



*THE PROFESSIONALS' EDGE™*  
[www.simondssaw.com](http://www.simondssaw.com)



*Band Saw Blades*  
**2020/2021**



## *Welcome letter from* **Simonds President**

*Thank you for choosing Simonds.*

*It is our Mission to empower the skilled masters of the metal fabricating industry with cutting edge technologies and the science and knowledge of metal cutting so that you can make great products for your customers.*

*We've been providing industry all over the world with a better way to cut for over 180 years.*

*We are the teachers of the metal cutting industry and we are ready to help you be the best you can be.*

*Our blade products are produced to the highest standards by our 2 world class factories in Melsungen Germany and Louisville Kentucky USA.*

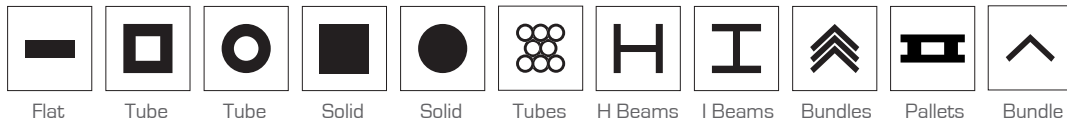
*Thanks again for choosing us.*

*We are excited to have you as a partner.*

A large, semi-transparent portrait of David Miles, the Simonds President, is centered in the lower half of the page. He is a middle-aged man with short brown hair, wearing a suit and tie, and smiling. The background of the entire page is a collage of images: on the left, a woman in a hard hat and safety vest; in the center, a woman in a business suit and glasses; on the right, a man in a suit and glasses. The overall color scheme is a warm, orange-tinted gradient.

**David Miles**  
**President**

<i>History of Simonds 1832-2020</i>	<b>4</b>
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## **CARBIDE BANDSAW BLADE**

<i>Triple Chip</i>	<b>18</b>
<i>QG7</i>	<b>19</b>
<i>TCi22</i>	<b>20</b>
<i>CHM</i>	<b>21</b>
<i>Set Tooth</i>	<b>22</b>

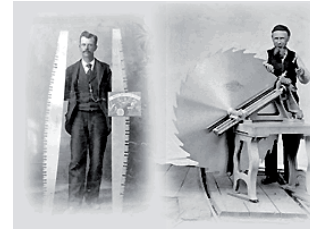
## **BI-METAL BANDSAW BLADE**

<i>Epic GP</i>	<b>24</b>
<i>SBX GP</i>	<b>26</b>
<i>SBX ONE</i>	<b>27</b>
<i>Siclone</i>	<b>28</b>
<i>Siclone XP</i>	<b>29</b>
<i>Pallet Buster</i>	<b>30</b>

## **CARBON BANDSAW BLADE**

<i>Flex Back</i>	<b>32</b>
<i>Wood Max</i>	<b>32</b>
<i>Hard Back</i>	<b>33</b>





## 1832

Abel Simonds opens a small scythe-making shop along the banks of the Nashua River in West Fitchburg – the company operates under the name J.T. Farwell & Company.

Our original products include cutting tools used around the farm.

## 1851

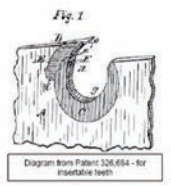
Abel Simonds buys out J. T. Farwell and renames the company A. Simonds & Son.



## 1878

As the agricultural market base moves further west, the mower blade and reaper business is sold off in 1878.

Simonds begins manufacturing circular saw blades and wide bandsaws that same year.



## 1885

George Simonds is granted two patents for his development of inserted tooth saw teeth (bits & shanks) – the design is so effective that it is still in use today, basically unchanged, 125 years later.

## 1841

The young company is awarded its first patent in 1841, #2379, for scythe blades.

### UNITED STATES PATENT OFFICE.

ABEL SIMONDS AND A. G. PAGE, OF FITCHBURG, MASSACHUSETTS.  
MACHINE FOR TURNING OR BENDING THE NECKS OF SCYTHES.  
Specification of Letters Patent No. 2,379, dated December 10, 1841.

To all whom it may concern:  
Be it known that we, ABEL SIMONDS and ALBERT G. PAGE, of Fitchburg, in the county of Middlesex, State of Massachusetts, have invented certain new and useful Improvements in a Machine for turning or bending the necks of scythes, and do hereby declare that the following is a full and exact description of the same, reference being had to the accompanying drawing, in which—

Fig. 1 represents a side view of the machine, and shows the lever A, which is pivoted at its upper end to the frame, and is provided with a handle B, and a curved end C, which is adapted to engage the neck of the scythe, and to depress it, when the force which depresses it is applied to the handle B, and the neck of the scythe is bent to the desired angle.

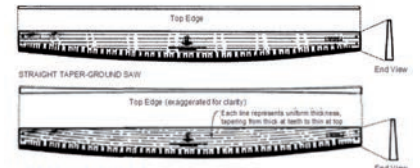
## 1868

Having outgrown the initial premises, in 1868 the company is incorporated as Simonds Mfg. Co., and moves to a new building in downtown Fitchburg.

## 1879

By 1879, Simonds develops an entirely new method of manufacturing saws - the Crescent Ground process - achieving results far superior to any saws made before.

This is the first of many Simonds product innovations.



# History of Simonds 1832-2020



## 1905

In 1905, Simonds enters the file business by purchasing the Fitchburg File Co. - the Red Tang file is born.



## 1915

By 1915, Simonds is the largest saw manufacturer in the world! Our third site, on North Street in downtown Fitchburg, is a sprawling complex.

