

BAND SAW BLADES

Eberle CT-flex nano

Performance
Precision
Quality

INTELLIGENT SOLUTIONS
MADE BY

Eberle

CARBIDE-TIPPED PROGRAM

CT-flex® nano

Coated
carbide-tipped blade

Features: TiAlN-coating, heat and wear resistant cutting edge, pre-honed tooth edges
Applications: stainless, acid-resistant, hardening martensitic steel, nickel based alloys
≤ 65 HRC

Work pieces:  round bar  square bar  flat bar



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

CT-flex® 3000

Carbide-tipped blade

Features: CT3 geometry, excellent performance, short cycle times, high stability
Applications: extremely hard-to-cut materials
≤ 65 HRC

Work pieces:  round bar  square bar  flat bar



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

CT-flex® 4000

Carbide-tipped blade

Features: CT4 geometry, excellent performance, short cycle times, very smooth running blade
Applications: hard-to-cut materials, Aluminum
≤ 65 HRC

Work pieces:  round bar  square bar  flat bar



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

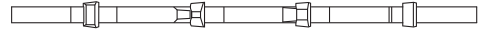
CT-flex® CHM

Carbide-tipped blade

Features: Multichip® geometry, superior performance, negative rake angle, extreme wear resistance
 Applications: case hardened and chrome plated materials ≤ 65 HRC



Work pieces: round bar thick-walled tubing



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

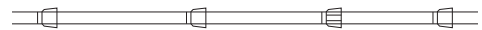
CT-flex® ALU XL

Carbide-tipped blade

Features: Multichip® geometry, improved chip formation, minor material loss, thin kerf
 Applications: large plates and large blocks of Aluminum



Work pieces: round bar square bar flat bar



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

CT-flex® Pro

Carbide-tipped blade

Features: triple chip tooth geometry, set tooth, vibration resistant
 Applications: corrosion and acid-resistant steels, nickel-based alloys ≤ 65 HRC



Work pieces: round bar thick-walled tubing square bar flat bar beams



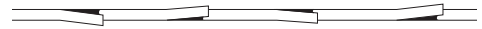
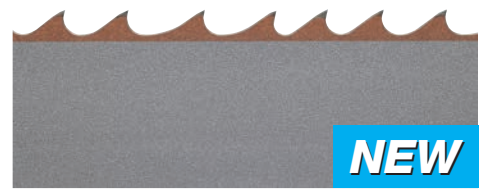
in	teeth per inch (tpi)						mm
		1.4/2	2	2/3	3	3/4	
3/4 x .035					ST		20 x 0,90
1 x .035					ST	ST	27 x 0,90
1 1/4 x .042				ST		ST	34 x 1,10
1 1/2 x .050		ST	ST	ST			41 x 1,30
2 x .063		ST					54 x 1,60

ST = set tooth

nanoflex® VTX

Coated
bimetal blade

Features: TiAlN-coating, special alloyed micro-resistant cutting edge, increased tooth hardness, variable tooth height with extremely positive rake angle
Applications: corrosion and acid-resistant steel, nickel-based alloys, tempered steel
≤ 50 HRC



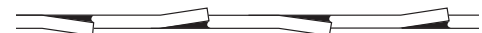
Work pieces: round bar thick-walled tubing square bar flat bar

in	teeth per inch (tpi)						mm
		.65/.95	.75/1.25	1.4/2	2/3		
1 1/4 x .042					CHT		34 x 1,10
1 1/2 x .050				CHT	CHT		41 x 1,30
2 x .050				CHT	CHT		54 x 1,30
2 x .063				CHT	CHT		54 x 1,60
2 5/8 x .063		CHT	CHT	CHT			67 x 1,60
3 1/8 x .063		CHT	CHT	CHT			80 x 1,60

nanoflex® Black

Coated
bimetal blade

Features: TiAlN-coating, prehoned edges, short cycle times, excellent wear resistance
Applications: Aluminum, mild steels, alloys, stainless steels
≤ 50 HRC



