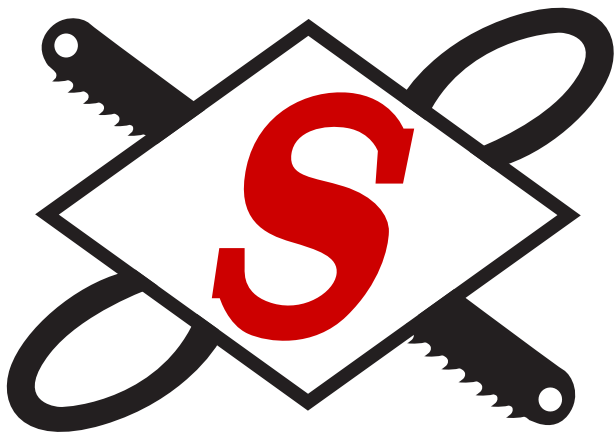
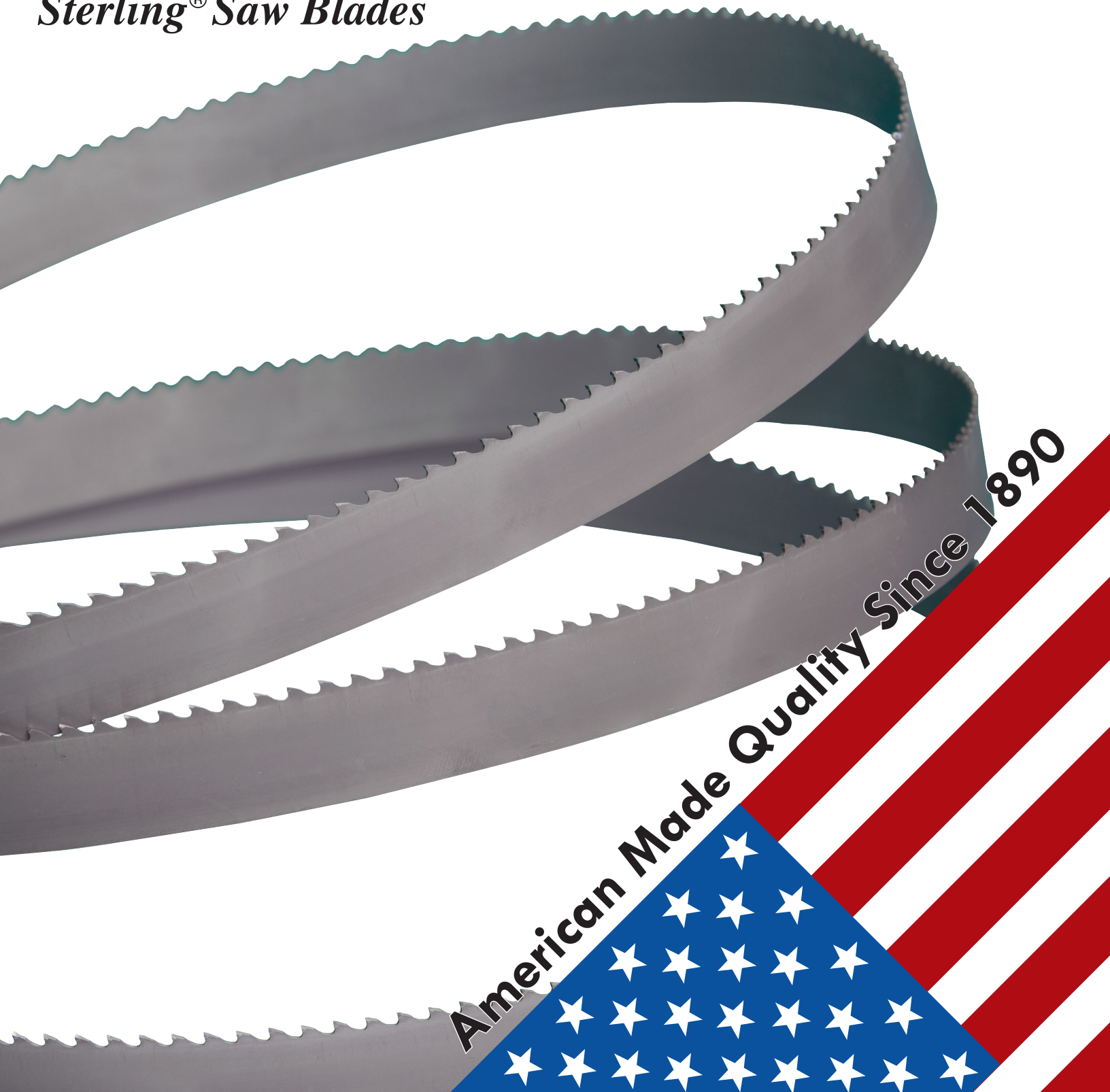


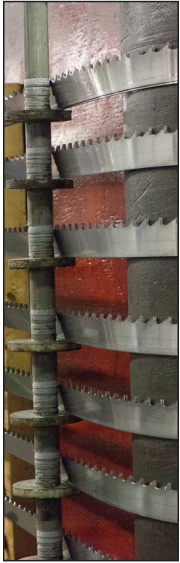
2017



Sterling[®] Saw Blades



American Made Quality Since 1890



History

John T. Ronan, a practicing engineer, moved to Buffalo N.Y. during its era of expansion and prosperity. In 1890, He became partners with Joseph Campbell and established Diamond Saw and Stamping Works and incorporated it in 1903. It produced various metal products for industry, and generally specialized in the manufacture of hack sawing machines and blades. John T. Ronan eventually bought all of the company stock and adopted the Sterling® brand. The company continued to prosper for many years. However, in the 1930's the business fell on difficult times with the rest of the country. John's son's, George and Learned, bought the assets of the company and nursed it back to health. It remained a privately held business, now known as Diamond Saw Works, Inc.

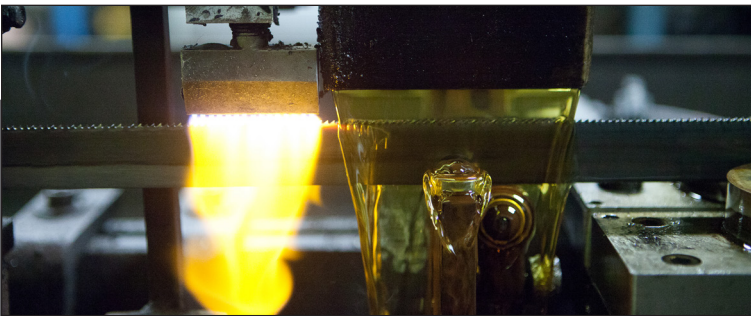
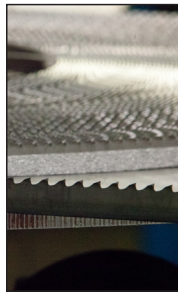
Again the company prospered, now specializing in the manufacture of metal cutting blades exclusively. The company efforts were directed toward updating manufacturing equipment, improving products, and expanding the sales force throughout the U.S. and branching out with sales agents in Canada and Europe. It was during this period, in 1937, that the broach tooth, the first variable pitch tooth design, was developed and patented by Diamond Saw and applied to power and hand hacksaws.

In 1955 – 1956 the decision was made to build a new high efficiency, 20,000 sq. ft., manufacturing facility in Chaffee, N.Y. Additions to the building now have Diamond Saw Works at 50,000 sq. ft. Learned Ronan's son's, L. Don, Thomas, Michael and William, began taking over the day to day operations from their Dad who retired in 1980.

In 1990, Diamond Saw Works decided to make all employees, owners through a leveraged Employee Stock Ownership Plan, (ESOP). Within seven years of it's inception, all the employees owned one – third of the company through the ESOP Plan. Currently the Employee Owners own 60%, with the eventual goal of owning 100%.

Today Diamond Saw Works is an industrial supplier of high quality metal and wood cutting saw blades. Band saw blades account for 85% of our business and manufacturing effort. Our world headquarters and sole manufacturing facility is located in Chaffee, N.Y. Our owner employees take pride in their work with customers, suppliers, fellow owners, and the community. For over 125 years the Sterling® name has stood for quality, durability, and reliability. Yesterday, today and tomorrow, Sterling® stands the test of time.

— Jim Ziemer – President of Sterling® Saw Blades



Safety Warning

Sterling® Saw Blade products are engineered and manufactured with safety in mind. All of the products manufactured by Sterling® Saw Blades are designed to perform without any undue safety issues when caution, common sense and proper safety practices are followed. The use of these tools is safe when proper application and protection guidelines are observed. Even when these proper precautions are taken, it is possible that fragments of a cutting tool, cutting material, or holding device may be thrown at a very high rate of speed and have potential to cause severe bodily harm. It is imperative that general safety precautions and safety glasses be used at all times.