*During this time, Simonds builds a new steel mill in Lockport, NY, replacing the smaller, earlier mill in Chicago.*

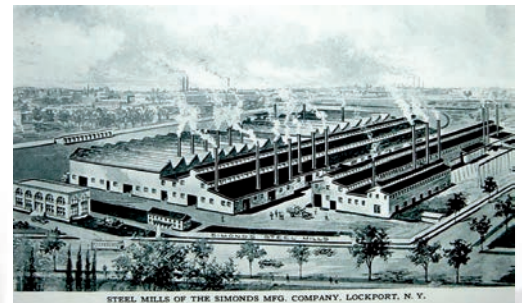
## 1900

To reduce our dependence on foreign steel, a steel mill is added in Chicago in 1900.



## 1923

**In 1923, our name is changed to the Simonds Saw & Steel Company, to better reflect our focus.**



## 1893

Sales into the middle and western parts of the country are so strong, the company decides to build a second factory in Chicago, which opens in 1893.

## 1931

Our current Fitchburg plant is built in 1931 - it is the world's first windowless plant, featuring straight - line production all on one level.

Raw material comes in the back, flows through the plant and leaves the front as finished product.

Even then, we saw the importance of a controlled manufacturing environment.



## 1963

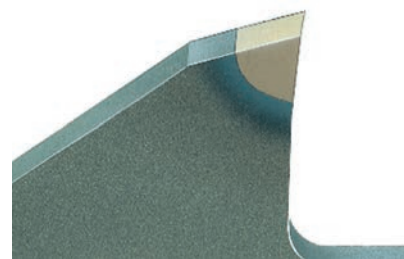
Simonds develops the first carbide tipped bandsaw blade in 1963, based on our carbide tipped circular saw innovations.



## 1955

In 1955, Simonds purchases Heller Bros. - combining our American Pattern range with Heller's Swiss Precision expertise.

The new, larger file company has stood the test of time, and is still a major player in the world market.



## 1965

In 1965, after 133 years of family ownership, Simonds is sold to Wallace Murray - an industrial conglomerate based in New York City.



# History of Simonds 1832-2020



VALUE ADDED CUTTING

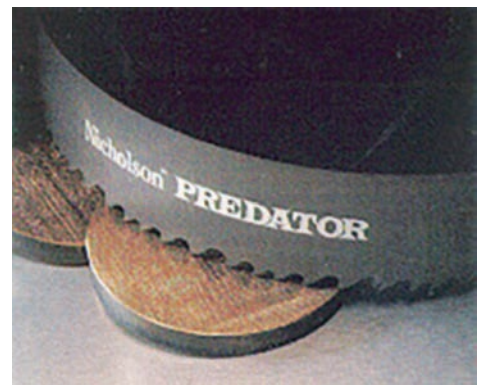


1992

In 1992, Simonds acquires Wespa Metallsagenfabrik GmbH, in Spangenberg, Germany, increasing our European market share.

2001

In January of 2001, the Nicholson bandsaw blade division of CooperTools is purchased, bringing together two storied saw-making traditions.



2004

Simonds develops SineWave technology.



1999

In October of 1999, the hole saw business of Anderson Products is purchased, opening doors in the growing power tool accessory blade market.



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## 2014

### **Wespa Factory Expansion:**

We increased our factory floor space by 70% to increase production capacity.



## 2019

### **Louisville Kentucky Expansion and Carbide production:**

We expanded our Louisville facility by 30% and installed Carbide manufacturing production.



## 2019

### **Wespa Grinding Technology:**

In 2019 we installed new tooth grinding technology into the Melsungen facility.





*History of Simonds*  
**2007 - A Milestone**

WARRANTED

**The Simonds Saw**  
WORKS  
**FITCHBURG, MASSACHUSETTS**  
UNEQUALED U.S.A. UNIFORMITY  
IN QUALITY AND

Since  
**1832**

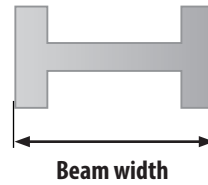
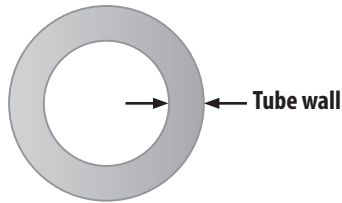
*Simonds celebrates its*  
**175th Anniversary**



**The Simonds Saw**  
WORKS  
**FITCHBURG, MASSACHUSETTS**  
U.S.A.  
UNEQUALED U.S.A. UNIFORMITY  
IN QUALITY AND  
**1832-2007**  
**175th ANNIVERSARY**

Material Group	Materials	CARBIDE		BI-METAL		CARBON
1	Aluminum/Bronze	TCi22	Set Tooth	EpicGP		CARBON
2	Cast Iron					
3	Carbon Steels			EpicGP	SBXGP	
4	Structural Steels			SBXGP	SBXONE	
5	Low Alloy Steels			EpicGP	SiClone	
6	Medium Alloy Steels/ Cr Mo	QG7		EpicGP	SiClone	
7	High Alloy Steels	QG7		SiClone	SiCloneXP	
8	Tool and Die Steels	QG7		SiClone	SiCloneXP	
9	Stainless Steel	QG7		SiClone	SiCloneXP	
10	Nickel Based Alloys	Triple Chip		SiClone	SiCloneXP	
11	Titanium & Titanium Alloys	TCi22		SiClone	SiCloneXP	
12	High Nickel Alloys	Triple Chip			SiCloneXP	
13	Exotic Metals	Triple Chip				
14	Induction Hardened Steels	CHM				
15	Carbon Fiber/ Graphite	Set Tooth				
16	Wood/Plastic			PalletBuster	EpicGP	CARBON

