P	99800
1-1/4 x .042	32 x 1.10	2-3/P	99801
		3-4/P	99802
		1.4-2/P	99803
1-1/2 x .050	38 x 1.30	2-3/P	99804
		3-4/P	99805
		1.4-2/P	99806
2 x .063	50 x 1.60	2-3/P	99807
		3-4/P	99808
		1-1.2/P	99809
2-5/8 x .063	67 x 1.60	1.4-2/P	99810
		2-3/P	99811

P = Positive Rake
 1" to 2-5/8" sizes available in 150' (45m) coils.
 All 150' coils supplied within plus or minus 10% of ordered size.
 Furnished in welded bands for all widths, or in random coils for 1" to 1-1/2" widths.



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 bimetal and carbide tip product lines.

BI-METAL

bi-metal unique®

INTENSSTM PRO-VTH



FEATURES

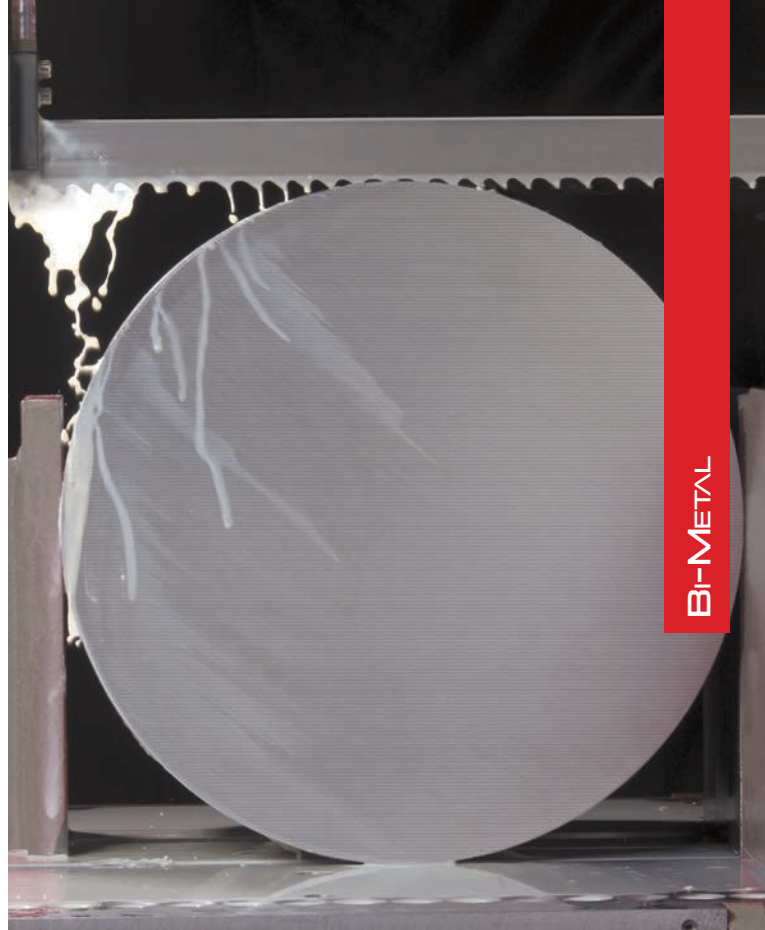
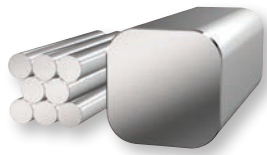
- Uniquely designed tooth edge with variable height and set
- Positive rake, ground teeth

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



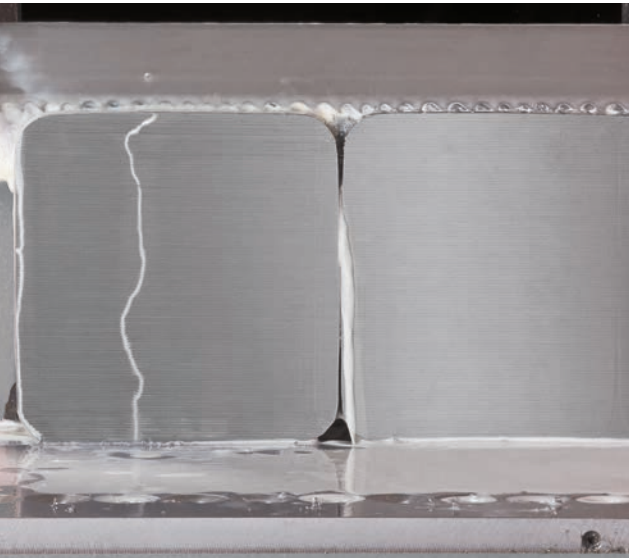
BI-METAL

Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
1 x .035	25 x 0.90	2-3P/T	99948*
		3-4P/T	99949*
		4-6P/T	99950*
1-1/4 x .042	32 x 1.10	2-3P/T	99953
		3-4P/T	99954
1-1/2 x .050	38 x 1.30	2-3P/T	99958
		3-4P/T	99959
2 x .063	50 x 1.60	1-1.2P/T	99991
		1.4-2P/T	99967
2-5/8 x .063	67 x 1.60	1.4-2P/T	99969
3.1/8 x .063	79 x 1.60	1-1.2P/T	99993
		1.4-2P/T	99988

P = Positive Rake • T = Tapered Shape

*bi-metal unique® Technology

1" and 1-1/4" sizes available in 250' (76m) coils. 1-1/2" and 2" sizes available in 150' (45m) coils. 2-5/8" and larger available in welded bands only.

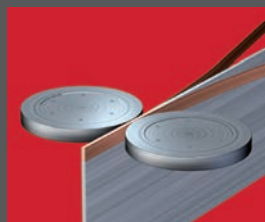


1. Patented process providing 170% more weld contact for superior teeth stripping resistance

2. Significantly reduced fracture and breakage

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

bi-metal unique®



BI-METAL



INTENSTM PRO



FEATURES

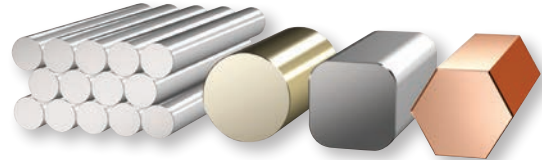
- Complete line with a full range of widths and pitches to suit a variety of cutting needs
- Unique tooth geometry provides intense production cutting in ferrous and non-ferrous metals

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.
Inches	mm		
3/4 x .035	19 x 0.90	3-4/P	99191*
		4-6/P	99902*
		5-8/P	99903*
		6-10/P	99206*
1 x .035	25 x 0.90	2-3/P	99905*
		3-4/P	99906*
		4-6/P	99907*
		5-8/P	99908*
1-1/4 x .042	32 x 1.10	6-10/P	99318*
		3/P	99484*
		2-3/P	99912
		3-4/P	99913
1-1/2 x .050	38 x 1.30	4-6/P	99914
		5-8/P	99915
		6-10/P	99500
		1-1.2/P	99917
2 x .063	50 x 1.30	1-2/P	99919
		1.4-2/P	99921
		2-3/P	99923
		3-4/P	99924
2-5/8 x .063	67 x 1.30	4-6/P	99926
		5-8/P	99927
		.8-1.3/P	99928
		1-1.2/P	99929
3-1/8 x .063	79 x 1.30	1.4-2/P	99931
		2-3/P	99932
		3-4/P	99933
		.8-1.3/P	99934
3-1/8 x .063	79 x 1.30	1-1.2/P	99937
		1.4-2/P	99941
		.8-1.3/P	99942
		1-1.2/P	99943
3-1/8 x .063	79 x 1.30	1-2/P	99945
		1.4-2/P	99947

P = Positive Rake
 *bi-metal unique® Technology
 Furnished in welded bands for all widths, or in random coils for 3/4" to 1-1/2" widths.
 Note: Special products on request.

BI-METAL

bi-metal
unique®

VERSATIX™ MP



Starrett® Versatix™ MP

FEATURES

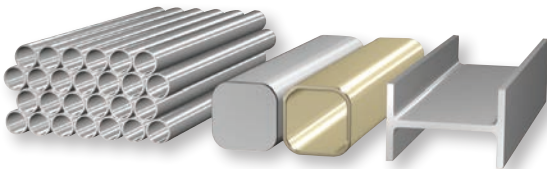
- Special tooth geometry developed for cutting structural materials
- Increased tooth strength

BENEFITS

- Faster and straighter cuts
- Less tooth breakage
- 2-3 and 3-4 pitches have 8 degree positive rake for faster cutting

APPLICATIONS

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



BI-METAL

Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
3/4 x .035	19 x 0.90	4-6/P	99212*
		5-8/P	99211*
		6-10/P	99210*
		8-12/P	99222*
		10-14/P	99234*
1 x .035	25 x 0.90	3-4/P	99343*
		4-6/P	99342*
		5-8/P	99341*
		6-10/P	99340*
		8-12/P	99329*
		10-14/P	99334*
		2-3/P	99494
1-1/4 x .042	34 x 1.10	3-4/P	99495
		4-6/P	99496
		5-8/P	99497
		6-10/P	99498

Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
1-1/2 x .050	41 x 1.30	2-3/P	99517
		3-4/P	99518
		4-6/P	99519
		5-8/P	99520
2 x .050	54 x 1.30	2-3/P	99551
		3-4/P	99552
		4-6/P	99553
2 x .063	54 x 1.60	2-3/P	99562
		3-4/P	99563
2-5/8 x .063	67 x 1.60	2-3/P	99564
		3-4/P	99565

P = Positive Rake
 *bi-metal unique® Technology
 Furnished in welded bands for all widths, or in random coils for 3/4" to 1-1/2" widths.
 Note: Special products on request.