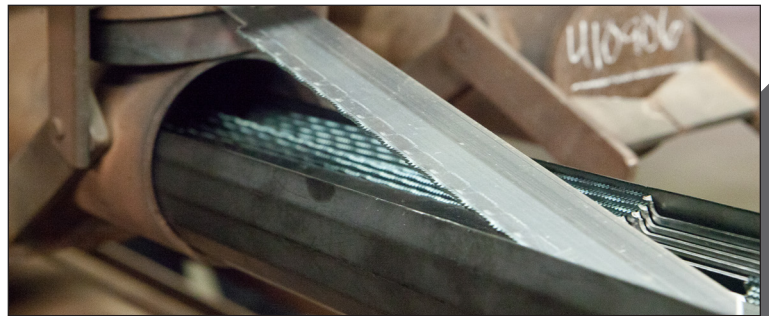
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Band Saw Blade Ordering Instructions

When ordering band saw blades and coil stock, please include the following information:

- Quantity
- Item number
- Coil or blade length (feet & inches)
- Blade width (note Timber Master TK™, Pallet Reclaim and Bi-Metal bandsaw widths 1" and above are over-width)
- Teeth per inch/grit
- Set (Raker, Wavy, E.T.S.)
- Style (Skip, Hook, Constant, Broach and Posi tooth)
- Blade Type (specific brand name)

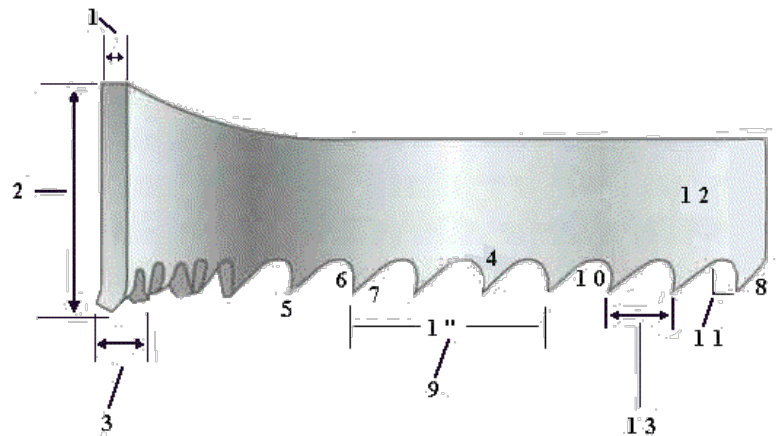
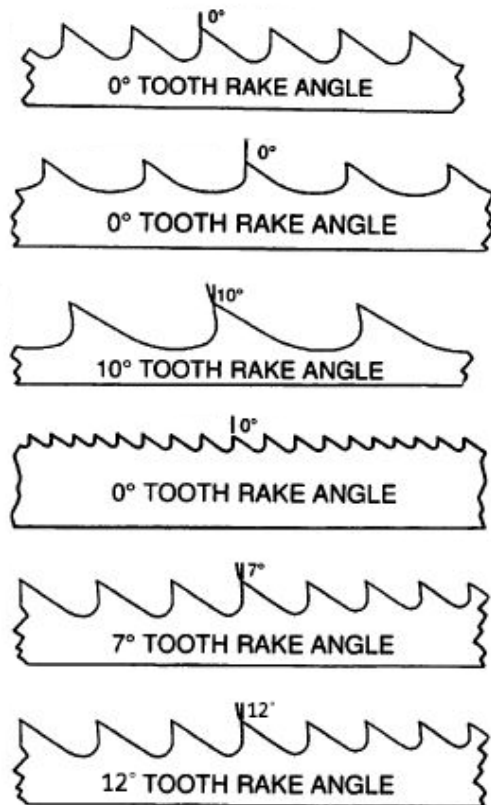


Guaranteed Trial Order Program

Diamond Saw Works offers a Guaranteed Trial Order Program on all Sterling® band saw blade products. Upon review and approval of consumer applications we will provide a product on a paid trial basis. The purpose of this program is to allow all consumers the opportunity to try our products risk-free. Contact your local Sterling® representative with your application information so we may provide you with the right blade that will meet your performance expectations.



Band Saw Blade Basics



1. **Gage** - The thickness of the blade.
2. **Blade Width** - The distance from the tip of the tooth to the back edge of the blade.
3. **Set** - The bending of teeth right or left to allow clearance of the back through the cut.
4. **Tooth Back** - The surface of the tooth opposite the tooth face.
5. **Tooth Tip** - The cutting edge of the tooth.
6. **Tooth Face** - The surface of the tooth on which the chip is formed.
7. **Tooth** - The cutting portion of the saw blade.
8. **Tooth Rake Angle** - The angle of the tooth face measured to a line perpendicular to the cutting direction of the saw.
9. **T.P.I.** - The number of teeth per inch.
10. **Gullet** - The curved area at the base of the tooth .
11. **Gullet Depth** - The distance from the tooth tip to the bottom of the gullet.
12. **Blade Back** - The body of the blade not including the tooth portion.
13. **Tooth Pitch** - The distance from the tip of one tooth to the tip of the next tooth.

Constant Pitch: Fixed teeth per inch. Contour or cut-off work. For ferrous, non-ferrous materials.

Skip Tooth: Greater gullet capacity than constant pitch. Better chip clearance. For softer wood, plastics, other materials.

Hook Tooth: Greater gullet capacity than constant pitch. Requires less feed pressure than skip tooth. 10° rake angle bites into material better.

Broach Tooth: Varied tooth pitch. Improved blade life. Less vibration noise than constant pitch. Use for interrupted cuts, tubing and shapes.

Posi Tooth: Varied tooth pitch. 7, 10 and 12 forward rake angle. Requires less feed pressure for longer life. Excellent for sawing solids.

Raker Set: Pattern is one tooth left, one tooth right and third tooth unset. Allows for fast efficient cutting on both solids and thicker sections.

Wavy Set: Groups of teeth alternately set to left and then to right, forming a wave pattern. Excellent for thin or interrupted sections to help reduce tooth breakage or stripping.

E.T.S.: Every tooth is set alternately left then right, no raker tooth. For woodworking or non-ferrous metals.

Pitch

Cross Section Thickness to Be Cut	Variable Pitch
7/32 - 7/8"	18/14
1/4 - 1-1/4"	14/10
11/32 - 1-1/2"	12/8
3/8 - 2"	10/6
1/2 - 2-3/8"	8/5
1 - 3"	6/4
1-1/2" - 4"	4/3
2 - 6"	3/2
3 - 12"	2/1.4
8"	1/8

Cross Section Thickness to Be Cut	Constant Pitch
5/32 - 1/2"	24
7/32 - 5/8"	18
1/4" - 7/8"	14
3/8 - 1-1/4"	10
1/2 - 1-1/2"	8
1 - 2"	6
1-1/2 - 3"	4
2 - 4"	3
3 - 6"	2
4-1/2 - 9"	2/1.4

Blade Type

	Carbon steels	"Structural Steel"	"Aluminum & light alloy steels"	"Alloy steels Mold steels"	Tool steels	Stainless steels	Nickel base	Titanium alloys
AISI	1010, 1020, 1045	A36	6061, 2011, 2024, 5052	4140, P20	A2, H13, S7	316, 304, 17-4 PH, 15-5 PH	Inconel, monel, waspalloy	Ti-6Al-4V
JIS	S20C, S45C		6061, 2011, 2024, 5052	SCM 440(H), SCM 445 (H)	SHD11, SHD12, SKD61, SKS41	SUS316, SUS304	NCuP-0	H4650, H4600
DIN	CK45, C16.8		AlCuPe, AlCuMg2, AlMgMn0.3	41CrMo4	X155CrVMoV51, (G)X40CrMoV51	X5CrNiMo18 10, X5CrNi18 10	NiCr19NaMo, NiCr19Co14Mo4Ti	

Super Weld

Excel

Kerf Plus

NXT-CT or Mach 12

Production Cutting Band Saws



Width	Thickness	Style	1/.8	1.7/1	2/1.4	3	3/2	4	4/3
1/2"	0.025	Set				943059			
		Triple Chip						943060	
3/4"	0.035	Set				943076			
		Triple Chip				943075			
		Heavy Set				943080			
	0.042	Triple Chip				943085			
1"	0.035	Set				943096			
		Triple Chip				943095			943105
		Negative							943106
	0.042	Triple Chip				943108			
1-1/4"	0.042	Triple Chip		943121	943122	943116	943123		943127
		Negative							943128
1-1/2"	0.050	Triple Chip		943133	943134		943143		943147
		Negative					943144		
2"	0.063	Triple Chip		943172	943175		943180		943185
		Special			943176				
2-5/8"	0.063	Triple Chip		943213	943215		943214		
3"	0.063	Triple Chip	943217		943219				