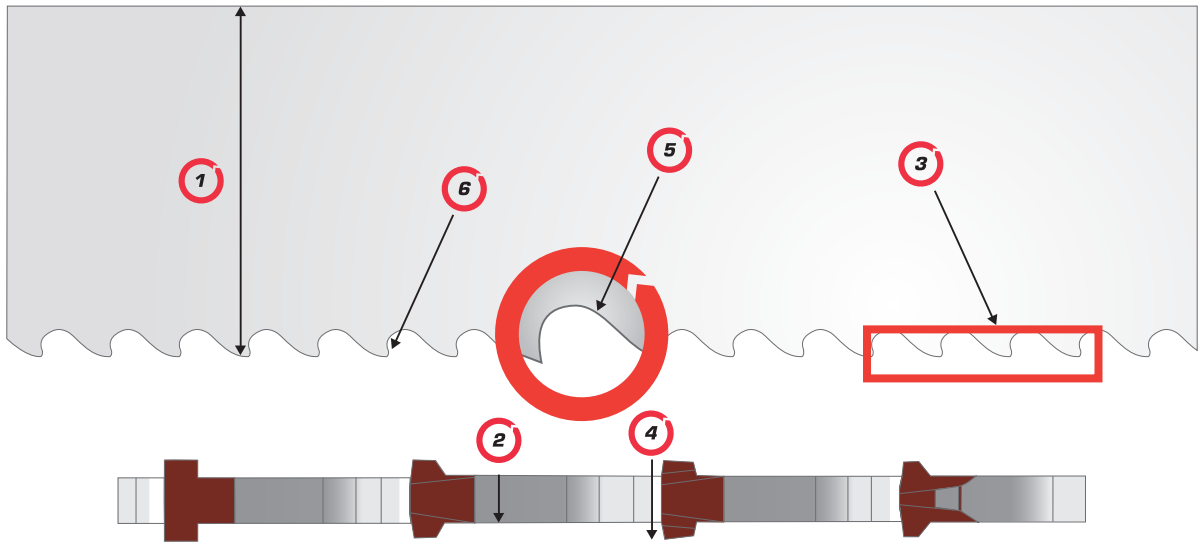
<b>Epic<sup>®</sup>GP</b>							<b>SBXGP</b>						<b>SBXONE<sup>™</sup></b>			
Tube wall	10/14	8/12	6/10	5/8	4/6	3/4	12/16	8/11	6/9	5/7	4/6	3/4	4/6	3/4	2/3	
1/16"	*						*									
1/8"	*	*					*	*								
1/4"		*	*					*	*							
1/2"				*	*				*	*						
3/4"					*	*					*	*				
1"					*	*					*	*				
Beam width												4/6	3/4	4/6	3/4	2/3
< 6"											*	*	*			
6" - 8"												*	*	*		
8" - 12"													*	*	*	
12"+															*	



Note: if cutting more than one piece, add wall thicknesses.

<b>Epic<sup>®</sup>GP   SiClone<sup>®</sup>   SiClone<sup>®</sup>XP</b>								<b>CARBIDE</b>					
Solids	5/8	4/6	3/4	2/3	1.4/2	1.1/1.4	0.7/0.9	2.5/3.5	2/3	1.9/2.1	1.4/1.8	1.0/1.2	0.9/1.1
1"	*	*						*					
2"		*	*					*					
4"			*	*				*	*				
6"			*	*					*				
8"				*					*				
10"				*	*				*	*			
12"				*	*					*	*		
16"					*					*	*		
20"					*	*					*		
24"					*	*					*	*	
30"						*	*					*	*
36"+						*	*						*





**1 Width**

The Dimension Of A Saw Blade As Measured From The Tip Of The Tooth To The Back Of The Band.

**2 Thickness**

Measurement Of Side To Side.

**3 TPI (Teeth per inch)**

The Number Of Teeth Per Inch As Measured From Gullet To Gullet.

**4 Kerf**

The Amount Of Material removed By The Cut Of The Blade.

**5 Gullet**

The Curved Area At The Base Of The Tooth.

**6 Tooth Face**

The Surface Of The Tooth On Which The Chip Is Formed.

## Breaking In A New Blade

### Why Is **Break-in** Important?

- New teeth are more fragile than honed teeth.
- Eliminates premature tooth edge fracturing.
- Break-in improves overall blade life and cut finish.

### Reduce **Feed Rate**

- By 20% to 50% depending on material machinability. (Softer material requires a higher feed rate reduction).
- Small adjustments to blade speed or feed rate may be necessary if noise or vibration occurs.
- Gradually increase feed rate until normal cutting rate is achieved.

**For additional assistance please contact your local Simonds Representative**



## *Blade Selection*

- Material Type.
- Material Shape.
- Bi-Metal or Carbide.
- Tooth Pitch.
- Specialty Options.

## *Machine Condition*

- **Wheels >**  
Check alignment, bearings, flanges.
- **Guides >**  
Should support the band without excessive pressure being applied.
- **Guide Arms >**  
Should be as close to the work as possible for support.
- **Brushes >**  
Align brush to bottom of Gullet.
- **Cutting Fluid >**  
Check Flow and Ratio.  
Ex. Between 10 - 15%

## *Machine Setup*

- **Band Tension >**  
Between 25,000/40,000 psi  
\*dependent upon width.
- **Break-In Procedure >**  
See page 12.
- **Cutting Parameters >**  
See App and Page 14-15.