BI-METAL

bi-metal
unique®

POWERBAND M-42



FEATURES

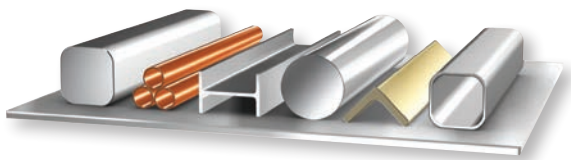
- Strong tooth geometry
- M42 high speed steel teeth combined with a fatigue resistant backing

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.
Inches	mm		
1/2 x .025	13 x 0.65	14/S	99192*
		18/W	99185*
1/2 x .035	13 x 0.90	10/S	99176*
		14/S	99181*
		4-6/S	99195*
3/4 x .035	19 x 0.90	5-8/S	99198*
		14/S	99238*
		3-4/S	99282*
1 x .035	27 x 0.90	4-6/S	99307*
		5-8/S	99297*
		14/S	99109*
		2-3/S	99411
1-1/4 x .042	34 x 1.10	3-4/S	99423
		4-6/S	99430
		5-8/S	99434
1-1/2 x .050	41 x 1.30	3-4/S	99693

S = Straight (Zero) Rake • W = Wavy Set (Zero) rake

*bi-metal unique® Technology

Furnished in welded bands for all widths, or in random coils for 3/4" to 1-1/2" widths.

Note: Special products on request.





BI-METAL

bi-metal
unique®

INTENSSTM 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.
Inches	mm		
1/4 x .025	6 x 0.65	10-14/P	99079
		14-18/W	99080
1/4 x .035	6 x 0.90	10-14/P	99078
		8-12/P	99122
3/8 x .025	10 x 0.65	10-14/P	99124
		14-18/W	99125
1/2 x .025	13 x 0.65	6-10/P	99102
		8-12/P	99165
		10-14/P	99186
		14-18/W	99188

Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
1/2 x .025	13 x 0.65	4/P	99143
		6/P	99151
		6-10/P	99154
1/2 x .035	13 x 0.90	8-12/P	99167
		10-14/P	99178
		4/P	99144

P = Positive Rake • W = Wavy Set (Zero) Rake
 Furnished in welded bands or in 100' (30m) coils.
 All products feature bi-metal® unique technology.
 Note: Special products on request.

PORTABAND

UNIVERZ™



FEATURES

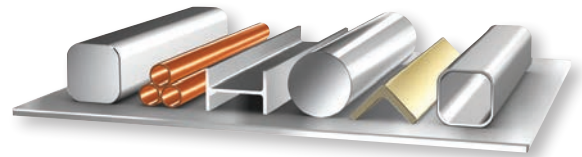
- Split Chip Advantage Technology
- Multiple cutting edges-Multiple Edge Performance
- Blade thickness: 0.020"

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

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



Length		Width x Thickness		Pitch/Rake	Cat. No.	EDP
Inches	cm	Inches	mm			
Univerz - 3 Bands per Sleeve						
44-7/8	114	1/2 x .020	13 x 0.50	10T	BM10	14600
				14T	BM14	14601
				18T	BM18	14602
				24T	BM24	14603
				10-14/S	BM1014	15708
				14-18/S	BM1418	16088
Univerz - 100 per Box						
44-7/8	114	1/2 x .020	13 x 0.50	10T	BM10B	16948
				14T	BM14B	16949
				18T	BM18B	16950
				24T	BM24B	16951
				10-14/S	BM1014B	16952
				14-18/S	BM1418B	16953
Univerz - 3 Bands per Sleeve						
53-3/4	136.5	1/2 x .020	13 x 0.50	10T	RBM10	14604
				14T	RBM14	14605
				18T	RBM18	14606
				24T	RBM24	14607
				10-14/S	RBM1014	15709
				14-18/S	RBM1418	16089
Advanz™ CG - Carbide Grit - 1 per Box						
44-7/8	114	1/2 x .020	13 x 0.50	Continuous	CG4CM	19954
				Gulleted	CG4GM	19956

Length		Width x Thickness		Pitch/Rake	Cat. No.	EDP
Feet	cm	Inches	mm			
Portaband Coil Stock - Univerz						
100	3048	1/2 x .020	13 x 0.50	10-14/S	99187-100	15710
				14-18/S	99180-100	16090
				10T	99171-100	14937
				14T	99179-100	14938
				18T	99182-100	14939
				24T	99184-100	14940

S = Straight (Zero) Rake
 All products feature bi-metal® unique technology.
 Sold in 100' coils.



S = Straight (Zero) Rake • W = Wavy Set, Zero Rake • P = Positive Rake
 All products feature bi-metal® unique technology.

TECHNICAL ASSISTANCE



ON-SITE TECHNICAL SUPPORT

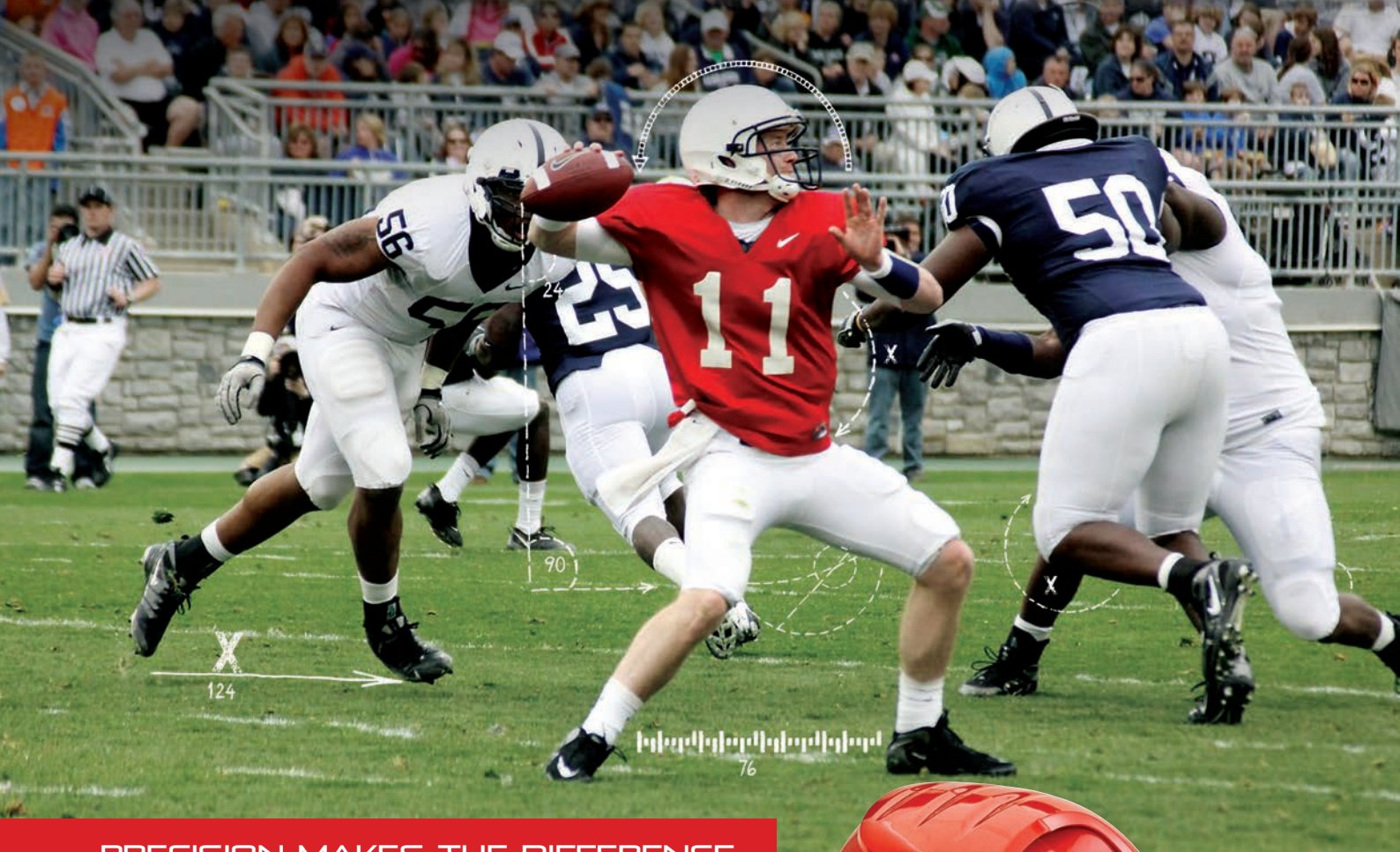
Starrett saw specialists are available to tune up and perform preventative maintenance on your production sawing machine using Starrett Band Saw Blades, at no additional cost.