Features & Benefits

- Newest grade of carbide for higher cutting speed, longer blade life, and high heat and abrasion resistance
- Unique ground tooth form improves cutting accuracy and offers a high quality, smoother finish
- Improved, tempered steel backer offers greater beam strength and extended blade fatigue life
- Available in coils and welded to length

Applications

- Triple chip pattern for difficult machining materials
- Set tooth for aluminum castings and foundry applications

NXT-CT™
Carbide Tipped

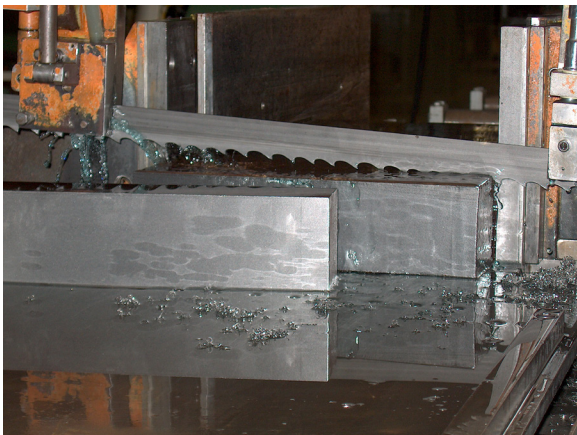
Width	Thickness	Set	Style	1	1/.8	1.5/1	2/1.4	3	3/2	4/3	6/4	8/5	10/6	12/8	14/10
3/4"	0.035	Raker	Broach								925002	925003	925006	925007	925008
1"	0.035	Raker	Hook					924997							
			Broach								925017	925022	925025		
			Posi						925010	925013	925015	925020			
1-1/4"	0.042	Raker	Hook	925310				925028							
			Posi						925035	925037	925040	925045			
1-1/2"	0.050	Raker	Hook	925320											
			Posi			925053	925054		925055	925057	925060				
			Broach									925061			
2"	0.050	Raker	Hook	925329											
			Posi						925066	925068	925069				
	0.063	Raker	Hook	925330											
			Posi			925086	925085		925087	925088	925089				
		Broach									925090				
2-5/8"	0.063	Raker	Posi		925096	925098	925097		925099	925102	925095				
3"	0.063	Raker	Posi		925100										

Features & Benefits

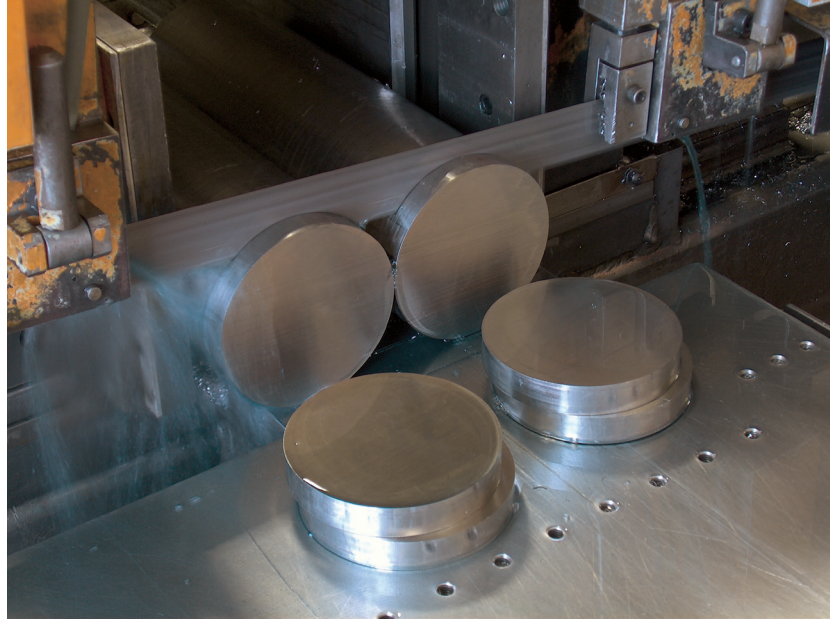
- High tooth hardness Rc 68-69
- 8% cobalt M42 tool steel cutting edge
- Cuts high alloy, heat treated and stainless steels
- Available in broach, posi and hook tooth designs. • Available in coils (150' or 250') and welded to length

Applications

- Production cutting
- Stainless steels
- Carbon steels
- Hardened materials
- Solid rods
- Medium to heavy production machines



Production Cutting Band Saws



Width	Thickness	Set	Style	3/2	4/3	6/4
1-1/4"	0.042	Raker	Posi	927216	927218	927220
1-1/2"	0.050	Raker	Posi	927238	927243	927245
2"	0.063	Raker	Posi	927254	927258	

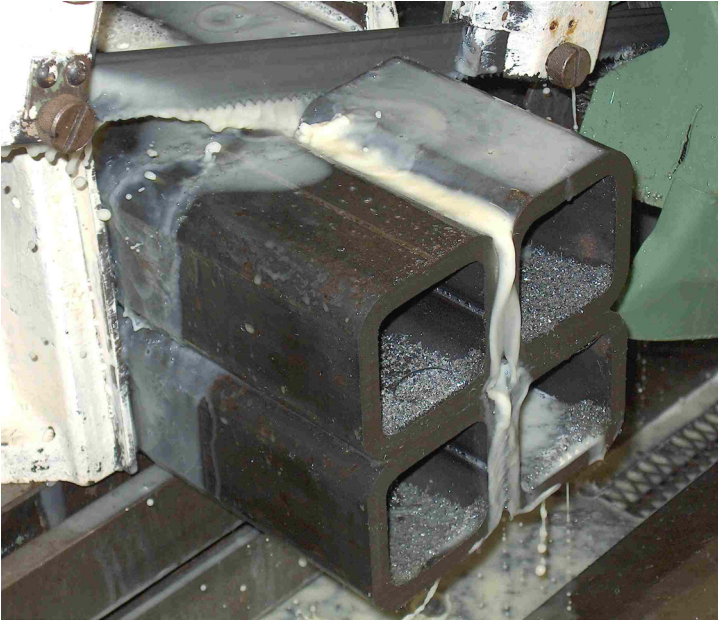
Features & Benefits

- Tooth hardness Rc 68-69
- 10% cobalt edge
- High chrome backer for maximum tool life
- Excellent heat and abrasion resistance
- 12 degree positive rake varied pitch tooth design
- Available in coils (150' or 250') and welded to length

Applications

- Solid or thick walled materials
- Exotic metals
- Super alloys
- Space age materials

Mach 12™
Bi-Metal M51



Width	Thickness	Set	Style	4/3	6/4
1"	0.035	Raker	Posi	925710	925715
1-1/4"	0.042	Raker	Posi	925720	925725
1-1/2"	0.050	Raker	Posi	925730	925735
2"	0.063	Raker	Posi	925740	

Features & Benefits

- Tooth hardness Rc 68-69
- 8% cobalt M42 tool steel cutting edge
- Modified tooth profile and set resists strippage and provides better finish
- Reduces vibration and chatter
- Available in coils (150' or 250') and welded to length

Applications

- Mild steel, alloys and stainless steel shapes
- Chanel
- I beams
- Angles
- Tubing
- Interrupted cuts
- Bundle cutting



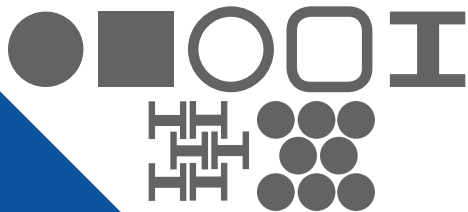
Cut Master™ Bi-Metal M42

Production Cutting Band Saws



Width	Thickness	Set	Style	3/2	4/3	6/4
1"	0.035	Raker	Posi			920205
1-1/4"	0.042	Raker	Posi		920220	920221
			Posi		920222*	
1-1/2"	0.050	Raker	Posi	920228*	920230	920231
			Posi		920232*	
2"	0.063	Raker	Posi	920237*	920240	
			Posi		920242*	
			Broach			920241
2-5/8"	0.063	Raker	Posi	920250*	920252*	

*10° face angle



Features & Benefits

- Tooth hardness Rc 68-69
- 8% cobalt M42 tool steel cutting edge
- Wide kerf - heavy set
- 10 degree face angle
- Available in coils (150' or 250') and welded to length

Applications

- Channel, H beams, I beams, angles, pipe and tubing
- Production cutting of profiles and structural shapes that tend to bind in the cutting process
- Production bundle cutting of profiles and structural shapes, ferrous and non ferrous materials
- Interrupted cuts