Material	Type	Grade	Up to 1"		From 1" - 3"		From 3" - 6"		Over 6"	
			Blade Speed (SFPM)	Cutting Rate (SPIM)	Blade Speed (SFPM)	Cutting Rate (SPIM)	Blade Speed (SFPM)	Cutting Rate (SPIM)	Blade Speed (SFPM)	Cutting Rate (SPIM)
Aluminum Bronze	Aluminum Alloys	2024 - 5052 - 6061 - 7075	300	9-13	300	9-13	300	9-13	300	9-13
	Copper Alloys	Beryllium Copper	190	4-8	180	4-8	170	3-6	200	3-6
		CDA 220	225	7-10	200	6-10	200	6-10	200	5-9
		CDA 360	310	12-14	295	11-14	285	11-14	270	10-13
		Copper Nickle (30%)	215	6-10	215	6-10	200	5-9	190	4-8
Bronze Alloys	AMPCO 18	210	6-10	190	6-10	180	6-10	170	6-10	
	AMPCO 21	180	5-7	170	5-7	170	5-7	160	5-7	
	AMPCO 25	130	3-5	120	3-5	110	3-5	100	2-4	
	Aluminum Bronze	150	5-9	140	5-9	130	4-8	120	3-7	
	Leaded Tin Bronze	330	11-16	310	11-16	295	11-16	275	8-12	
	Manganese Bronze	220	8-12	210	8-12	200	7-11	180	9-11	
Brass Alloys	932	310	9-13	300	9-13	285	11-12	265	7-11	
	937	260	9-13	240	9-13	230	6-10	220	7-11	
Cartridge/Red Brass (85%) Naval Brass		300	9-13	300	9-13	300	9-13	300	9-13	
		300	9-13	300	9-13	300	9-13	300	9-13	
Cast Iron	Grey Cast Iron	A48 (Class 20)	225	4-8	190	4-8	180	4-8	170	4-8
		A48 (Class 40)	160	4-8	150	4-8	135	4-8	120	4-8
		A48 (Class 60)	150	4-8	135	4-8	120	4-8	100	4-8
Ductile Cast Iron	A536 (60-40-18)	200	4-8	190	4-8	180	4-8	170	4-8	
A536 (120-90-02)	150	4-8	135	4-8	120	4-8	100	4-8		
Carbon Steels	Low Carbon Steels	1008-1013	250	8-10	275	9-12	280	12-15	250	9-12
		1015-1018	250	8-10	275	9-12	250	12-15	230	9-12
		1048-1065	200	5-7	200	5-7	175	8-10	150	6-8
		1065-1095	200	4-6	200	5-7	150	6-8	120	6-8
	Free Machining Steels	1108-1111	300	9-11	330	12-14	275	13-15	220	11-14
1112-1113		300	8-11	330	11-13	275	12-15	220	12-10	
1115-1132		300	7-10	330	10-13	275	13-16	220	11-14	
1137-1151		275	6-8	250	8-10	250	8-11	200	7-10	
1212-1213		300	8-10	320	11-13	300	13-15	255	11-14	
Structural Steels	Structural Steels	A-36	275	11-15	250	11-15	250	11-15	225	9-13
Low Alloy Steels	Molybdenum Steels	4017-4024	300	3-5	270	4-7	250	6-8	220	5-8
		4032-4042	300	3-5	270	4-7	250	6-8	230	5-8
		4047-4068	250	3-5	220	4-6	200	5-7	180	3-5
Nickel Moly Steels	4608-4621	250	3-5	220	5-6	220	6-7	200	5-6	
	4640	220	3-5	200	4-6	200	5-7	170	4-6	
4812-4820	200	3-5	180	3-5	180	4-6	160	4-5		
Medium Alloy Steels/Cr Mo	Manganese Steels	1320-1330	250	5-7	250	5-8	200	8-11	175	7-10
		1335-1345	250	5-7	225	5-7	200	7-9	175	5-8
	Chrome Moly Steels	4130-4140	280	4-6	250	5-8	250	8-10	220	6-8
		4142-4150	230	3-5	200	4-6	200	5-7	170	4-6
	Nickel Chrome Moly Steels	4317-4320	250	3-5	225	4-6	200	5-7	170	4-6
		4337-4340	230	3-4	200	4-5	200	4-6	170	4-5
		8615-8627	250	4-5	230	6-7	230	6-8	200	6-7
		8630-8645	250	3-5	230	4-6	230	5-7	180	4-6
		8647-8660	220	2-4	200	3-5	200	4-6	150	3-5
		8715-8750	250	3-5	220	4-6	220	5-7	180	4-6
		9310-9317	200	1-3	160	2-3	160	2-4	150	2-3
		9437-9445	250	4-5	230	4-5	230	5-6	180	4-5
		9747-9763	250	2-4	230	3-5	200	4-6	180	3-5
9840-9850	240	4-5	220	4-6	200	5-7	180	4-6		
Chrome Steels	5045-5046	280	4-6	250	5-7	250	8-10	200	7-8	
	5120-5135	280	4-6	250	6-7	240	7-8	180	5-8	
	5140-5150	250	3-5	230	4-6	230	5-7	200	4-6	
	50100-52100	180	2-4	160	3-5	150	4-6	100	3-5	



