

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

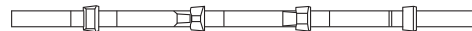


in	teeth per inch (tpi)							mm
	.75/1.25	1/1.3	1.4/2	2	2/3	3	3/4	
3/4 x .035						TR		20 x 0,90
1 x .035					TR	TR	TR	27 x 0,90
1 1/4 x .042				TR	TR	TR	TR	34 x 1,10
1 1/2 x .050			TR	TR	TR	TR	TR	41 x 1,30
2 x .063	TR	TR	TR	TR	TR			54 x 1,60
2 5/8 x .063	TR	TR	TR					67 x 1,60
3 1/8 x .063	TR		TR	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



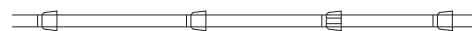
Work pieces: ● round bar ○ thick-walled tubing

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

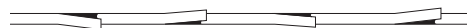
ST = set tooth

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

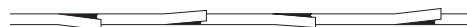
in	teeth per inch (tpi)						mm
	.75/1.25	1/1.3	1.4/2	2/3	3/4		
1 1/2 x .050			DCS	DCS	DCS	41 x 1,30	
2 x .063		DCS	DCS	DCS	DCS	54 x 1,60	
2 5/8 x .063	DCS	DCS	DCS			67 x 1,60	
3 1/8 x .063	DCS	DCS	DCS			80 x 1,60	

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

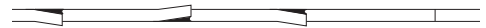
Bimetal blade

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

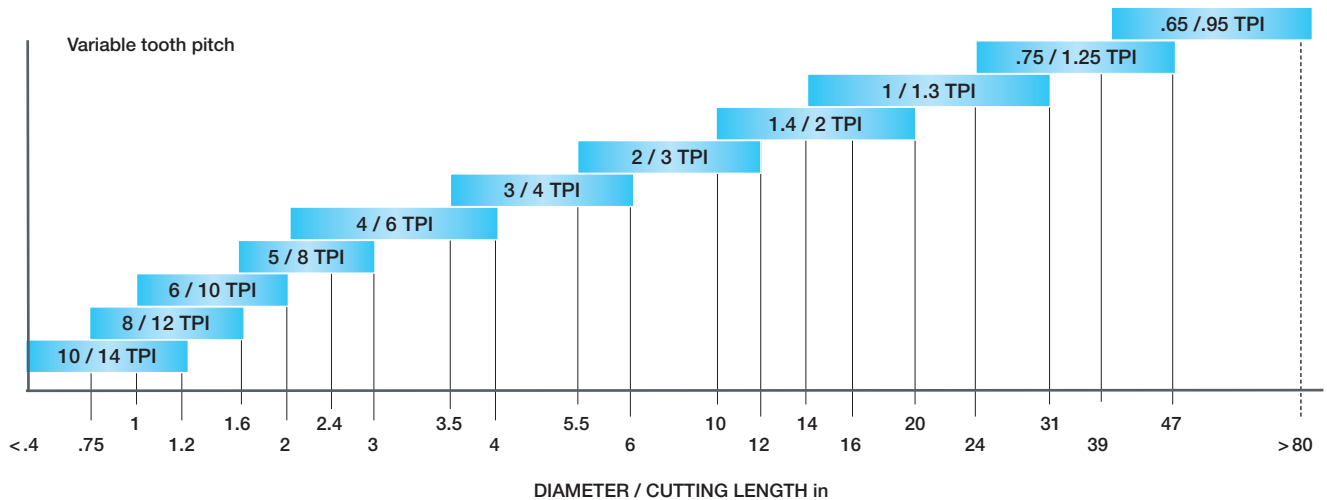
Features: strong positive tooth geometry, variable setting widths, reduced vibration and tooth breakage
 Applications: profiles and tubes
 ≤ 44 HRC



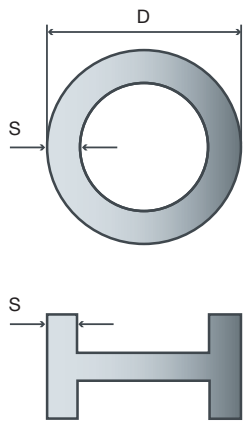
- Work pieces: ○ Tubes ●● bundle single-layer ○○○ bundle multiple-layer
- bundle round bars □□□ bundle tubes H beams ≡ special profiles

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

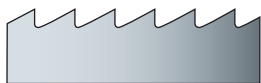


CUTTING RECOMMENDATIONS FOR TUBES AND PROFILES



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

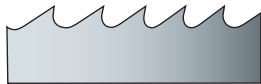
TOOTH FORMS



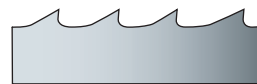
N-TOOTH | neutral rake angle
 > short-chip materials
 > small work pieces



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



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



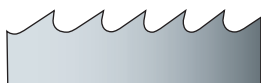
CW-TOOTH | positive rake angle
 > low-alloy materials, Aluminum
 > mold construction, contours



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

J. N. Eberle & Cie. GmbH

Eberlestr. 28
 D-86157 Augsburg
 Tel.: +49 (821) 52 12-0
 Fax: +49 (821) 52 12-300
 E-Mail: info@eberle-augsburg.de
www.eberle-augsburg.de

Eberle America, Inc.

6311 Ronald Reagan Drive
 Suite 174
 USA-63367 Lake St. Louis, MO
 Tel.: +1 (314) 406-1102
 Fax: +1 (636) 240-6155
 email: info@eberleblades.com
www.eberle-america.com

Eberle France

20, Boulevard des Nations
 F-69960 Corbas
 Tél: +33 (4) 78 96 07 53
 Fax: +33 (4) 78 96 97 67
 E-mail: contact@eberlefrance.fr
www.eberle-france.com

Eberle Italia S.r.l.

Via Umbria 3/D
 I-20098 San Giuliano Milanese
 Tel.: +39 (02) 98 28 17 17
 Fax: +39 (02) 98 28 01 78
 E-mail: eberle@eberle.it
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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:

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Technical advice

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

Tel.: +1 (314) 406-1102
Fax: +1 (636) 240-6155
Email: info@eberleblades.com

We look forward to your call.

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 Quality products since 1836