Kerf Plus™
Bi-Metal M42

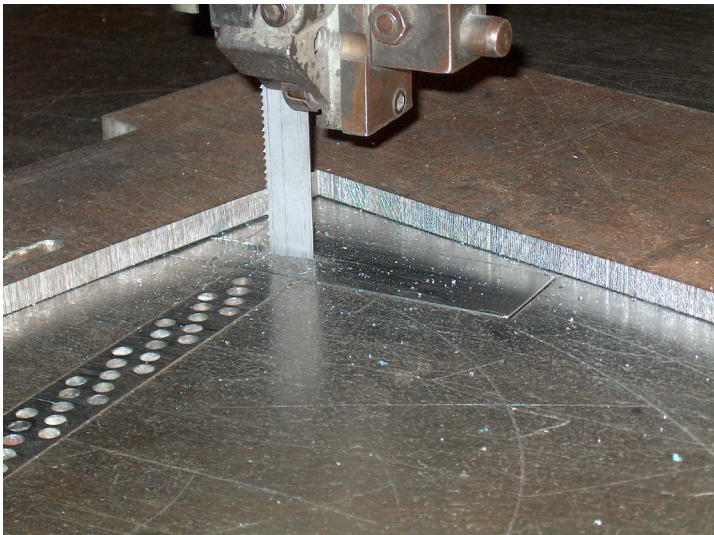
Width	Thickness	Set	Style	3	4	6	10	10/6	12/8	14	14/10	18/14
1/4"	0.025	Raker	Hook			923014						
			Broach								923015	923017
1/4"	0.035	Raker	Constant				923005			923010		
3/8"	0.025	Raker	Broach								923028	
3/8"	0.035	Raker	Hook		923012	923022						
			Constant				923020					
1/2"	0.025	Raker	Hook		923046	923032						
			Constant				923033				923041	
			Broach					923036	923037		923043	923044
1/2"	0.035	Raker	Hook	923047		923048						
			Constant							923055		
			Broach					923060			923067	

Features & Benefits

- Tooth hardness Rc 68-69
- 8% cobalt edge
- Available in coils (150' or 250') and welded to length

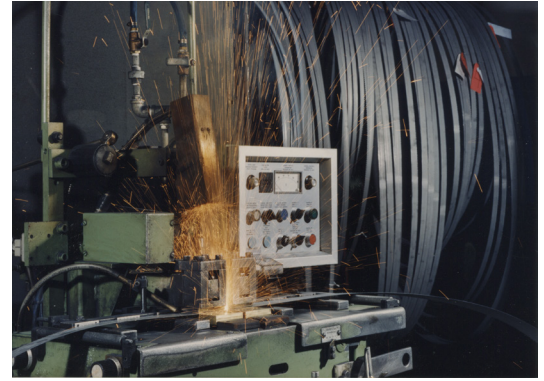
Applications

- Die work



Contour Band™ Bi-Metal M42

General Purpose Band Saws



Width	Thickness	Set	Style	8/5	10/6	12/8	14/10	18/14
1/4"	0.025	Wavy	Broach				923016	923018
3/8"	0.025	Wavy	Broach					923031
1/2"	0.020	Wavy	Broach					923052
	0.025	Wavy	Broach				923049	923051
3/4"	0.035	Wavy	Broach	923113	923118	923121	923124	923126
1"	0.035	Wavy	Broach	923166	923172	923176	923178	
1-1/4"	0.042	Wavy	Broach	923228	923231	923234		
1-1/2"	0.050	Wavy	Broach	923253				
2"	0.050	Wavy	Broach	923255				
	0.063	Wavy	Broach	923260				



Features & Benefits

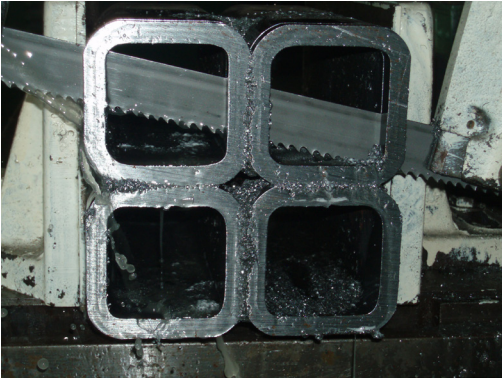
- Tooth hardness Rc 66-68
- 8% cobalt matrix II tool steel cutting edge
- Wavy set
- 0 degree face angle
- Available in coils (150' or 250') and welded to length

Applications

- Maintenance, tool room and repair shops
- Light fabrication of mild steel
- Thin wall tubing
- Sheet metal
- Vertical, hand feed machines
- Contour cutting

New Wave™
Bi-Metal Matrix II

General Purpose Band Saws



Width	Thickness	Set	Style	1.2	3	3/2	4/3	6/4	8/5	10	10/6	12/8	14	14/10	18	18/14	24
1/2"	0.020	Raker	Constant Broach							923030			923035		923040		
		Wavy	Constant												923038		923034
5/8"	0.032	Raker	Broach									923072		923074			
3/4"	0.035	Raker	Hook		923075												
			Constant Broach					923107	923112		923090			923095			
1"	0.035	Raker	Constant Broach							923150							
			Posi Broach				923162	923167			923170	923175		923177			
1-1/4"	0.042	Raker	Broach			923215	923217										
								923222	923227			923230					

Features & Benefits

- Tooth hardness Rc 66-68
- 8% cobalt matrix II tool steel cutting edge
- Comes in a wide variety of configurations including hook, broach, constant and posi
- Available in coils (150' or 250') and welded to length

Applications

- Ferrous and non-ferrous grating and expanded metals
- Maintenance, tool room and repair shops
- Light fabrication of mild steel
- Thin wall tubing, sheet metal
- Vertical, hand feed machines
- Contour cutting



Blades for Portable Band Saw Machines

Width	Thickness	Length	Set	Style	10	14	14/10	18	18/14	24
1/2"	0.020	3' 8-7/8"	Raker	Constant	23900	23903		23906		
			Wavy	Constant						23907
			Raker	Broach			23908		23905	
			Wavy	Broach					23904	

Features & Benefits

- 8% cobalt matrix II
- Provides excellent life in tough cutting applications
- Available 5 per pack or bulk 100

Super Weld™
Bi-Metal Matrix II

Since 1890

www.sterlingsawblades.com

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General Purpose Band Saws

Width	Thickness	Set	Style	3	4	6	6/4	8	10	10/6	12/8	14	14/10	18	
1/4"	0.025	Raker	Constant						914040						
			Broach											914070	
3/8"	0.025	Raker	Skip	914085	914095										
			Hook		914090	914100									
1/2"	0.025	Raker	Hook		914170	914180									
			Constant			914185			914190			914200		914210	
			Broach							914225			914235		
		Wavy	Constant									914205			
3/4"	0.032	Raker	Hook	914275											
			Constant			914295		914300	914310				914330		
			Broach							914350	914355		914360		
1"	0.035	Raker	Constant										914410		
			Posi				914420								
			Broach							914430	914435				

Features & Benefits

- Special heat treating process
- Spring tempered hardness on tooth edge and back
- Available in broach, skip and hook tooth
- Available in coils (100' or 250') and welded to length

Applications

- Tool room cutting
- Mild steel cutting
- Economy blade

Tri-Temp
Hard Edge
Hard Back

Width	Thickness	Set	Style	2	3	4	6	8	10	14	18	24	**Heavy set
3/16"	0.025	Raker	Skip			911012							
			Constant						911015	911020			
1/4"	0.025	Raker	Hook			911035	911045						
			Skip				911050						
			Constant						911055	911065	911070		
		Wavy	Constant									911075	
3/8"	0.025	Raker	Hook		911095	911105	911115						
			Skip			911110							
			Constant						911125	911130			
1/2"	0.025	Raker	Hook		911180	911190	911200						
			Hook**			911192							
			Skip			911195							
			Constant					911205		911210	911220	911230	
		Wavy	Constant									911235	
5/8"	0.032	Raker	Hook			911270							
			Constant						911285				
3/4"	0.032	Raker	Hook	911295	911300	911310	911320						
			Constant				911325	911330	911335	911355			
1"	0.035	Raker	Hook		911385								
			Constant					911395		911405			
1-1/4"	0.042	Raker	Hook		911427								

Features & Benefits

- Tooth hardness Rc 64-65
- Teeth and back edge flame hardened for durability
- Flexible body to run at high speeds
- Comes in skip, hook and standard tooth forms
- Available in coils (100' or 250') and welded to length

Applications

- Hobby and production wood working
- Cabinet shops
- Furniture manufacturing
- Aluminum, brass and other soft materials
- Wet ice and dry ice
- Straight, contour and resawing