# Speed And Feed **Chart**

Material	Type	Grade	Up to 1"		From 1" - 3"		From 3" - 6"		Over 6"	
			Blade Speed (SFPM)	Cutting Rate (SPIM)	Blade Speed (SFPM)	Cutting Rate (SPIM)	Blade Speed (SFPM)	Cutting Rate (SPIM)	Blade Speed (SFPM)	Cutting Rate (SPIM)
Tool and Die Steels	Die Steels	A-2	210	2-3	200	3-4	190	3-4	180	2-3
		D-2 - D-3	110	1-2	100	1-2	90	1-2	80	1-2
		D-7	90	1	80	1	70	1	70	1
		0-1 - 0-2	240	3-4	210	4-5	190	5-6	170	4-5
		0-6	230	3-4	200	4-6	180	5-7	150	4-6
Tool and Die Steels	High Speed Tool Steels	T-1 - T-2	130	1-2	110	2-3	100	2-4	90	2-3
		T-4 - T-5	110	1-2	100	1-2	90	2-3	80	1-2
		T-6 - T-8	110	1-2	100	1-2	80	1-2	70	1-2
		T-15	80	1	80	1	70	1	50	1
		M-1	150	2-4	140	2-4	130	3-5	110	2-4
		M-2 - M3	120	2-3	110	2-3	100	3-4	80	2-3
		M-4 - M-10	100	1-2	90	1-2	80	1-3	60	1-2
Tool and Die Steels	Hot Work Steels	H-12 - H-13 - H-21	150	2-4	125	3-5	125	2-4	125	2-4
		H-22 - H-24 - H-25	150	1-3	125	1-3	125	1-3	125	1-3
Tool and Die Steels	Shock Resistant Steels	S-1	220	3-5	180	3-5	165	3-5	150	2-4
		S-2 - S-5	170	2-4	150	2-4	120	2-4	100	1-3
Stainless Steel	Austenitic	201 - 202 - 302 - 304	120	2-4	100	3-4	100	2-4	100	1-3
		303 - 303F	140	2-4	120	2-4	100	2-4	100	2-4
		308 - 309 - 310 - 330	90	1	70	1	60	1	60	1
		314 - 316 - 317	90	1	80	1	70	1	60	1
		321 - 347	130	1-3	110	1-3	100	1-3	80	1-3
Stainless Steel	Ferritic	430	100	1-3	90	2-4	80	2-4	80	1-3
		430F	200	3-5	180	4-6	170	5-7	150	4-6
Stainless Steel	Martensitic	410 - 420 - 420F	150	1-3	130	1-3	120	2-4	100	1-3
		416	200	3-5	180	4-6	170	5-7	150	4-6
		440A - 440B - 440C	120	1-3	100	1-3	90	2-4	70	1-3
Stainless Steel	Precipitation Hardened	15-5PH - 17-4PH	100	2-3	90	2-4	80	3-4	80	2-3
Nickel Based Alloys	Nickel Alloys	Monel	100	1-2	100	1-2	80	1-2	60	1
		Monel R	140	2-3	140	2-4	125	2-4	75	2-3
		Monel K	100	1	80	1	60	1	60	1
		Monel KR	100	1-3	90	1-3	80	1-3	60	1-2
Nickel Based Alloys	Nickel Based Alloys	Inconel	110	1-2	100	1-3	80	1-3	80	1-2
		Inconel X	90	1	80	1	70	1	60	1
		Hastelloy A	120	1-2	100	1-2	85	2-3	75	1-2
		Hastelloy B	110	0-1	100	1-2	90	1-2	75	0-1
		Hastelloy C	100	0-1	90	0-1	70	0-1	60	0-1
		Rene 41	90	1	90	1	90	1-2	90	1-2
		Waspalloy	90	1	90	1-2	90	1-2	90	1-2
Titanium & Titanium Alloys	Titanium	CP Titanium	100	0-1	90	0-1	80	0-1	70	0-1
		6-Al-4V	100	0-1	80	0-1	70	0-1	60	0-1

## **Bandsaw Blade APP 1.0**



- **Calculator for Metric and Imperial.**
- **Calculator for Solid, Tube and Beams.**
- **International Steel Grade.**
- **Tooth Pitch Recommendation.**
- **Sinewave<sup>®</sup> Calculator.**

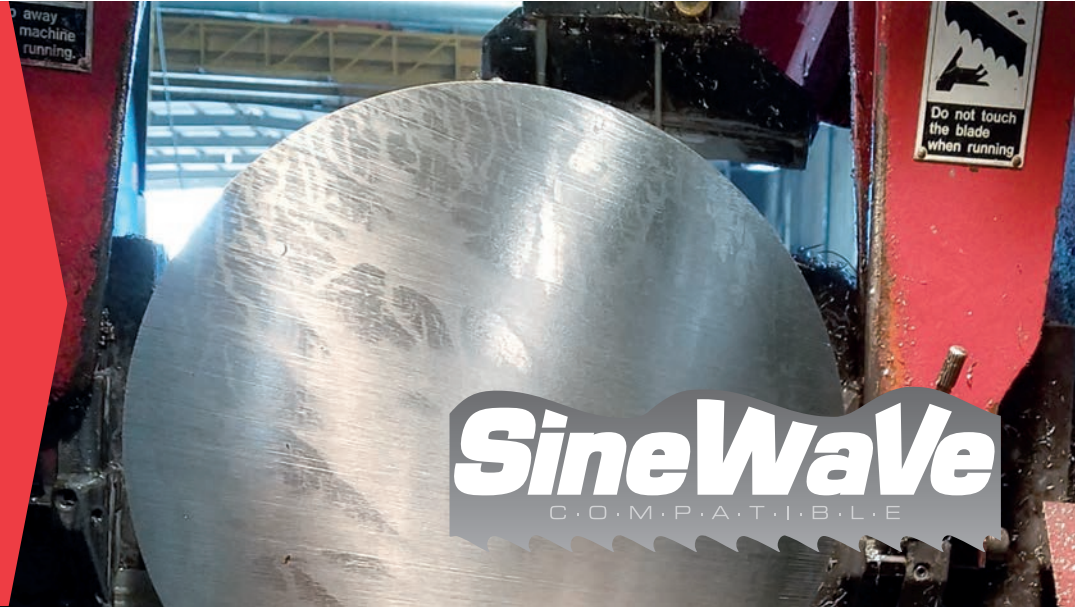
Compatibility: iOS, Android



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www.simondssaw.com

## How does **SineWave®** Work?

**SineWave®** technology from **Simonds Saw** provides an aggressive broaching action in the cut, enhancing cutting ability, reducing work time and increasing blade life. It incorporates a series of ramps on the back edge of bandsaw blades, which allows bandsaw machines to exert more force into a cut without increasing machine pressure.



