

HSS FERROUS BLADES (M-2 Steel / 63/65 RC Hardness / 500 SFPM Max)

Diameter (mm/in.)	Bore DIA.	2 mm / .079	2.5 mm / .098	3 mm / .118	3.5 mm / .137	4 mm / .157	Sharpen / Repair
160, 6	32, 1	\$60					\$15.00
200, 8	32	\$65	\$75				\$15.00
225, 9	32, 40	\$70	\$80				\$18.00
250, 10	32, 40	\$80	\$90				\$18.00
275, 11	32, 40	\$80	\$80	\$115			\$21.00
300, 12	32,38,40	\$105	\$110	\$125			\$21.00
315, 12.5	32, 40	\$120	\$120	\$130	\$140		\$24.00
325, 13	40	\$130	\$140	\$150			\$24.00
350, 14	32,40,50	\$140	\$140	\$155	\$175		\$24.00
370, 15	40, 50		\$200	\$210			\$27.00
400, 16	40, 50		\$235	\$230	\$240	\$275	\$27.00
425, 17	40, 50		\$280	\$260	\$285	\$315	\$30.00
450, 18	40, 50		\$370	\$335	\$370	\$395	\$30.00

HSS NON-FERROUS BLADES (M-2 Steel / 54/56 RC Hardness / 500 SFPM Max)

Diameter (in.)	Bore DIA.	1.2 mm / .047	1.6 mm / .062	2 mm / .079	2.5 mm / .098	3 mm / .118	Sharpen / Repair
6" - 7"	5/8", 1"	\$90	\$95		\$100	\$130	\$15.00
8"	5/8", 1"	\$100	\$100		\$115	\$145	\$15.00
9"	5/8", 1"	\$125	\$125		\$130	\$155	\$18.00
10"	5/8", 1"	\$165	\$135		\$140	\$165	\$18.00
11"	32 mm		\$180		\$160	\$210	\$21.00
12"	5/8", 1"		\$240		\$225	\$245	\$21.00
12-1/2"	32 mm						\$24.00
14"	1"		\$375		\$300	\$340	\$24.00
16"	1"				\$450	\$480	\$27.00

The following quantity discounts apply to the above new blades: Excessively dull blades, or blades with broken teeth require re-tooth:

2-5 blades	10% off	11 or more	20% off	Double the sharpening charge (\$45 minimum)
6-10 blades	15% off	Quantity discounts may apply up to 50% off sharpening		

Blade coatings also available: Add \$40 for TiN (mild gold), \$50 for TiCN (hard blue), \$60 for TiALN (stainless auto)

Recommendations for High Speed Steel Cold Saw and Segmental Saw Blades

For Cutting this Material:	Run Blades at this speed:	With these tooth angles:			
Mild Steel	70-160 SFPM	20	Hook	8	Back
Hard Steel	40-65 SFPM	15	Hook	8	Back
Stainless Steel	45-65 SFPM	15	Hook	6	Back
Steel Tubing	65-120 SFPM	15	Hook	8	Back
Cast Steel	30-65 SFPM	15	Hook	8	Back
Cast Iron	66-82 SFPM	12	Hook	8	Back
Copper	800-1300 SFPM	20	Hook	10	Back
Brass	1150-2000 SFPM	14	Hook	8	Back
Bronze	300-1300 SFPM	12	Hook	8	Back
Aluminum	4500-6500 SFPM	24	Hook	12	Back