Carbon Hard Edge Flex Back

Friction - For friction cutting only

Features & Benefits

- Made of special silicone carbon steel
- Good abrasion resistance and fatigue life
- Oxygenated tooth design
- Available in coils (100' or 250') and welded to length

Applications

- Ferrous metals
- Sheet metals and light plate
- Thin wall aircraft tubing and structurals
- Cut thin and odd shaped exotic materials
- Super alloys

Width	Thickness	Set	Style	8	10	14
1/2"	0.032	Raker	Constant		917000	917003
1"	0.035	Raker	Constant	917019	917021	



Straight Knife & Scalloped

Width	Thickness	Edge	Item #
3/8"	0.020	Straight Knife	950102
		Scalloped	950300
	0.025	Straight Knife	950104
1/2"	0.020	Straight Knife	950106
		Scalloped	950302
	0.032	Straight Knife	950108
		Scalloped	950304
5/8"	0.022	Scalloped	950306
3/4"	0.020	Straight Knife	950112
		Scalloped	950308
	0.032	Scalloped	950310
1"	0.020	Straight Knife	950114
		Scalloped	950312
	0.032	Straight Knife	950116
		Scalloped	950314
1-1/4"	0.020	Straight Knife	950118

'V' Toothed Knife

Width	Thickness	Edge	10	14
1/2"	0.020	Single	950404	
		Double		950505
	0.032	Single	950406	
5/8"	0.022	Single	950408	
		Double		950509
3/4"	0.020	Single	950410	950411
		Double	950510	
	0.032	Single	950412	
1"	0.020	Single	950414	950415
		Double	950514	950515

Features & Benefits

- Produces little downward drag resulting in no tearing during the cut and producing an excellent finish
- Run at speeds of 2000 - 8000 sfpm depending upon material
- Available in coils (100' or 250') and welded to length

Applications

Straight Knife (Single Edge)

- Slicing foam, food, plastics, rubber, fabric, sponges and fiberglass insulation

Scalloped (Single Wavy Edge)

- Slicing woven fabric, felt, filter material, fiberglass insulation, fish filleting and hosing material

Applications

Single Edge

- Cutting foam, food, plastics, rubber, fabric, sponges, fiberglass insulation and filter material

Double Edge

- Bidirectional cutting of foam, plastics, rubber, fabric, plastic film, food and filter material

Friction & Knife Edge

X-tra Duty .032

Features & Benefits

- Tooth hardness Rc 64-65
- .032 Gauge body for additional strength and rigidity
- Teeth and back edge flame hardened for durability
- Flexible body to run at high speeds
- Comes in raker and “every tooth set” hook tooth
- Available in coils (100' or 250') and welded to length

Applications

- Hobby wood working
- Cabinet shops
- Furniture manufacturing
- High production wood manufacturing
- Straight, contour and resawing

Width	Thickness	Set	Style	2	3	4
1/4"	0.032	Raker	Hook			916000
3/8"	0.032	ETS	Hook	916008	916012	
		Raker	Hook		916010	916015
1/2"	0.032	ETS	Hook	916019	916020	
		Raker	Hook			916025



Every Tooth Set (ETS)

Features & Benefits

- Tooth hardness Rc 64-65
- Teeth and back edge flame hardened for durability
- Flexible body to run at high speeds
- Comes in “every tooth set” configuration for rapid cutting or all types of wood
- Available in coils (100' or 250') and welded to length

Applications

- Hobby wood working
- Cabinet shops
- Furniture manufacturing
- High production wood manufacturing
- Straight, contour and resawing

Width	Thickness	Set	Style	2	3	4
1/4"	0.025	ETS	Hook			917995
3/8"	0.025	ETS	Hook		918000	918003
1/2"	0.025	ETS	Hook			918009
3/4"	0.032	ETS	Hook	918013		

Hard Edge Flex Back

Specialty Band Saws & Tools

Width	Thickness	Continuous	Segmented	4P Gulleted
1/2"	0.020	960100	960105	
	0.025			960110
3/4"	0.020	960115	960120	
	0.032			960125
1"	0.020	960130	960135	
	0.025	960140	960145	
	0.035	960150	960155	960160
	0.040	960165	960170	
1-1/4"	0.025	960175	960180	
	0.040	960185	960190	
	0.042			960195
1-1/2"	0.040	960200	960205	

Features & Benefits

- Made from a special silicone hardened steel
- Can be run at speeds of 6000 to 15000 SFPM
- Available in 25/35, 35/40, 40/50, 60/80, 80/100 blended grit sizes
- Available in welded to length only

Applications

- For cutting carbon, graphite, fiberglass, ceramics, stones, granite, and ect.

Band Saw Accessories

Super Sterling® Heavy Duty Oil-Free Synthetic Sawing Fluid

- Works on all sawing applications including cutoff, band, power hacksaw, reciprocating, etc.

5 Gallon Container
Item# 10800

4 (1 Gallon) Containers
Item# 10805

55 Gallon Drum
Item# 10807

Sterling® Mist Unit - Item# 10810

- For use with Super Sterling® oil free synthetic sawing fluid

Tachometer - Item# 10012

- For measuring RPM and band saw speed surface feet per minute

Refractometer - Item# 10017

- To determine the concentration of Super Sterling® and other industrial fluids

Tension Meter - Item# 10006

- For use on band saw blades and/or power hack saw blades

Magnetic Guide Alignment Tool - Item# 10010

- To check and adjust the blade orientation to the saw table assuring improved cutting accuracy

Blue DiamondTM
& Accessories

Carbide Tipped

Features & Benefits

- Precision ground carbide tooth provide long life with excellent finish
- Flexible backer to resist fatigue
- Welded tip, not soldered for strength
- Available in coils and welded to length

Width	Thickness	Style	1.7/1
1-1/2"	0.050	Triple Chip	943133
2"	0.062	Triple Chip	943172

M42 Bi-Metal

Features & Benefits

- M42 bi-metal with Rc 68-69 tooth
- 1 tpi tooth pitch
- Available in coils and welded to length

Width	Thickness	Set	Style	1	1.2
1-1/4"	0.042	Raker	Hook	925310	923305
1-1/2"	0.050	Raker	Hook	925320	
2"	0.050	Raker	Hook	925329	
	0.063	Raker	Hook	925330	

Pro Cut

Features & Benefits

- Flexible backer to resist fatigue
- Full hardened tooth provides for several sharpenings
- Welded tip, not soldered for strength
- Comes in a variety of sizes and tooth pitches
- Available in coils (100' or 250') and welded to length

Width	Thickness	Tooth Spacing	Style	1	1.2	1.3	2	*Heavy set
1"	0.035	3/4"	Hook			913104		
		1/2"	Hook				913106	
	0.042	7/8"	Hook		913110			
		3/4"	Hook				913112	
1-1/4"	0.042	1"	Hook	913116				
		7/8"	Hook		913118			
			Hook		913119*			
		3/4"	Hook				913121	
1-1/2"	0.050	1"	Hook	913125				
		7/8"	Hook		913127			
			Hook		913129*			
2"	0.050	1"	Hook	913134				
		7/8"	Hook		913136			

Applications

- Production wood working
- Resawing
- Portable band mills
- Works especially well in hardwoods

Applications

- Heavy duty production wood working
- Resawing
- Portable band mills
- Good for hard and soft wood

Applications

- Production wood working
- Resawing
- Portable band mills

Pro Cut Timber Master TK™

Pallet Slayer™

Features & Benefits

- Rc 64-65 full hard teeth
- Hard edge, hard back

Applications

- Pallet disassembly

Width	Thickness	Set	Style	6	8/5
1-1/4"	0.042	Raker	Constant	915010	
			Broach		915015



Pallet Reclaim C - Carbon

Features & Benefits

- Rc 64-65 full hard teeth
- Hard edge, hard back
- Available in 250' coils and welded to length

Applications

- Pallet disassembly

Width	Thickness	Set	Style	8/5
1-1/4"	0.042	Wavy	Broach	914443
		Raker	Broach	914450

Safety Tip - BiMetal Reciprocating Blade

Features & Benefits

- Rounded tip for added protection in pallet repair operations
- Packaged 50 per box