The rocking motion of SineWave ensures less tooth contact within the work piece, which increases penetration for faster cutting.

Ramp depth and length can be engineered to a customer's specific cutting applications, operating parameters and production requirements to optimize performance across a wide variety of materials.



## Special Applications Technology

**SineWave®** technology provides ramp customization capabilities to optimize the cutting performance of specific alloy cross sections.

SineWave® can be supplied on all bi-metal and all carbide tipped bandsaw blades from 1" to 3-1/8".

SineWave® is supplied only in welded-to-length bands.

## How Do I Order SineWave?

- Determine maximum cross-section dimension of all materials cut.
- Determine your required aggressiveness of the cutting action - light, moderate or aggressive.
- Call your Simonds sales person for applications assistance.

**Application specific, contact your Simonds Representative.**

## SineWave Advantages

- Cuts work hardened materials 30-40% faster – keep.
- Increased Blade Life.
- A more consistent cutting rate.
- Ideal for use on difficult to cut alloys.

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***CARBIDE  
BANDSAW BLADE***





# Triple Chip

## ADVANTAGES

- Triple Chip geometry provides a smooth surface finish.
- Positive rake angle allows faster penetration for high production cutting.

## APPLICATIONS GROUPS

- 10 Nickel Based Alloys.
- 12 High Nickel Alloys.
- 13 Exotic Metals.



CARBIDE CUTTING ITEM CLASS 55



Width x Thickness		Teeth per inch				
inch	mm	2.5/3.5	2/3	1.9/2.1	1.4/1.8	0.9/1.1
1" x 035	27 x 0.90	55801105				
1 1/4" x 042	34 x 1.10	55801208				
1 1/2" x 050	41 x 1.30	55803458	55803700	55803308		
2" x 063	54 x 1.60	55804808	55804708	55804508	55804008	
2 5/8" x 063	67 x 1.60				55805808	55805308
3 1/8" x 063	80 x 1.60					55808008

Solids	2.5/3.5	2/3	1.9/2.1	1.4/1.8	0.9/1.1
1"	*				
2"	*				
4"	*	*			
6"		*			
8"		*			
10"		*	*		
12"			*	*	
16"			*	*	
20"				*	
24"				*	*
30"					*
36"+					*





**QG7**

**ADVANTAGES**

- Multi-chip design provides higher penetration for faster cutting rates.
- New gullet design provides for better chip flow.

**APPLICATIONS GROUPS**

- 6 Medium Alloy Steels/Cr Mo.
- 7 High Alloy Steels.
- 8 Tool and Die Steels.
- 9 Stainless Steel.

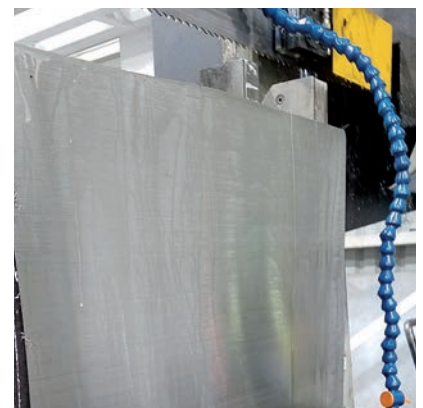


**CARBIDE CUTTING ITEM CLASS 55**



Width x Thickness		Teeth per inch				
inch	mm	2/3	1.9/2.1	1.4/1.8	1.0/1.2	0.9/1.1
1 1/2" x 050	41 x 1.30	55741400	55741500			
2" x 063	54 x 1.60	55754400	55754500	55754600		
2 5/8" x 063	67 x 1.60		55767500	55767600		55767800
3 1/8" x 063	80 x 1.60				55780700	

Solids	2/3	1.9/2.1	1.4/1.8	1.0/1.2	0.9/1.1
1"	*				
2"	*				
4"	*				
6"	*				
8"	*				
10"	*	*			
12"		*	*		
16"		*	*		
20"			*		
24"			*	*	
30"				*	*
36"+					*



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**ADVANTAGES**

- New carbide technology to resist abrasive wear.
- Multi-chip design provides higher penetration for faster cutting rates.

**APPLICATIONS GROUPS**

- ① Aluminum/Bronze.
- ⑪ Titanium & Titanium Alloys.



CARBIDE CUTTING ITEM CLASS 55



Width x Thickness		Teeth per inch			
inch	mm	2/3	1.9/2.1	1.4/2.0	1.0/1.2
1 1/2" x 050	41 x 1.30	55241400	55241500	55241600	55241700
2" x 063	54 x 1.60	55254400	55254500	55254600	55254700
2 5/8" x 063	67 x 1.60			55267600	55267700
3 1/8" x 063	80 x 1.60				55280700

Solids	2/3	1.9/2.1	1.4/2.0	1.0/1.2
1"				
2"				
4"	*			
6"	*			
8"	*			
10"	*	*		
12"		*	*	
16"		*	*	
20"			*	
24"			*	*
30"				*
36" +				