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.

TRAINING

Starrett saw specialists can also instruct saw operators on achieving the best performance of blade and machine for your applications.

Contact your Starrett Band Saw distributor about arranging a visit to your workplace by a Starrett saw specialist.



PRECISION MAKES THE DIFFERENCE

GOES THE DISTANCE.

Three major product lines to meet our customer's needs with performance and quality.

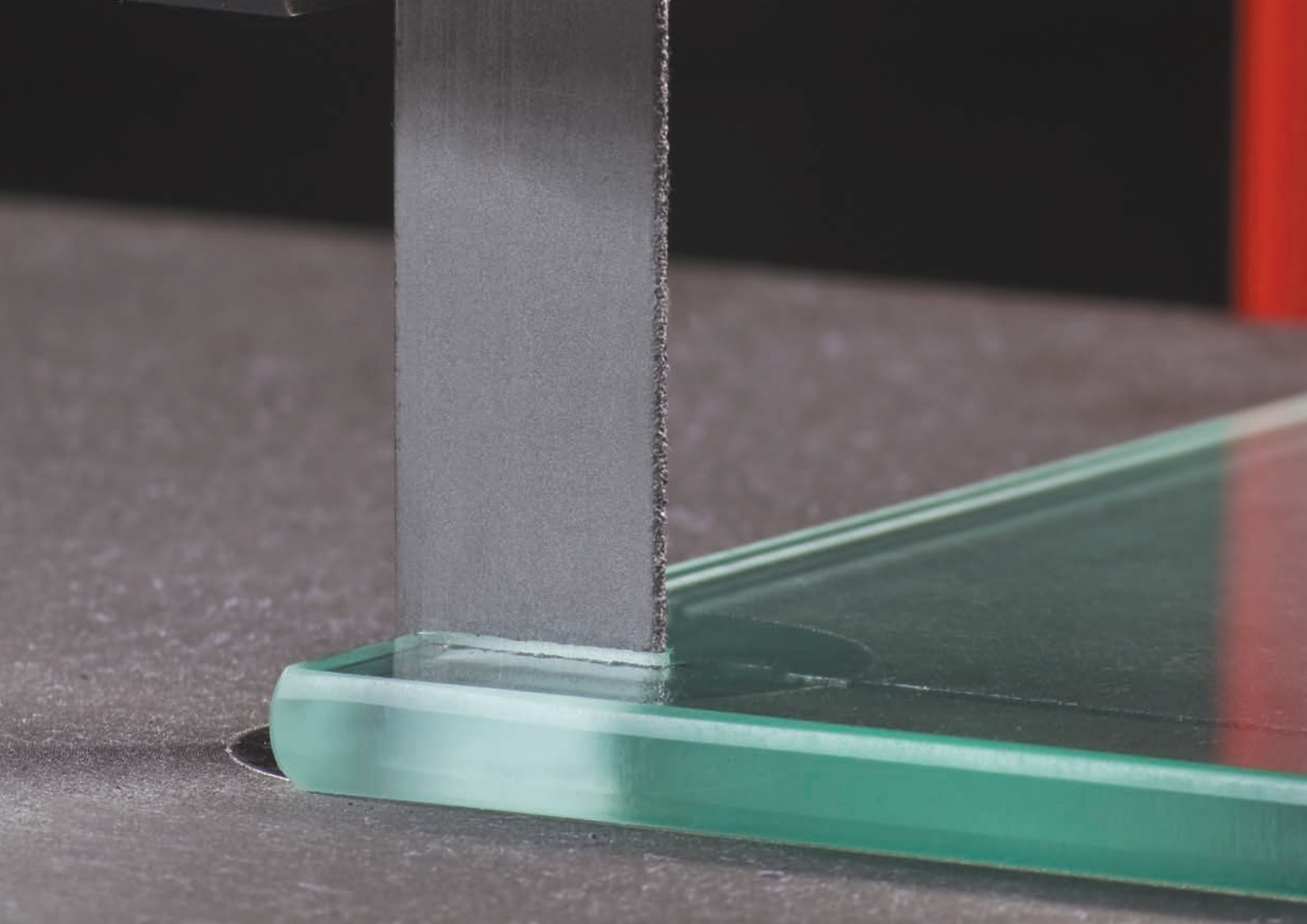


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CARBIDE / DIAMOND GRIT

ADVANZ™ MC7

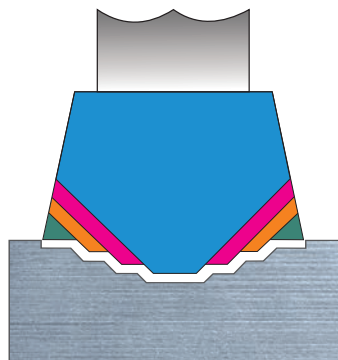


FEATURES

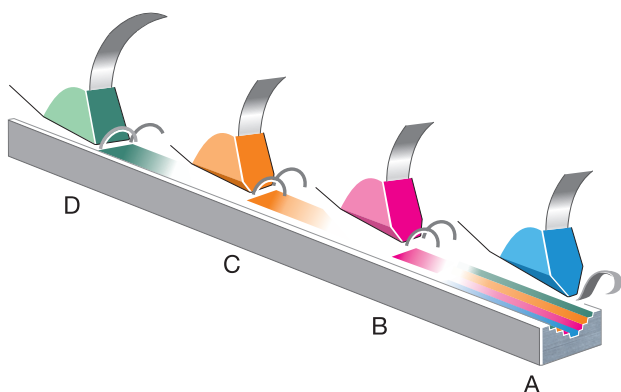
- Exclusive Starrett tooth geometry
- Carbide tipped
- Progressively ground trapezoidal tooth design
- Utilizes a progressive four tooth grind creating seven distinct chips
- Positive rake angle
- Sub micron carbide (HV1600)

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

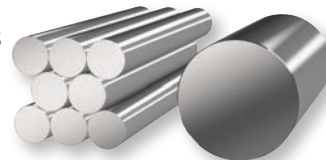


MC7 (Seven Multiple Chips)



APPLICATIONS

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



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

P = Positive Rake
 Furnished in welded bands.
 Note: Special products on request.



CARBIDE

NEW!

ADVANZ™ MC5



FEATURES

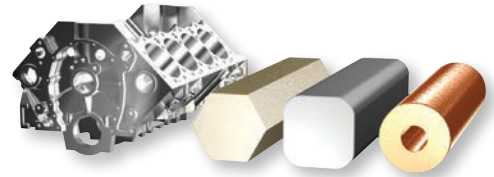
- Exclusive Starrett tooth geometry
- Carbide tipped
- Ground tooth produces 5 chips
- Utilizes a multiple chip grind with a high/low tooth sequence
- Positive rake angle
- Sub micron carbide (HV1600)

BENEFITS

- Ferrous and Non-Ferrous metals and castings
- 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

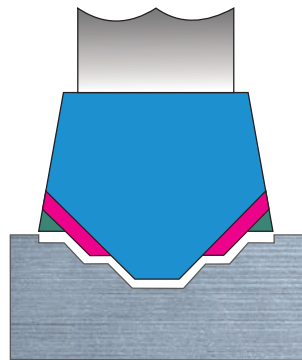
APPLICATIONS

- Low alloy tool steels
- Hot and cold rolled machine steels
- Automotive aluminium casting blocks
- Cast Iron
- Brass
- Bronze
- Copper

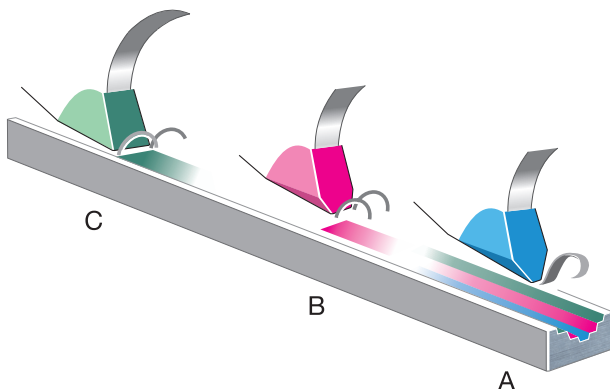


Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
1-1/4 x .042	34 x 1.10	2-3/P	92572
1-1/2 x .050	41 x 1.30	1.4-2/P	92574
		2-3/P	92586
2 x .063	54 x 1.60	1.4-2/P	92577
		2-3/P	92580

P = Positive Rake
Furnished in welded bands.
Note: Special products on request.