Applications

- Pallet disassembly

Width	Thickness	Length	18
3/4"	0.035	8"	46920

Metal Cutting - Universal 1/2" Shank

- Shatterproof
- Packed 5 per vinyl pouch or 50 per box

Recommended Uses	Width	Thickness	Length	10	14	14/10	18	18/14	24	32
Metal decking and roofing & nonferrous metals	3/4"	0.035	6"	40610						
			8"	40810						
Cutting soil pipe, heavy gauge metal & nail-embedded wood	3/4"	0.050	6"	40010						
Heavy gauge metals, compositions, masonite, wood	3/4"	0.035	6"			40640				
			8"			40840				
			12"			40120				
Cutting soil pipe & heavy gauge metal	3/4"	0.050	6"			40040				
			8"			40080				
Metals heavier than 1/8", bar stock, angles, rubber, masonite and fiberglass	3/4"	0.035	4"		40414					
			6"		40614					
			8"		40814					
Pipe, angle iron & heavy gauge metal over 1/8"	3/4"	0.050	6"		40014					
Heavy gauge sheet metal, conduit, pipe, tubing, thin fiberglass	3/4"	0.035	4"				40418			
			6"				40618			
			8"				40818			
Conduit, angle iron & heavy gauge metal up to 1/4"	3/4"	0.050	6"				40018			
Graduated teeth for fast cuts in metals heavier than 3/32", bar stock, angles, pipe, fiberglass, fiber, "Transite"	3/4"	0.035	6"					39684		
Metals lighter than 18 gauge, thin wall tubing, formed sheet & trim	3/4"	0.035	4"						40424	
			6"						40624	
Very thin gauge metals, sheet, tubing & trim	3/4"	0.035	4"							40432

Metal Scroll Cutting

- Packed 5 per vinyl pouch or 50 per box

Recommended Uses	Width	Thickness	Length	14	18
Scroll cutting heavy gauge metal, fiberglass, masonite	5/16"	0.035	3-5/8"	43114	
Scroll cutting metals lighter than 14 gauge	1/4"	0.035	3"		42018



Metal Cutting

Reciprocating Saw Blades

Ruff-Neck Demolition Blades



Recommended Uses	Width	Thickness	Length	3	8/5	12/8
Demolition work, remodeling, wood, wall-board, paneling, plaster, nail-embedded wood	1"	0.062	6"		46685	
			9"		46985	
			12"		46185	
Fastest cutting, roughing in work in wood	1"	0.062	12"	46190		
Wavy set for nail-embedded wood, metal lath, thin steel plate and metal demolition	1"	0.062	6"			46706
			9"			49606

- Universal 1/2" shank
- Packaged 2 per vinyl pouch or 50 per box

Fire & Rescue

Recommended Uses	Width	Thickness	Length	12/8	14/10
Fire and rescue work	3/4"	0.050	8"		40911
	1"	0.062	9"	46911	

- Packaged 2 per vinyl pouch or 50 per box

Wood & Plaster Cutting

Recommended Uses	Width	Thickness	Length	4	6	10
Fast cutting, positive rake design with wide gullet spacing for roughing-in	Taper	0.050	6"	45004		
Wood and nail-embedded woods, all composition material, also nonferrous metals	3/4"	0.035	6"		45606	
General roughing -in work in wood and nail-embedded woods, fast cutting	Taper	0.050	6"		45006	
			9"		45906	
			12"		45106	
Thinner sections of wood, plastics, metals 1/8" and under, where extra blade length is required	Taper	0.050	12"			45110
Plaster cutting - smooth, fast cuts in plaster, plasterboard and metal lath plaster,	3/4"	0.035	5"		52056 (V-tooth)	

- Packaged 2 per vinyl pouch or 50 per box



Demolition/ Wood Cutting

Blue Diamond™ Collection

- Packaged 1 per vinyl pouch

Recommended Uses	Shank	Width	Thickness	Length	Grit	Item #
Diamond edged air, jig and reciprocating saw blades are for use on various composites and hard friable materials such as quartz, glass, fiberglass, carbon graphite and ceramics	Air Saw	1/2"	0.025	5"	40/50	12700
	1/4" Univ	1/4"	0.042	3-1/2"	40/50	82700
	'T' Style	5/16"	0.042	4"	40/50	86700
	Recip	3/4"	0.035	6"	40/50	46700

Slik-Kote™ Collection

- Special treatment and coating results in a hard, abrasion resistant surface that increases the cutting life of the blade
- Universal, Bayonet and "T" Style packaged 5 per vinyl pouch or 100 per box
- Reciprocating blades are packaged 5 per vinyl pouch or 50 per box

Recommended Uses	Shank	Width	Thickness	Length	6	8	10	12	14
Fiberglass and other abrasive applications, also effective on metals including stainless steel	Univ 1/4"	5/16"	0.042	3-1/2"			82040		82041
	Bayonet	3/8"	0.035	3"					80148
	T' Style	5/16"	0.042	4"		88266			
				3"			88269		
	Recip	Taper	0.050	6"	41666				
				9"	41679				
	3/4"	0.035	6"			41668		41670	

Pneu-Saw™

- Packaged 5 per vinyl pouch or 100 per box

Recommended uses	Width	Thickness	Length	18	24	32
Scroll cuts in heavy metal, composites, fiberglass and plastics	1/2"	0.025	3-5/8"	12718		
Scroll cutting heavy gauge metal and fiberglass					12724	
Scroll cutting metals lighter than 14 gauge						12732

Glas-Fab™ Collection

- Hard surface coating adds blade life in abrasive materials
- Packaged 5 per vinyl pouch or 100 per box

Recommended uses	Shank	Width	Thickness	Length	2-Way
Smooth splinter free cuts in fiberglass, wood, plexiglass	Univ 1/4"	5/16"	0.050	3-1/2"	82032
	Bayonet	3/8"	0.050	3"	80033
	T' Style	4"	0.050	4"	87072

Specialty Jig Blades

Carbide Grit Collection- Imported

- Enhanced cutting capability and increased blade life
- Narrow width allows for straight and contour cutting
- Packaged 5 per vinyl pouch

Recommended Uses	Shank	Width	Thickness	Length	Medium Grit	Course Grit
Hard abrasive materials such as ceramic tile, fiberglass and slate	Univ 1/4"	5/16"	0.032	2-7/8"	30042	30040
	T' Style	5/16"	0.032	3"	36201	36402
	Recip	3/4"	0.040	4" 8"		51400 51800



Metal Cutting - Universal 'T' Style

- Durable, high performance bi-metal
- Shatterproof
- Packaged 5 per vinyl pouch or 100 per box

Recommended Uses	Width	Thickness	Length	8	12	18	24
Mild steel 1/4" - 3/8", nonferrous 1/4" - 5/8", laminates and plastics, 5/16" width for tighter contours in metal, wood, etc.	5/16"	0.042	4"	86260			
Mild steel 1/8" - 1/4", nonferrous 1/8" - 5/8", laminates and plastics, 5/16" width for tighter contours in metal, wood, etc.	5/16"	0.042	3"		86263		
Mild steel up to 3/16", nonferrous up to 1/4" and laminates, 5/16" width for tighter contours in metal, wood, etc.	5/16"	0.042	3"			86264	
Thin wall tubing and metal under 1/8"	5/16"	0.042	3"				86267



Wood Cutting - Universal 'T' Style

- Durable, high performance bi-metal
- Shatterproof
- 5/16" width for tighter contours in wood, metal, etc.
- Packaged 5 per vinyl pouch or 100 per box

Recommended Uses	Width	Thickness	Length	6	10
Fast cuts in hard and soft woods up to 2-3/8", 5/16" width for tighter contours in wood, metal, etc	5/16"	0.042	4"	87076	
For smooth cuts in hard and soft wood, plywood up to 1 1/4", also plastics, hollow ground	5/16"	0.050	4"	87074	
For smooth cuts in hard and soft wood, plywood up to 1 1/4", also plastics, hollow ground	5/16"	0.050	4"		87073
Reversed tooth direction for down cutting, reduces top splintering and chipping, hollow ground	5/16"	0.050	4"		87077 (down cut)



Carbide Grit 'T' Style

Metal Cutting - Universal 1/4" Style

- Packaged 5 per vinyl pouch or 100 per box

Recommended Uses	Width	Thickness	Length	10	14	18	24
1/4" - 1/2" steel, 1/4" - 3/4" nonferrous, plastics, etc.	5/16"	0.042	3-1/2"	82050			
1/8" - 1/4" steel, 1/8" - 1/2" nonferrous, aluminum, fiberglass, plastic, etc.	5/16"	0.042	3-1/2"		82051		
1/16" - 1/8" steel, conduit, plastics, tubing, etc.	5/16"	0.042	3-1/2"			82052	
1/16" steel and under, thin wall tubing, formica, etc.	5/16"	0.042	3-1/2"				82053

Wood Cutting - Universal 1/4" Style

- Packaged 5 per vinyl pouch or 100 per box

Recommended Uses	Width	Thickness	Length	6	10
Positive rake for roughing-in and scroll cuts up to 1/2" in wood, plywood, hardboard, plastics, etc.	1/4"	0.035	3-1/2"	82021	
Smoother finish and scroll cuts in wood, plywood, hardwood, plastics, laminates up to 1/2"	1/4"	0.035	3-1/2"		82022
Long life in wood cutting, laminates and composites	3/8"	0.035	4"	82008	
Fine set teeth for finish cuts in wood, plywood, plastics, masonite, brass and aluminum	3/8"	0.035	4"		82011