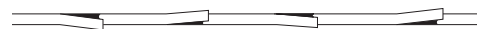
Work pieces: round bar tubing bundle single-layer
 square bar flat bar beams special profiles

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

duoflex® VTX

Bimetal blade

Features: special alloyed micro-resistant cutting edge, increased tooth hardness, variable tooth height with extremely positive rake angle
Applications: mold steels, stainless steels, nickel-based and heat-treated alloys
≤ 50 HRC



Work pieces: round bar thick-walled tubing square bar flat bar

in	teeth per inch (tpi)						mm
		.65/.95	.75/1.25	1.4/2	2/3		
1 1/4 x .042					CHT		34 x 1,10
1 1/2 x .050				CHT	CHT		41 x 1,30
2 x .050				CHT	CHT		54 x 1,30
2 x .063				CHT	CHT		54 x 1,60
2 5/8 x .063		CHT	CHT	CHT			67 x 1,60
3 1/8 x .063		CHT	CHT	CHT			80 x 1,60

duoflex® GTX

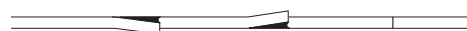
Bimetal blade

Features: special alloyed micro-resistant cutting edge,
ground triple chip geometry, excellent finish

Applications: large applications of mold steels, alloys
≤ 50 HRC



Work pieces: round bar square bar flat bar beams



in	teeth per inch (tpi)							mm
		.75/1.25	1/1.3	1.4/2				
2 x .063		DCS	DCS	DCS				54 x 1,60
2 5/8 x .063		DCS	DCS	DCS				67 x 1,60
3 1/8 x .063		DCS	DCS	DCS				80 x 1,60

duoflex® SPX

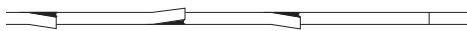
Bimetal blade

Features: special alloyed micro-resistant cutting edge, repeating
positive rake, angle tooth geometry, reduced cutting force

Applications: stainless steel, mold steels, tool steels
≤ 49 HRC



Work pieces: round bar thick-walled tubes square bar flat bar beams



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

duoflex® MX55

Bimetal blade

Features: special alloyed micro-resistant cutting edge,
positive rake angle, general purpose capability

Applications: mild steels, alloyed, stainless and heat resistant steels
≤ 49 HRC



Work pieces: round bar tubing bundle single-layer

bundle thick-walled tubes bundle round bars square bar flat bar beams



in	teeth per inch (tpi)							mm
		.75/1.25	1.4/2	2/3	3/4	4/6		
1 x .035				DCS	DCS	CS		27 x 0,90
1 1/4 x .042				DCS	DCS	CS		34 x 1,10
1 1/2 x .050				DCS	DCS			41 x 1,30
2 x .063			DCS	DCS	DCS			54 x 1,60
2 5/8 x .063		DCS	DCS	DCS				67 x 1,60
3 1/8 x .063		DCS	DCS					80 x 1,60

duoflex® M42

Bimetal blade

Features: vibration resistant tooth edge, zero and positive rake angles
 Applications: variable and constant tooth pitches for universal applications, mild steels, structural steels, alloys ≤ 44 HRC



- Work pieces: ● round bar ○ tubes ●● bundle single-layer
- bundle multiple-layer ●●● bundle round bars ■ square bar ■ flat bar
- bundle tubes H beams ≡ special profiles