MC5 (Five Multiple Chips)



CARBIDE

CARBIDE

ADVANZ™ TS



FEATURES

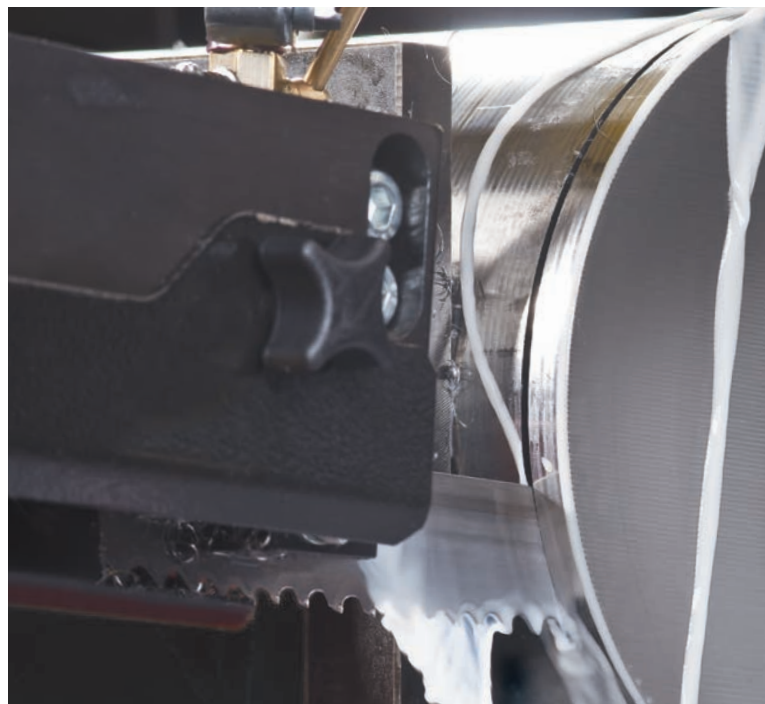
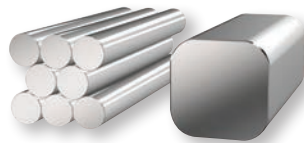
- Carbide tipped teeth
- Triple chip tooth geometry
- Aggressive Rake angle

BENEFITS

- Ideal for cutting hard materials
- Extreme resistance to wear when cutting difficult to machine steels
- Reduced cutting time - Higher productivity
- Precise cuts producing excellent finish

APPLICATIONS

- High-alloy metals
- Aerospace alloys
- Stainless steel
- Nickel alloys
- Hard and abrasive materials
- For machines with hydraulic feed control



Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
3/4 x .035	19 x 0.90	3-4/P	92503
		3/P	92500
1 x .035	27 x 0.90	3-4/P	92509
		3/P	92504
1-1/4 x .042	34 x 1.10	2-3/P	92515
		3-4/P	92517
1-1/4 x .050	34 x 1.30	2-3/P	92522
		3/P	92512
		1/P	92526
		1.4-2/P	92521
1-1/2 x .050	38 x 1.30	2-3/P	92516
		3-4/P	92569
		1/P	92562
		1.3/P	92519

Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
1-1/2 x .050	41 x 1.30	3/P	92524
		1.4-2/P	92559
2 x .063	54 x 1.60	2-3/P	92528
		1/P	92527
		1.3/P	92558
2-5/8 x .063	67 x 1.60	.9-1.1/P	92560
		1.4-2/P	92561
		2-3/P	92530
		.9-1.1/P	92562
3-1/8 x .063	80 x 1.60	1.4-2/P	92563
		2-3/P	92532
		1/P	92531

P = Positive Rake
 Furnished in welded bands.
 Note: Special products on request.

CARBIDE

ADVANZ™ CS



FEATURES

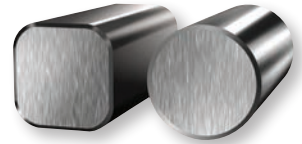
- Carbide tipped teeth
- Triple chip tooth geometry
- Negative Rake angle

BENEFITS

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

APPLICATIONS

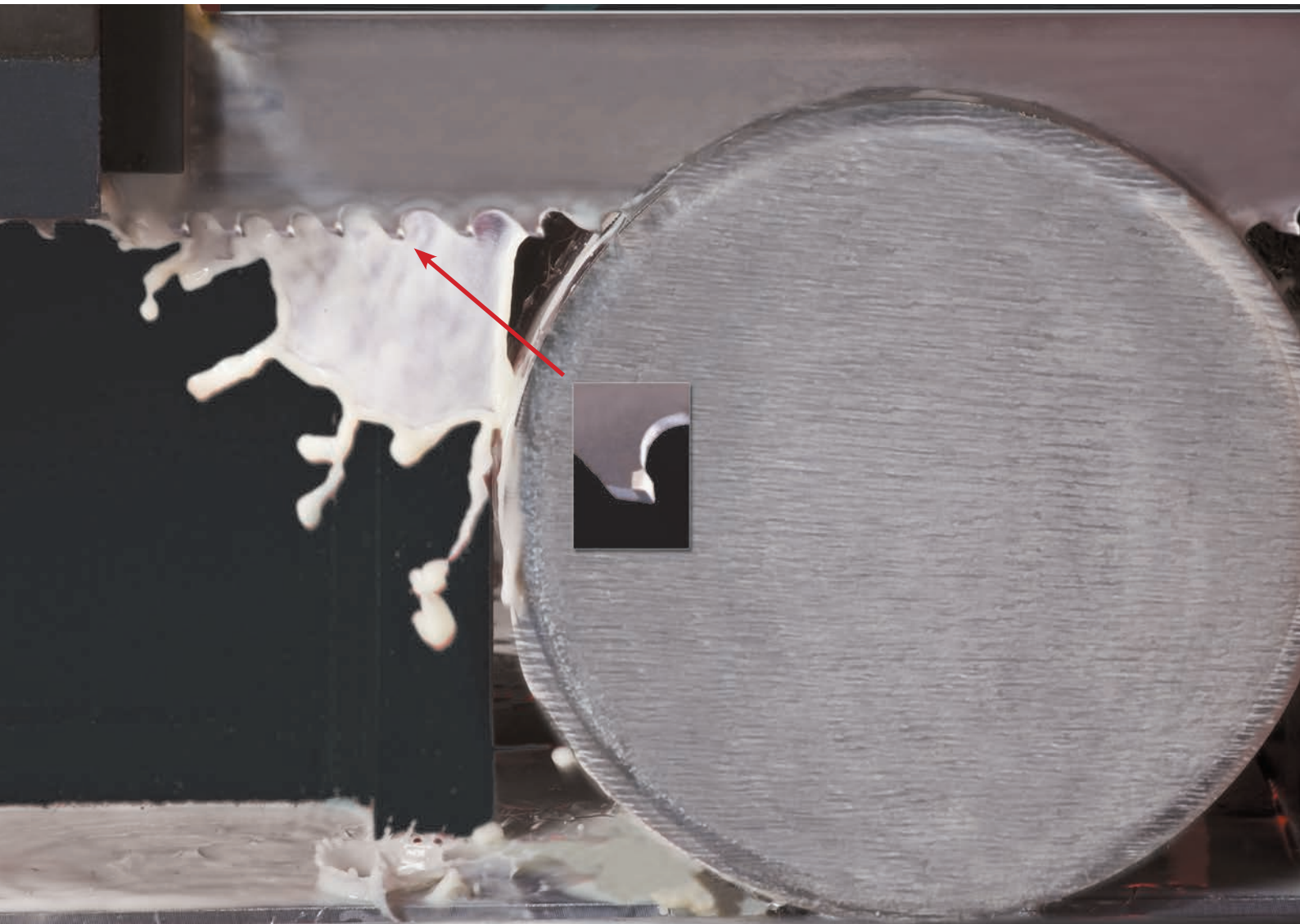
- Case hardened steel
- Steel for shafts and linear guides
- Case hardened materials up to 60 HRC



Width x Thickness

Inches	mm	Pitch/Rake	Material No.
1 x .035	27 x 0.90	3-4/N	92564
1-1/4 x .042	32 x 1.10	3-4/N	92565
1-1/4 x .050	32 x 1.30	3-4/N	92566
1-1/2 x .050	41 x 1.30	2-3/N	92570
		3-4/N	92576

N = Negative Rake
Furnished in welded bands.
Note: Special products on request.