Metal Cutting - Bayonet Style

- Packaged 5 per vinyl pouch or 100 per box

Recommended Uses	Width	Thickness	Length	14	18	24
1/8" - 1/4" steel, 1/8" - 1/4" nonferrous and laminates	3/8"	0.035	3"	80112		
1-16" - 1/8" steel, conduit, plastics, tubing, etc	3/8"	0.035	3"		80111	
Thin sheet steel, thin wall tubing and thin nonferrous	3/8"	0.035	3"			80113
1/8" - 1/4" steel, 1/8" - 3/8" nonferrous, suitable for scroll work	1/4"	0.035	1-3/4"	80114		
Thin sheet steel, thin wall tubing, suitable for scroll work	1/4"	0.035	1-3/4"			80115

Wood Cutting - Bayonet Style

- Packaged 5 per vinyl pouch or 100 per box

Recommended Uses	Width	Thickness	Length	6	10
Faster cutting, set tooth, for roughing-in wood, plastics, compositions	3/8"	0.035	3"	80091	
Fast cutting, set tooth for wood, compositions, nonferrous metals-medium smooth finish	3/8"	0.035	3"		80092

Universal Style Jig Blades

Ferrous & Nonferrous Blades- Imported

- Cut with fewer burrs and less heat than abrasive blades
- No need for secondary finish grinding
- Modified triple chip grind resists material build up on the tooth allowing longer life between re-sharpening

Application	Description	Arbor	RPM	Grade	Item #
Steel cutting	7-1/4" x 36T TCG saw blades - ferrous	5/8"*	5800	C-6	10700
	8" x 48T TCG saw blades - ferrous	5/8"*	5800	C-6	10705
	9" x 48T TCG saw blades - ferrous	1"	5200	C-6	10707
	10" x 80T TCG saw blades - ferrous	5/8"	5800	C-6	10710
	12" x 100T TCG saw blades - ferrous	1"	2000	C-6	10715
	14" x 120T TCG saw blades - ferrous	1"	1700	C-6	10720

*Diamond arbor

Wood Cutting Blades- Imported

- Alternate tooth bevel grind for fast clean cuts

Application	Description	Arbor	RPM	Grade	Item #
Framing/general purpose	7-1/4" x 24T ATB saw blade	5/8"*	7000	C-2	10750
	8-1/4" x 24T ATB saw blade	5/8"*	7000	C-2	10760
Finishing	7-1/4" x 40T ATB saw blade	5/8"*	7000	C-2	10755
General purpose	10" x 40T ATB saw blade	5/8"	7000	C-3	10765
General purpose/ fine finishing	10" x 60T ATB saw blade	5/8"	7000	C-3	10770
Fine finishing	12" x 80T ATB saw blade	1"	7000	C-3	10780
Ultra fine finishing	10" x 80T ATB saw blade	5/8"	7000	C-3	10775
	12" x 96T ATB saw blade	1"	7000	C-3	10785

Dado Sets- Imported

- Bevel ground outside saws and chipper sets
- Stay sharp longer even when cutting man made materials

Application	Description	Arbor	RPM	Grade	Item #
Dado Cutting	6" x 30T stack dado set	5/8"	7000	C-4	10790
	8" x 42T stack dado set	5/8"	7000	C-4	10792



Porta-Hack Bi-Metal

- Portable hacksaw
- Used for job-site cutting of pipe, structurals and other materials
- Packaged 10 blades per box

Recommended Uses	Width	Length	8	14
Thinner sections of steel, brass, bronze, fiberglass	1-1/4"	12"		10906
		16"		10907
		21"		10930
		24"		10973
		30"		10975
For heavier sections of steel, brass, bronze, fiberglass	1-1/4"	16"	10929	

Power Hacksaw Bi-Metal-Imported

- Shatterproof power hacksaw
- Strong, shatter-resistant for high productivity and safety
- Extra wide blade gives rigidity and durability
- Packaged 10 blades per box

Width	Thickness	Length	4	6	10	14
1"	0.050	12"				10304
		14"			10312	10316
1-1/4"	0.062	14"		10320	10324	
1-1/2"	0.750	14"		10340		
1-1/4"	0.620	18"			10380	
1-1/2"	0.750	18"	10392	10396		
1-3/4"	0.88	18"		10412		
		21"		10428		
2"	0.100	24"	10456			



Hand Hacksaw Blades

Bi-Metal Shatterproof

- Shatter resistant bi-metal construction allows blade to bend & flex
- High hardness provides extended tool life
- Packaged 5 per vinyl pouch or 100 per box

STERLING® BIMETAL SHATTERPROOF NO. 10079 12" x 1.81" DIAMOND SAW WORKS, INC., Chaffee, New York 14030 U.S.A.

Recommended Uses	Width	Thickness	Length	14	18	18/14	24	24/20	32
For cutting heavy gauge metal, fiberglass	1/2"	0.025	12"	10077					
For cutting metals lighter than 14 gauge	1/2"	0.025	12"		10079				
For cutting metals lighter than 18 gauge tubing, formed sheet, trim	1/2"	0.025	12"				10081		
For cutting very thin gauge metals, sheet, tubing, trim	1/2"	0.025	12"						10083
Varied pitch mitigates tooth strippage problems and allows for faster cuts in a wider variety of applications	1/2"	0.025	12"			10073			
								10075	

Hand Hacksaw Frame - Item # 10022

- High tension
- Blades can be mounted straight or at a 45° angle for flush cutting
- Packaged 5 per box

PVC/ABS Plastic Pipe Saw Blades

- Spring tempered to resist flexing
- 63-66 Rc hardness
- Cuts plastic, wood, drywall, PVC and ABS pipe
- Packaged 5 per box

Blade with Handle

Length	10
12"	70131
18"	70181

Replacement Blades

Width	Thickness	Length	10
2-1/2"	0.035	12"	70130
		18"	70180

Hand Hacksaw Blades

Diameter		Item #		
Inches	mm	Bi-Metal	Carbide Tipped	Diamond Edge
9/16"	14	55009	-	54100
5/8"	16	55010	-	54105
11/16"	17	55011	-	54110
3/4"	19	55012	56012	54115
13/16"	21	55013	56013	54120
7/8"	22	55014	56014	54125
15/16"	24	55015	56015	54130
1"	25	55016	56016	54135
1-1/16"	27	55017	56017	54140
1-1/8"	29	55018	56018	54145
1-3/16"	30	55019	-	54150
1-1/4"	32	55020	56020	54155
1-5/16"	33	55021	-	54160
1-3/8"	35	55022	56022	54165
1-7/16"	37	55023	56023	54170
1-1/2"	38	55024	56024	54175
1-9/16"	40	55025	56025	54180
1-5/8"	41	55026	56026	54185
1-11/16"	43	55027	56027	54190
1-3/4"	44	55028	56028	54195
1-13/16"	46	55029	-	54200
1-7/8"	48	55030	56030	54205
2"	51	55032	56032	54210
2-1/16"	52	55033	56033	54215
2-1/8"	54	55034	56034	54220
2-1/4"	57	55036	56036	54225
2-5/16"	59	55037	-	54230
2-3/8"	60	55038	56038	54235
2-1/2"	64	55040	56040	54240
2-9/16"	65	55041	-	54245
2-5/8"	67	55042	56042	54250
2-3/4"	70	55044	56044	54255
2-7/8"	73	55046	56046	54260
3"	76	55048	56048	54265
3-1/8"	79	55050	56050	54270
3-1/4"	83	55052	56052	54275
3-3/8"	86	55054	56054	54280
3-1/2"	89	55056	56056	54285
3-5/8"	92	55058	56058	54290
3-3/4"	95	55060	56060	54295
3-5/8"	98	55062	56062	54300
4"	102	55064	56064	54305
4-1/8"	105	55066	56066	54310
4-1/4"	108	55068	56068	54315
4-3/8"	111	55070	56070	54320
4-1/2"	114	55072	56072	54325
4-3/4"	121	55076	56076	54330
5"	127	55080	56080	54335
5-1/2"	140	55088	56088	54340
5-3/4"	146	55092	56092	-
6"	152	55096	56096	54345

Bi-Metal - Varied Pitch

- High Hardness teeth
- Varied pitch
- Positive rake teeth

Carbide Tipped- Imported

- Best suited for use in fiberglass, transite, flake board & cast iron

Blue Diamond™

- Bi-metal matrix steel
- 40/50 blended diamond grit nickel matrix braze bonded edge
- 1-5/8" cutting depth
- Best suited for use in abrasive, non-ferrous materials