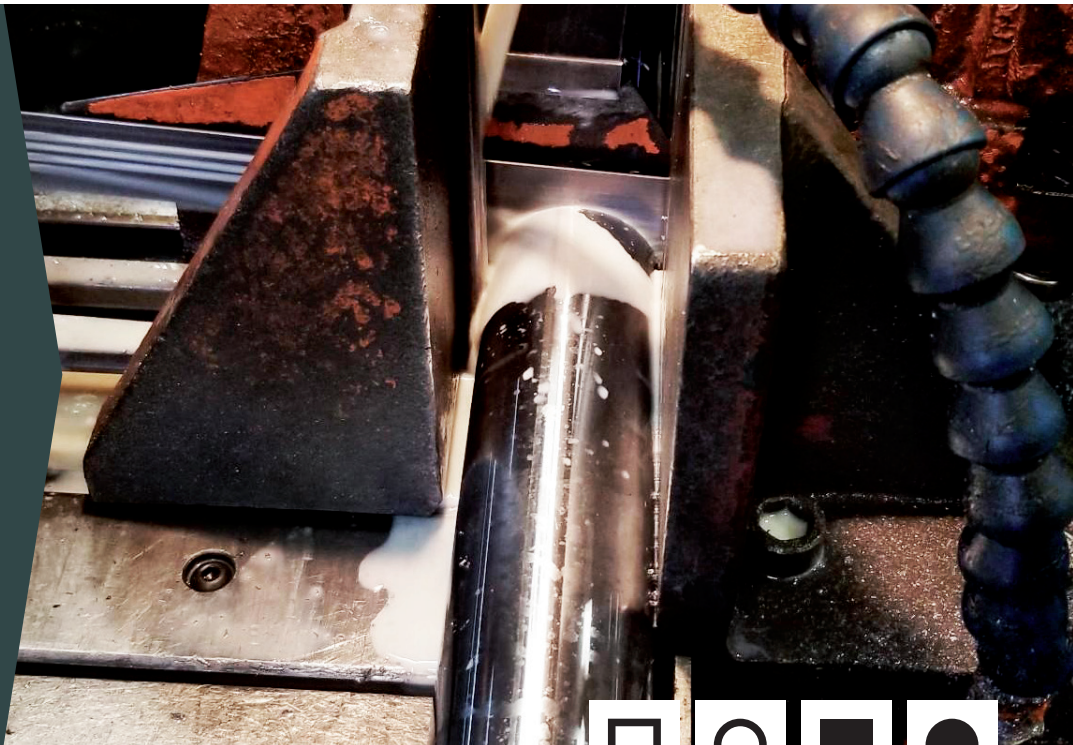


**ADVANTAGES**

- Triple Chip geometry provides a smooth surface finish.
- Tooth Geometry allows for less vibration on induction hardened materials.

**APPLICATIONS GROUPS**

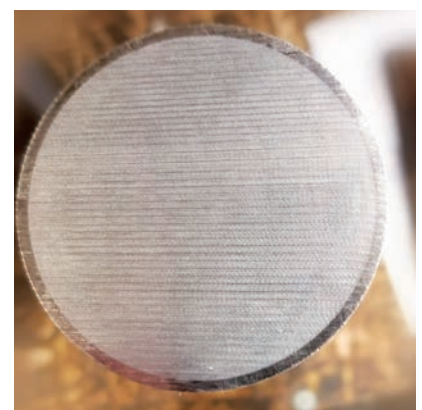
- 14 Induction Hardened Steels.



**CARBIDE CUTTING** ITEM CLASS 55



Width x Thickness		Teeth per inch
inch	mm	2.5/3.5
1 1/2" x 050	41 x 1.30	55803608
2" x 063	54 x 1.60	55804908
2 5/8" x 063	67 x 1.60	55805908



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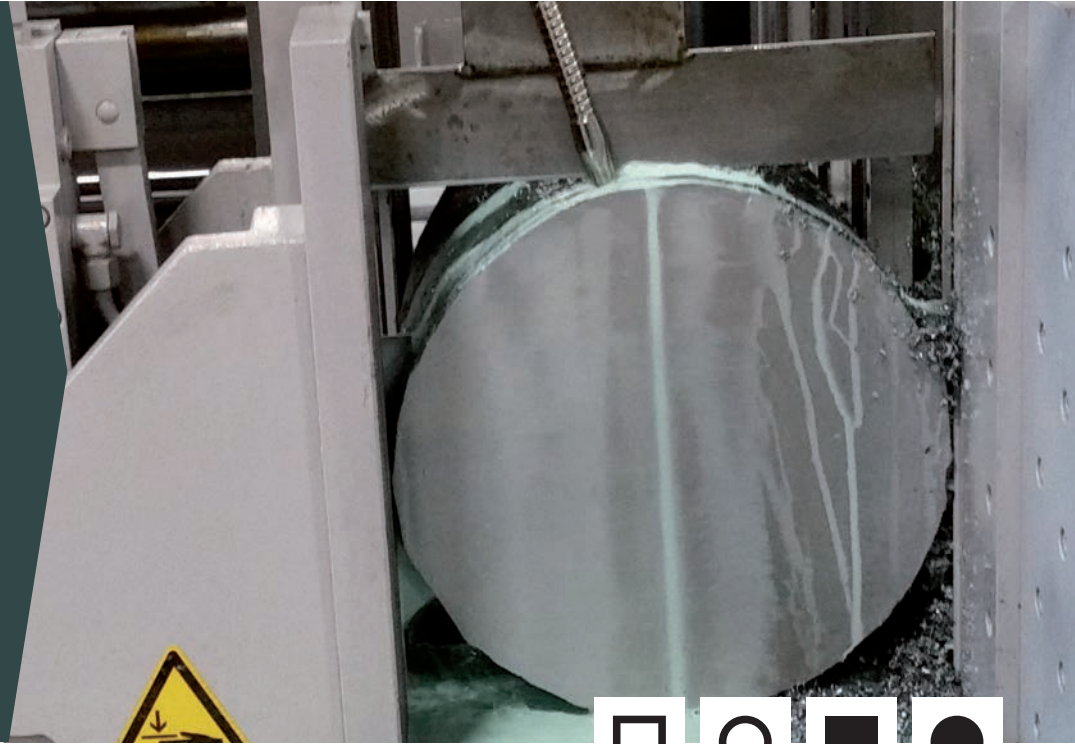
# Set Tooth

## ADVANTAGES

- Three tooth pattern with raker ensures straighter cuts.
- Designed for both manual and automatic bandsaws.