CARBIDE

ADVANZ™ FS



FEATURES

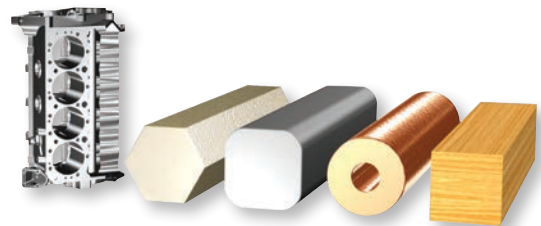
- Carbide tipped teeth
- Triple chip tooth geometry
- Positive Rake angle

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 hard woods such as Tauari and others
- Robust vertical and horizontal machines

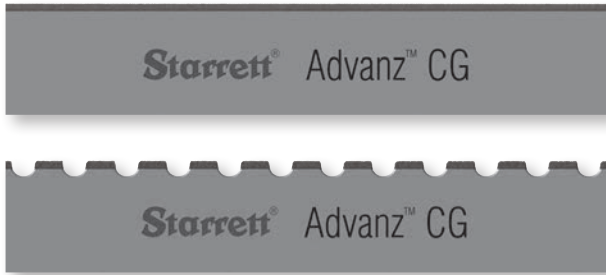


Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
3/4 x .035	19 x 0.90	3/P	92550
1 x .035	27 x 0.90	2-3/P	92507
		3/P	92552
1 x .050	27 x 1.30	2-3/P	92551
		3/P	92553
1-1/4 x .042	34 x 1.10	3/P	92513
1-1/4 x .050	34 x 1.30	3/P	92555
1-1/2 x .050	41 x 1.30	2-3/P	92556

P = Positive Rake
 Furnished in welded bands.
 Note: 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

Width x Thickness		Form	Grit	Material No.
Inches	mm			
1/4 x .020	6 x 0.50	Gullet	Fine	95400
		Gullet	Medium	95401
		Gullet	Medium	95403
3/8 x .025	10 x 0.65	Continuous	Medium	95404
		Gullet	Medium/Coarse	95406
		Gullet	Medium	95412
1/2 x .020	13 x 0.50	Gullet	Medium/Coarse	95413
		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 x .042	25 x 1.10	Gullet	Medium/Coarse	95428
		Gullet	Coarse	95429
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

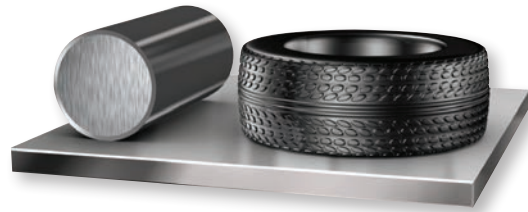
Furnished in welded bands. 100' and 250' coils.
Note: Special products on request.

Length	Width x Thickness		Pitch/Rake	Cat. No.	EDP	
	Inches	cm				Inches
Advanz CG - Portabands						
44-7/8	114	1/2 x .020	13 x 0.50	Continuous	CG4CM	19954
				Gulleted	CG4GM	19956

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

Starrett® Advanz™ DG

FEATURES

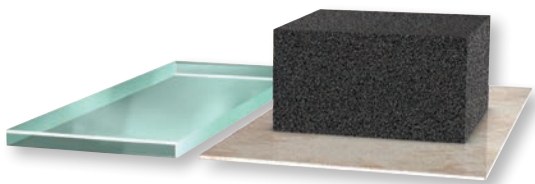
- Cutting edge coated with diamond grains
- Continuous cutting edge
- High strength body

BENEFITS

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

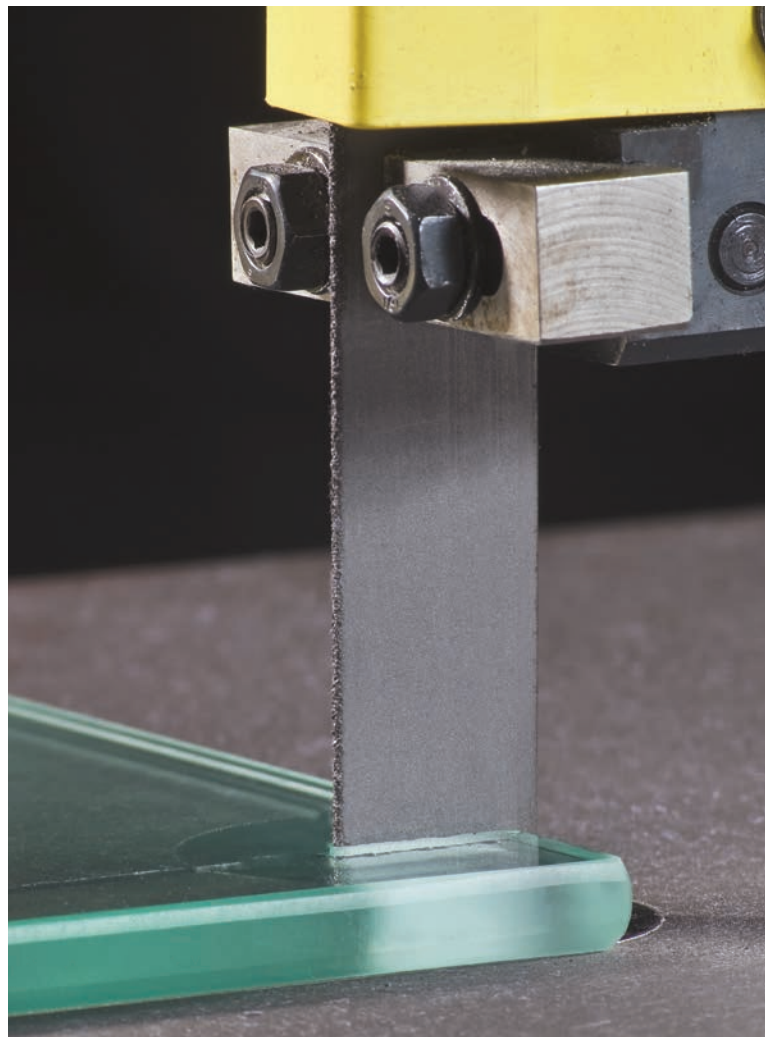
APPLICATIONS

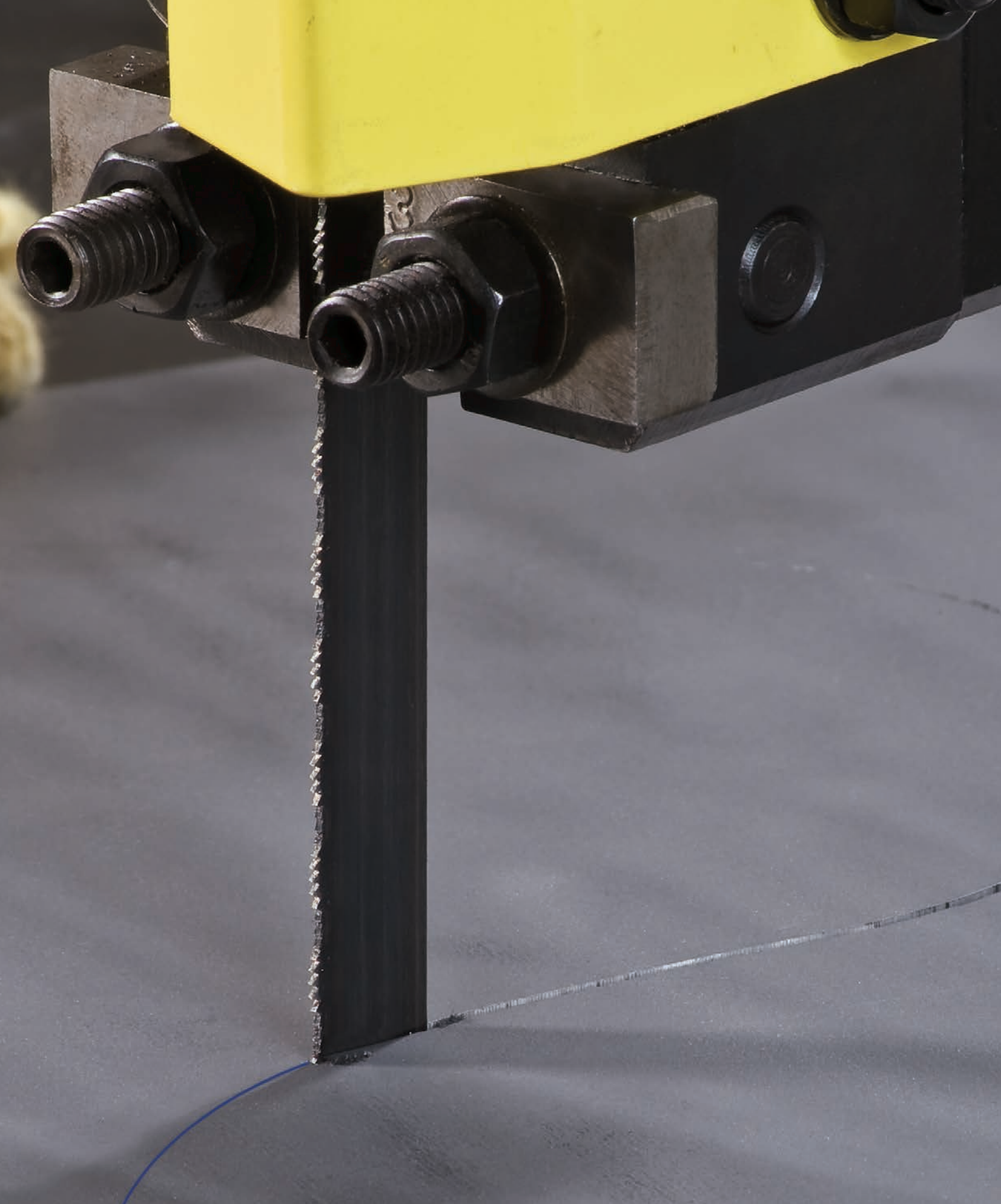
- Glass
- Glazed ceramic
- Silicon
- Graphite
- Fiberglass
- Stones
- Pyrex
- Ideal for machines that have high cutting speed



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

Furnished in welded bands.
Note: Special products on request.