Arbors- Imported

Fits Hole Saws	Follows Through	Shank	Thread Size	Chuck Size	Item #
9/16" - 1-3/16"	1" - 1-3/16"	1/4" Hex	1/2-20	1/4"	57015
		3/8" Hex	1/2-20	3/8"	57016
	7/8" - 1-1/2"	7/16" Hex	1/2-20	1/2"	57018
1-1/4" - 2-3/8"	1-1/4" - 2-3/8"	7/16" Hex	5/8-18	1/2"	57020
1-1/4" - 6"	1-7/16" - 6"	7/16" Hex	5/8-18	1/2"	57045*

*Quick change design, with knurled collar

1/4" Pilot Drills- Imported

Description	Item #
4" Long 1/4" pilot drill (For 1/4" rd., 7/16" Hex & 5/8" hex)	57035
3" Long 1/4" pilot drill (For 1/4" hex & 3/8" hex)	57036
3" Pilot drill for use with diamond edge	54500
12" Extension (For 7/16" hex shank)	57100

Arbor Adaptor- Imported

Description	Item #
Converts 1/2" - 20 threaded arbors (57015, 57016 and 57018) to 5/8" - 18 thread size to accommodate larger diameter saws	57000

Hole Saw Kits

- Includes the most commonly used hole saws, arbors and accessories used for that trade task
- Kit packed in a sturdy, plastic case

Bi-Metal Pro Pack Hole Saw Kit - Item #57515

Includes:

- | | |
|---------------------|---|
| 1 - 3/4" hole saw | 1 - 2" hole saw |
| 1 - 7/8" hole saw | 1 - 2-1/4" hole saw |
| 1 - 1-1/8" hole saw | 1 - 2-1/2" hole saw |
| 1 - 1-3/8" hole saw | 1 - (57045*) 7/16" hex arbor |
| 1 - 1-1/2" hole saw | 1 - (57035) Additional 1/4" pilot drill |
| 1 - 1-3/4" hole saw | 1 - (57000) Arbor adaptor |

Bi-Metal Plumber's Hole Saw Kit - Item #57528

Includes:

- | | |
|---------------------|---|
| 1 - 3/4" hole saw | 1 - 1-3/4" hole saw |
| 1 - 7/8" hole saw | 1 - 2-1/4" hole saw |
| 1 - 1-1/8" hole saw | 1 - (57045*) 7/16" hex arbor |
| 1 - 1-1/2" hole saw | 1 - (57035) Additional 1/4" pilot drill |

Bi-Metal Electrician's Hole Saw Kit - Item #57528

Includes:

- | | |
|---------------------|---|
| 1 - 7/8" hole saw | 1 - 2-1/2" hole saw |
| 1 - 1-1/8" hole saw | 1 - (57018) 7/16" hex arbor |
| 1 - 1-3/8" hole saw | 1 - (57045*) 7/16" hex arbor |
| 1 - 1-3/4" hole saw | 1 - (57035) Additional 1/4" pilot drill |
| 1 - 2" hole saw | |

Carbide Tipped Hole Saw Kit - Item #57507- Imported

Includes:

- | | |
|---------------------|---|
| 1 - 3/4" hole saw | 1 - 2" hole saw |
| 1 - 7/8" hole saw | 1 - 2-1/4" hole saw |
| 1 - 1-1/8" hole saw | 1 - 2-1/2" hole saw |
| 1 - 1-3/8" hole saw | 1 - (57045*) 7/16" hex arbor |
| 1 - 1-1/2" hole saw | 1 - (57035) Additional 1/4" pilot drill |
| 1 - 1-3/4" hole saw | 1 - (57000) arbor adaptor |

Band Saw Speed Chart

Material to Cut		Bi-Metal Band	S.F.P.M.	Cut Rate Aq. In/Min	Feed Pressure	Tool Life Sq In/Ft	Material Characteristics
Low Carbon	1010-1019	Matrix II	300-350	11-15	Medium/light	650-800	Free machining
Medium Carbon	1020-1050	Matrix II	190-225	7-9	Medium/light	425-700	Free machining
High Carbon	1055-1095	Matrix II	145-170	6-8	Medium	300-400	Free machining
Free Machining	1109-1113	Matrix II	300-350	12-15	Medium/light	700-850	Free machining
	1115-1213	Matrix II	200-250	8-10	Medium/light	500-750	Free machining
Manganese	1320-1340	M42/M51	175-220	6-8	Medium	330-375	Work hardening
Nickel	2015-2517	M42/M51	225-250	6-7	Medium	250-300	Work hardening
	2320-2350	M42/M51	110-140	5-6	Medium	250-300	Work hardening
	2513-2515	M42/M51	175-220	4-5	Medium	250-300	Work hardening
Nickel-Chrome	3115-3150	M42	125-160	6-9	Medium	275-350	Tendency to chip weld
	3215-3240	M42/M51	110-140	5-8	Medium	250-300	Work hardening
	3415-3450	M42/M51	90-125	4-6	Medium/heavy	250-300	Work hardening
Molybdenum	4023-4037	Matrix II	230-270	6-8	Medium	350-375	Abrasive
	4042-4063	Matrix II	180-220	5-7	Medium/heavy	325-350	Abrasive
Chrome-Moly	4120-4140	M42/M51	185-210	5-7	Medium	275-350	Work hardening/abrasive
	4320-4340	M42/M51	180-230	5-7	Medium	250-325	Work hardening/abrasive
Nick-Chro-Moly	86020-8750	M42	175-230	5-7	Medium	275-425	Good cutting characteristics
	9310-9850	M42/M51	160-220	4-6	Medium/heavy	175-300	Work hardening
Nickel-Moly	4615-4640	M42/M51	210-240	5-7	Medium	275-300	Work hardening
	4812-4820	M42/M51	175-190	4-6	Medium/heavy	225-275	Work hardening
Chrome	5120-5160	M42	190-230	6-8	Medium	225-350	Good cutting characteristics
	50100-52100	M42/M51	150-185	4-6	Medium	200-275	Abrasive
Chro-Van-Silicon	6115-6120	M42	160-225	3-6	Medium	200-275	Abrasive
Silicon	9262	M42	175-200	8-16	Medium	175-250	Extremely abrasive
Stainless	201-304	M42/M51	80-125	2-4	Medium/heavy	275-300	Work hardening
	308-348	M42/M51	55-80	55-80	Medium/heavy	100-250	Work hardening
	410-430	M42/M51	110-150	2-4	Medium	125-250	Work hardening/abrasive
	440 & 17-series	M42/M51	75-110	1-2	Medium/heavy	125-175	Work hardening/abrasive
Tool Steel	M1, M2, M3, T1, T2	M42/M51	120-150	3-5	Medium/heavy	125-175	Work hardening/abrasive
Die Steel	O-1, O-2, O-6, O-7	M42/M51	175-210	3-5	Medium/heavy	225-350	Work hardening/abrasive
	A-2, A-4	M42/M51	180-220	3-4	Medium/heavy	200-250	Work hardening/abrasive
	D-2, D-3, D-4	M42/M51	90-120	2-3	Medium/heavy	125-175	Work hardening/abrasive
Hot Work Steel	H12, H13, H21	M42	160-200	4-5	Medium	275-325	Abrasive
	H22, H24, H25	M42	130-175	2-4	Medium/heavy	175-225	Abrasive
Monel		M42/M51	60-90	.5-4	Medium/heavy	50-100	Extremely work hardening
Inconel		M42/M51	50-80	.5-4	Medium/heavy	25-70	Extremely work hardening
Hastelloy		M42/M51	50-80	.5-4	Medium/heavy	55-100	Extremely work hardening
Titanium		M42/M51	40-60	.5-4	Medium/heavy	25-60	Extremely work hardening
Aluminum	2011-7075	Matrix II	325-400	14-25	Medium/light	175-275	Abrasive/chip build up
Copper		Matrix II	275-350	6-8	Medium/light	250-600	Good cutting characteristics
Bronze		Matrix II	225-300	14-18	Medium/light	200-425	Good cutting characteristics
Brass Red		Matrix II	225-300	14-18	Medium/light	225-400	Good cutting characteristics
Brass, Navel		Matrix II	275-350	10-14	Medium/light		Good cutting characteristics
Cast Iron		Matrix II	165-225		Medium		
Cast Steel		Matrix II	110-225		Medium		
Structurals		Matrix II	175-250		Medium/light		Tooth breakage potential



Diamond Saw Works, Inc.

12290 Olean Rd
Chaffee, New York 14030-9768
716-496-7417 / 800-828-1180
Fax: 800-237-8853
sales@diamondsaw.com

www.sterlingsawblades.com

Warehouse in:

Portland, OR, Charlotte, NC,
Houston, TX, Rancho Cucamonga, CA