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

duoflex® PT

Bimetal blade

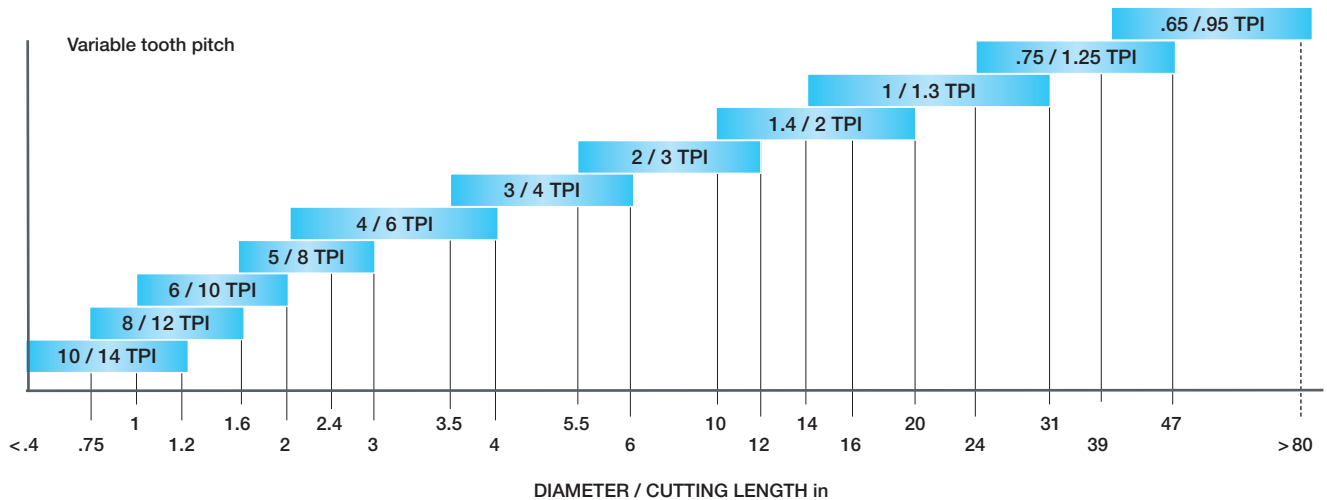
Features: strong positive tooth geometry, variable setting widths, reduced vibration and tooth breakage
 Applications: profiles and tubes ≤ 44 HRC



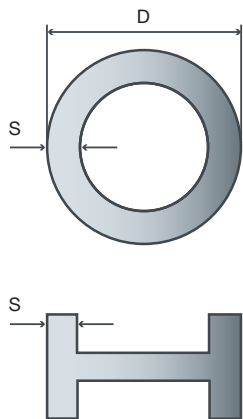
- Work pieces: ○ Tubes ●● bundle single-layer ○○ bundle multiple-layer
- bundle round bars □□□ bundle tubes H beams ≡ special profiles

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

CUTTING RECOMMENDATIONS FOR SOLID MATERIAL

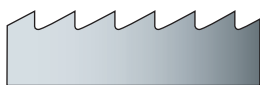


CUTTING RECOMMENDATIONS FOR TUBES AND PROFILES



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

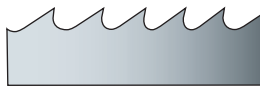
TOOTH FORMS



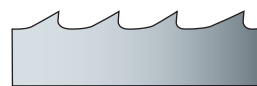
N-TOOTH | neutral rake angle
 > short-chip materials
 > small work pieces



CST-TOOTH | positive rake angle
 > short-chip materials
 > profiles, tubes, bundles



CS-TOOTH | positive rake angle
 > long-chip, tough materials
 > universal application



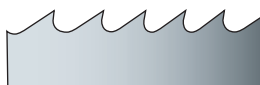
CW-TOOTH | positive rake angle
 > low-alloy materials, Aluminum
 > mold construction, contours



DCS-TOOTH | positive rake angle
 > heavy duty, high alloyed work pieces
 > large cross-sections



CHT-TOOTH | variable, extremely positive rake angle
 > hard-to-cut materials, heat-treated steels
 > large to very large work pieces



CSP-TOOTH | positive rake angle
 > austenitic materials
 > nickel-based alloys



TR/TRN-TOOTH | variable rake angle
 > heavy duty work pieces
 > high cutting performance

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On our website www.eberle-america.com you can find the latest product information as well as an overview of our current trade show dates.

Eberle Cutting Data App

The Eberle Cutting Data App for bimetal and carbide band saws can be downloaded from our homepage www.eberleslidechart.com or from:

**Training**

We offer band saw blade training to your company upon request. Just contact your Authorized Eberle Distributor or get in touch with our headquarter.

Technical advice

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

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We look forward to your call.

Eberle

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 Cold Rolling Mill and Saw Factory
 Quality products since 1836