CARBON

NEW! CARBON

DURATEC™ SFB

Starrett® Duratec™ SFB

FEATURES

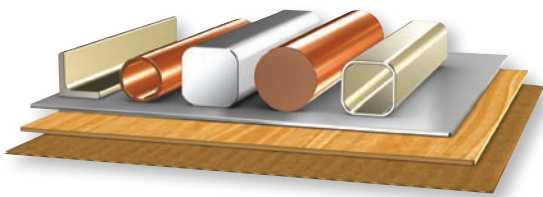
- Made from special high carbon steel
- Flexible back

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		Pitch/Rake	Material No.		
Inches	mm				
1/8 x .025	3 x 0.65	14/S	91050		
		18/S	91060		
3/16 x .014	5 x 0.35	8/S	91083		
		4S/K	91080		
		10/S	91090		
		14/S	91100		
3/16 x .025	5 x 0.65	18/S	91110		
		24/W	91111		
		14/S	91178		
		4/S-K	91120		
1/4 x .014	6 x 0.35	4P/HP	91130		
		6S/K	91140		
		6/S	91151		
		6P/HP	91147		
		8/S	91152		
		10/S	91161		
		14/S	91181		
		18/W	91190		
		24/W	91204		
		32/W	91210		
1/4 x .025	6 x 0.65	3/S	91221		
		3P/LP	91230		
		4S/K	10079		
		4P/HP	91250		
		6S/K	91265		
		6/S	91261		
		6/HP	91264		
		8/S	91271		
		10/S	91281		
		14/S	91291		
3/8 x .025	10 x 0.65	18/W	91300		
		24/W	91307		
		3P/LP	91330		
		4S/K	91340		
		4P/HP	91350		
		6S/K	91372		
		1/2 x .025	13 x 0.65		

Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
1/2 x .025	13 x 0.65	6/S	91361
		6P/HP	91373
		8/S	91374
		10/S	91380
		14/S	91401
		18/W	91420
5/8 x .032	16 x 0.80	24/W	91430
		3S/K	91435
		4S/K	91436
		6S/K	91437
		6/S	91438
3/4 x .032	19 x 0.80	8/S	91440
		10/S	91450
		14/S	91471
		3S/K	91510
		3P/LP	91515
		4S/K	91529
		4/S	91530
		4P/HP	91528
		6/S	91531
		8/S	91550
1 x .035	25 x 0.90	10/S	91570
		14/S	91621
		18/W	91622
		2P/LP	91670
		3S/K	91680
		3P/LP	91689
		4S/K	91695
		4/S	91696
6/S	91701		
1 x .035	25 x 0.90	8/S	91720
		10/S	91730
		14/S	91761

S = Straight (Zero) Rake • W = Wavy Set, Zero Rake
 SK = Skip Tooth • P = HK Tooth
 Furnished in welded bands, 100' (30m) coils or random length.
 Note: Special products on request.



CARBON

DURATEC™ FC

Starrett® Duratec™ FC

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



Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
1 x .035	25 x 0.90	8/S	91726
		10/S	91740

S = Straight (Zero) Rake
Furnished in welded bands and 100' (30m) coils.
Note: Special products on request.

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

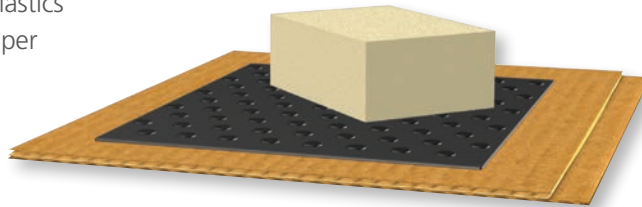
- Quick, smooth and precise cuts, with excellent finishing
- Without material waste

APPLICATIONS

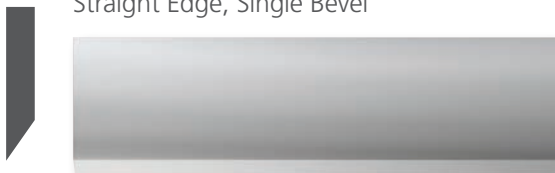
- Foam
- Rubber and soft plastics
- Cardboard and paper
- Cork



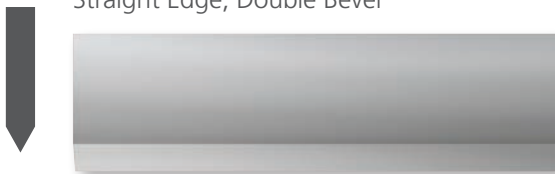
CARBON



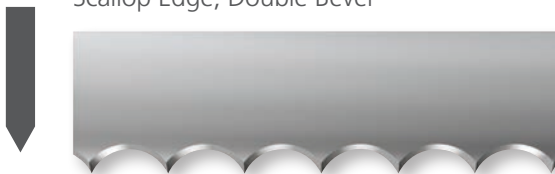
Straight Edge, Single Bevel



Straight Edge, Double Bevel



Scallop Edge, Double Bevel



Wavy Edge, Double Bevel



Width x Thickness		Edge and Bevel	Material No.
Inches	mm		
3/8 x .022	10 x 0.55	Scallop - Double Bevel	93126
		Scallop - Double Bevel	93590
1/2 x .018	13 x 0.46	Scallop - Double Bevel	93188
		Straight - Single Bevel	93135
1/2 x .022	13 x 0.55	Straight - Double Bevel	93160
		Wavy - Double Bevel	93388
		Scallop - Double Bevel	93189
5/8 x .018	16 x 0.46	Scallop - Double Bevel	93580*
		Straight - Double Bevel	93609
		Wavy - Double Bevel	93715
3/4 x .022	19 x 0.55	Scallop - Double Bevel	93637
		Wavy - Double Bevel	93715
		Scallop - Double Bevel	93637
		Scallop - Double Bevel	93637
1 x .025	25 x 0.60	Straight - Double Bevel	93794
		Scallop - Double Bevel	93806
1 x .035	25 x 0.90	Straight - Double Bevel	93796
		Scallop - Double Bevel	93809
		Wavy - Double Bevel	93912

Furnished in welded bands and 100' (30m) coils for 1/4" to 1" widths.

Furnished in welded bands and random coils for 1-1/2" width.

Note: Special products on request.

*Stainless steel blade.



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Model FMS5000

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WOOD CUTTING

WOOD CUTTING

WOODPECKER™ PREMIUM

FEATURES

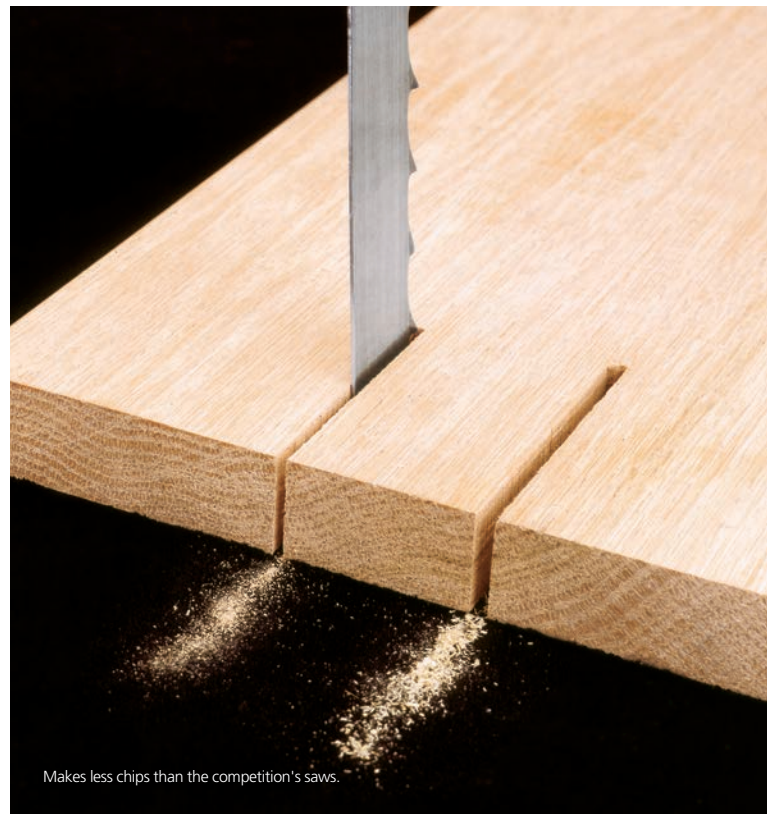
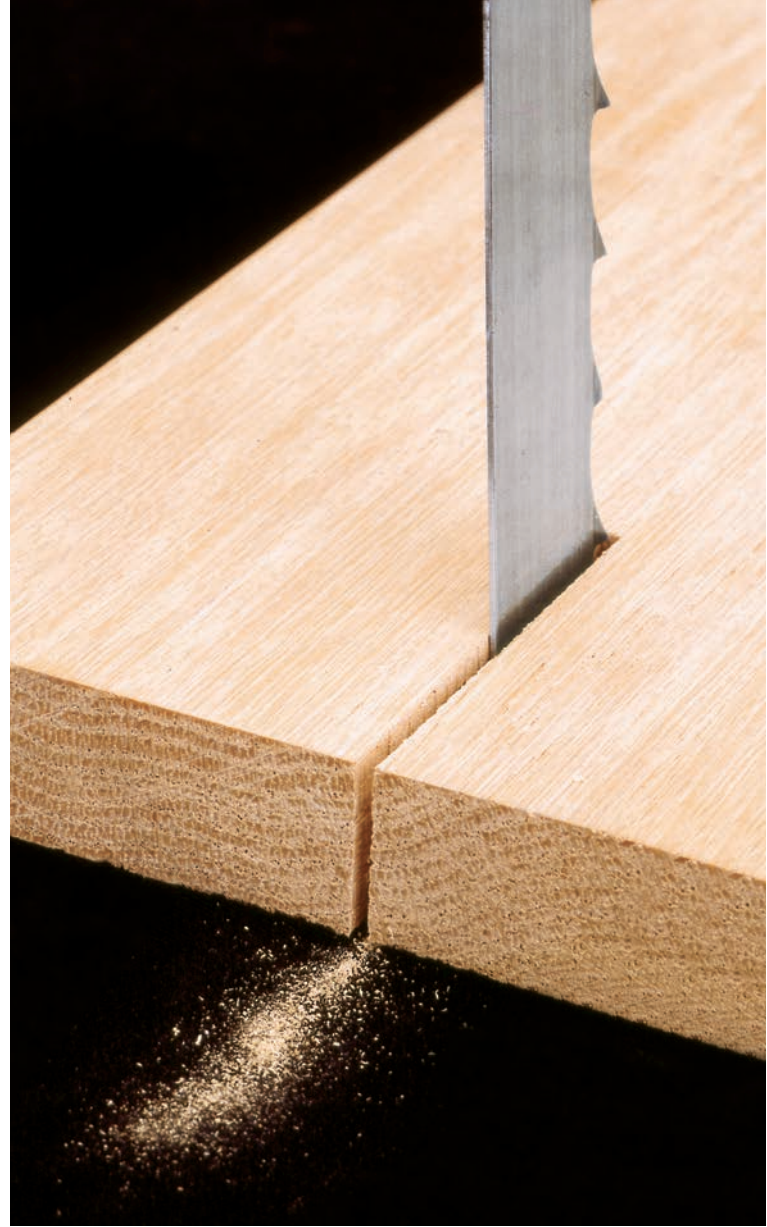
- A selection of blades ideal for a variety of woodworking applications
- Includes blades as thin as .020" for jobs such as contour cutting fine hardwoods to thicker blades for tough tasks including pallet work
- Hardened spring tempered back and ground, precision set teeth with positive tooth angles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

Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
1/4 x .020	6.5 x 0.50	4/P	91991
		6S/K	91992
		3/P	91995
3/8 x .022	10 x 0.55	4/P	91996
		6/P	91997
		3/P	92000
1/2 x .022	13 x 0.55	4/P	92001
		6-P	92002
5/8 x .022	16 x 0.55	3/P	92003
		4/P	92004
3/4 x .028	19 x 0.71	3/P	92007
1 x .023	25 x 0.58	3/P	92010
1 x .035	25 x 0.90	1.3/P	92035
		2/P	92036
1-1/4 x .035	32 x 0.90	1.1/P	92042
		1.3/P	92043
		1.1/P	92017
1-1/4 x .042	32 x 1.10	1.3/P	92018
		Variable 5-8/S	92046
1-1/2 x .042	38 x 1.10	1.1/P	92022
2 x .042	50 x 1.10	1.1/P	92026
2-9/16 x .042	65 x 1.10	1.1/P	92030

P = Positive Rake

K = Skip Tooth

S = Straight (Zero) Rake



Makes less chips than the competition's saws.

WOOD CUTTING

BI-METAL WOODPECKER™ PRO BI-METAL

FEATURES

- Manufactured from high speed steel M42 containing 8% cobalt
- Specifically designed for all types of hard wood
- Electron beam welded bi-metal construction
- Rockwell tooth hardness C67-69 ensures longer blade life

Width x Thickness			
Inches	mm	Pitch/Rake	Material No.
1/4 x .025	6.5 x 0.65	6P/HP	92100
3/8 x .025	10 x 0.90	4/P	92101
1/2 x .025	13 x 0.65	3/P	92102
3/4 x .035	19 x 0.90	3/P	92103
1 x .035	25 x 0.90	2/P	92104
1-1/4 x .035	32 x 0.90	1.1/P	92105
		1.3/P	92106
		5-8/S	92107
1-1/4 x .042	32 x 1.10	1.3/P	92108
		1.1/P	92109
1-1/2 x .050	38 x 1.30	1.1/P	92110
2 x .050	50 x 1.30	1.1/P	92111

P = Positive Rake
HP = High Profile Teeth
S = Straight (Zero) Rake





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FOOD PROCESSING

FOOD PROCESSING

MEATKUTTER™ PREMIUM MKP

SPECIFICATIONS

- Polished high carbon steel
- Hardened, ground teeth
- Hardened back
- Laser-etched blade for easy identification

FEATURES

- Clean and sanitary operation
- Fast, smooth and clean cuts, with less waste
- Accurate cuts with less effort
- Laser-etched blade identification guarantees product quality and satisfaction

MEAT TYPES

- Fresh meat
- Frozen meat
- Poultry
- Fish

APPLICATIONS

- Suitable for butcheries, food industry, slaughterhouses, supermarkets

Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
1/2 x .022	13 x 0.55	3/H	94310
		4/H	94311
		6/K	94312
5/8 x .018	16 x 0.46	4/H	94314
		6/K	94315
5/8 x .022	16 x 0.55	3/H	94316
		4/H	94317
3/4 x .022	19 x .055	3/H	94318
		4/H	94319

H = Hook
 K = Skip
 Furnished with welded, 100' (30m) coils or random coils.

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
- Laser-etched blade for easy identification

FEATURES

- Rust-proof
- Fast, smooth and clean cuts, with less waste
- Laser-etched blade identification guarantees product quality and satisfaction

MEAT TYPES

- Bone-in or boneless, thawed or frozen
- Poultry
- Fish

APPLICATIONS

- Suitable for butcheries, food industry, slaughterhouses, supermarkets

Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
5/8 x .018	16 x 0.46	4/H	94321
		6/K	94322

H = Hook
K = Skip

Furnished with welded, 100' (30m) coils or random coils.

Starrett Meatkutter™ 5/8 x .018" X6 OP21221688
Stainless Steel 16 x 0.46mm

FOOD PROCESSING

CARCASSKUTTER™ PREMIUM CKP

SPECIFICATIONS

- Polished high carbon steel
- Hardened, ground teeth
- Hardened back
- Laser-etched blade for easy identification

FEATURES

- Fast, smooth and clean cuts with less waste
- Accurate cuts with less effort
- Laser-etched blade identification guarantees product quality and satisfaction

CARCASS TYPES

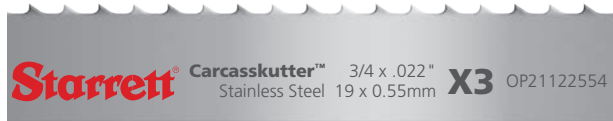
- Animal carcass cuts
- Cattle
- Pigs
- Goats

APPLICATIONS

- Suitable for frozen meat and slaughter houses
- Cold storage facilities
- Meat packing and processing plants

Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
3/4 x .022	19 x 0.55	3/H	94370
		4/H	94371

H = Hook
Furnished welded Individually wrapped or random coils.





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 below)

FEATURES

- Minimal meat residue guaranteeing clean and sanitary operation
- Fast, smooth and clean cuts, with less food loss in comparison to conventional blades
- Excellent cutting precision

MEAT TYPES

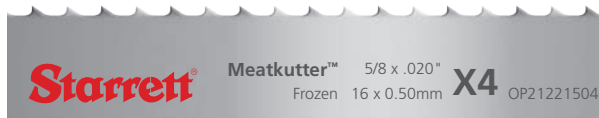
- Fish
- Frozen meat up to -4°F (-20° C)

APPLICATIONS

- Meat packing industries

Width x Thickness		Pitch/Rake	Material No.
Inches	mm		
5/8 x .014	16 x 0.35	3/H	94360
5/8 x .020	16 x 0.50	3/H	94361
		4/H	94362
3/4 x .022	19 x 0.55	3/H	94363
1 x .023	27 x 0.60	3/H	94364
1-1/4 x .032	34 x 0.80	2/H	94365
2 x .035	50 x 0.90	1.3/H	94366

H = Hook
Welded blade, 100' (30m), Random length coil



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			
Inches	mm	Pitch/Rake	Material No.
1-1/4 x .035	34 x 0.90	3/H/H	94380

H = Hook
Furnished welded or random coils.





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)	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)	
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.	Length x Width x Thickness	TPI (TP/25mm)	Pinhole Diameter	EDP
BS1210-5	12" x 1-1/8" x .050"	10		40097
BS1214-5	300mm x 28mm x 1.25mm	14		40098
BS1410-5	14" x 1-1/8" x .050"	10	8.5mm	40099
BS1414-5	350mm x 28mm x 1.25mm	14		40100
BS1406-6	14" x 1-3/8" x .062"	6		40101
BS1410-6	350mm x 35mm x 1.6mm	10		40102
BS1406-7	14" x 1-5/8" x .075"	6	10.75mm	40105
BS1706-6	17" x 1-3/8" x .062"	6	8.5mm	40113
BS1710-6	425mm x 35mm x 1.6mm	10		40114
BS1806-6	18" x 1-3/8" x .062"	6		40115
BS1810-6	450mm x 35mm x 1.6mm	10		40116
BS1804-7	18" x 1-5/8" x .075"	4		40118
BS1806-7	450mm x 41mm x 2mm	6	10.75mm	40119
BS1804-8	18" x 1-7/8" x .088"	4		40121
BS1806-8	450mm x 47mm x 2.25mm	6		40122
BS2104-8	21" x 1-7/8" x .088"	4		40126
BS2106-8	525mm x 47mm x 2.25mm	6		40127
BS2403-0	24" x 2-1/8" x .100"	3	16.75mm	40131
BS2404-0	600mm x 54mm x 2.5mm	4		40132

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 envelope.

POWER HACKSAWS

HIGH SPEED STEEL-RS

HIGH SPEED STEEL

FEATURES

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

APPLICATIONS

- Ideal for cutting a wide range of materials

BENEFITS

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



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)	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)	
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.	Length x Width x Thickness	TPI (TP/25mm)	Pinhole Diameter	EDP
RS1210-5	12" x 1" x .050"	10		40046
RS1214-5	300mm x 25mm x 1.25mm	14		40047
RS1410-5	14" x 1" x .050"	10		40049
RS1414-5	350mm x 25mm x 1.25mm	14		40050
RS1406-6	14" x 1-1/4" x .062"	6	8.5mm	40051
RS1410-6	350mm x 32mm x 1.6mm	10		40052
RS1606-6	16" x 1-1/4" x .062"	6		40057
RS1610-6	400mm x 32mm x 1.25mm	10		40058
RS1706-6	17" x 1-1/4" x .062"	6		40062
RS1710-6	425mm x 32mm x 1.6mm	10		40063
RS1806-6	18" x 1-1/4" x .062"	6		40064
RS1810-6	450mm x 32mm x 1.6mm	10		40065
RS1804-7	18" x 1-1/2" x .075"	4	10.75mm	40067
RS1806-7	450mm x 38mm x 2mm	6		40068
RS1804-8	18" x 1-3/4" x .088"	4		40070
RS1806-8	450mm x 45mm x 2.25mm	6		40071
RS2104-8	21" x 1-3/4" x .088"	4		40075
RS2106-8	450mm x 45mm x 2.25mm	6		40076
RS2404-0	24" x 2" x .100" 600mm x 50mm x 2.5mm	4	11.25mm	40081
RS3004-0	30" x 2-1/2" x .100" 750mm x 63mm x 2.5mm	4	16.75mm	40083

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 envelope.

Cat. No.	Length x Width x Thickness	TPI (TP/25mm)	Pinhole Diameter	EDP
Metric High Speed Steel Power Hacksaw Blades (for KASTO and other metric machines)				
RS300-6	12" x 1-1/4" x .075"	6		16168
RS300-10	300mm x 32mm x 2mm	10		16169
RS350-6	14" x 1-1/4" x .075"	6		40177
RS350-10	50mm x 32mm x 2mm	10		40178
RS400-4		4	8.5mm	40179
RS400-6	16" x 1-1/4" x .075" 400mm x 32mm x 2mm	6		40180
RS400-10		10		40181
RS450-4		4		40182
RS450-6	18" x 1-1/2" x .075" 450mm x 38mm x 2mm	6		40183
RS450-10		10		40184
RS500-4		4		16170
RS500-6	20" x 1-3/4" x .075" 500mm x 45mm x 2mm	6		16171
RS500-10		10		16172
RS550-4		4		40173
RS550-6	22" x 1-3/4" x .075" 550mm x 45mm x 2mm	6		40174
RS550-10		10		40185
RS575-4	23" x 2" x .100"	4	10.5mm	40175
RS575-6	575mm x 50mm x 2.5mm	6		40176
RS600-4	24" x 2" x .100" 600mm x 50mm x 2.5mm	4		16173
RS600-6		6		16174
RS650-4	26" x 2-3/16" x .100"	4		40186
RS650-6	650mm x 55mm x 2.5mm	6		40187
RS700-4	28" x 2-3/16" x .100"	4		40188
RS700-6	700mm x 55mm x 2.5mm	6		40189
RS850-4	34" x 2-3/8" x .118"	4		16175
RS850-6	850mm x 60mm x 3mm	6		16176
RS900-2 1/2	36" x 4-1/2" x .138" 900mm x 114mm x 3.5mm	2-1/2 TPI	12.5mm	68716
RS1000-2 1/2	40" x 5" x .138" 1000mm x 126mm x 3.5mm			16177

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 envelope.

RECOMMENDATIONS

BLADE BREAK-IN

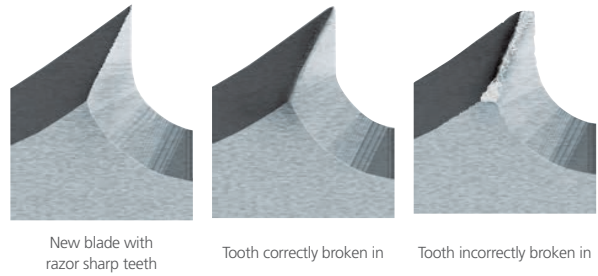
Using the right break-in procedures for a bi-metal blade ensures longer blade life, faster cuts for a longer period of time and consistent performance. Conversely, blade life can be significantly compromised if the proper break-in procedures are not followed.

Softer material such as carbon steel and aluminum:

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

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

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



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

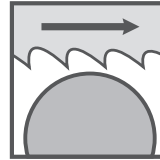
INSTALLATION GUIDELINES

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.

- 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



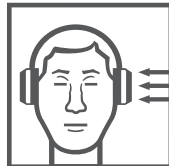
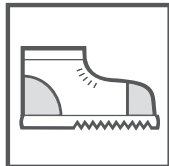
- Wear gloves when handling band saw blade



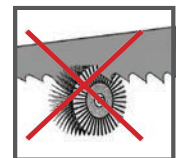
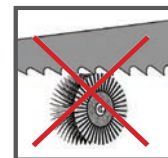
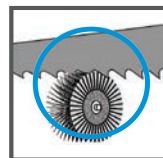
- Apply appropriate tension to the blade
- Be aware of pinch points and keep hands and clothing clear of rotating blade



- Use eye protection, safety shoes, and hearing protection



- 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



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

- 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

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. 57793Z

- 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.

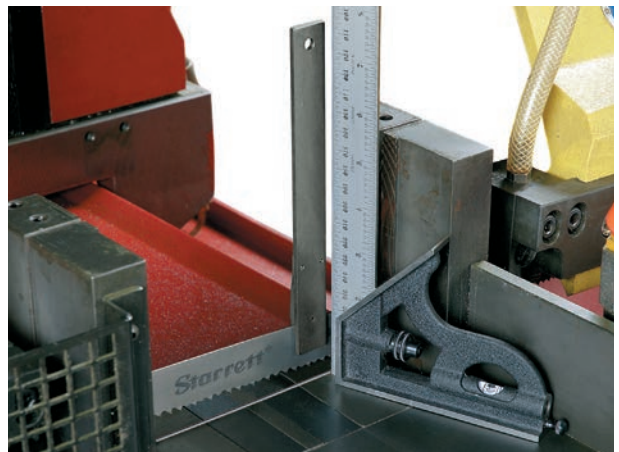
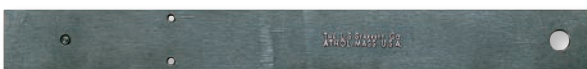


SAW TENSION GAGE FOR BAND SAW BLADES No. 682EMZ

- 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. PT9292S

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 SOFTWARE

STARRETT.COM/POWERCALC

PowerCalc helps users choose the right Starrett band saw blade for their application. The PowerCalc software is a free web-based application and available 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
- Tradeshows and Events

STARRETT LITERATURE AT YOUR FINGERTIPS

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Material Test

Jobsite & Workshop Tools

Laser Measurement

Metrology Equipment

Precision Granite

Precision Ground Solutions

Precision Measuring Tools

PTA & Hand Tools

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Service

Webber Gage Blocks

BAND SAW BLADES



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Phone: (978) 249-3551 | Fax: (978) 249-8495
121 Crescent Street-Athol, MA 01331-1915-USA