## APPLICATIONS GROUPS

- 1 Aluminum/Bronze.
- 15 Carbon Fiber/Graphite.



**CARBIDE CUTTING** ITEM CLASS 55



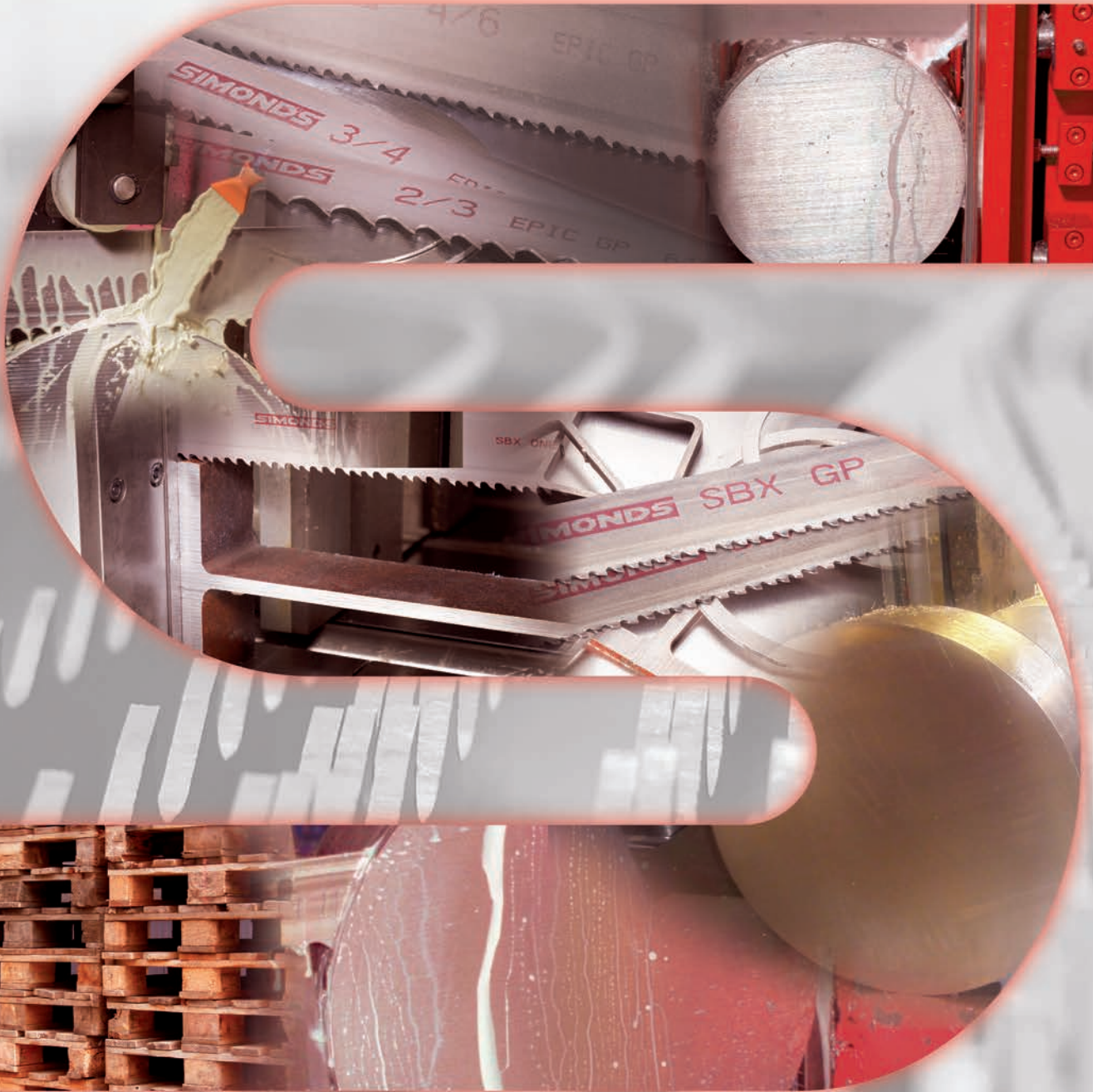
Width x Thickness		Teeth per inch	
inch	mm	3	2/3
3/4" x 035	20 x 0.90	55400100	55200203
1" x 035	27 x 0.90	55400600	55270203
1 1/4" x 042	34 x 1.10	55500600	55340203





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**BI-METAL  
BANDSAW BLADE**





**ADVANTAGES**

- M42 high speed edge improves wear resistance in all-purpose applications.
- Conventional tooth geometry.

**APPLICATIONS GROUPS**

- 1 Aluminum/Bronze.
- 3 Carbon Steels.
- 5 Low Alloy Steels.
- 6 Medium Alloy Steels/Cr Mo.



Width x Thickness		Teeth per inch						
inch	mm	14	10/14	10	8/12	6/10	6	4
1/4" x 035	6 x 0.90			64060010			64060006	
3/8" x 035	10 x 0.90			64100010			64100006	64100004
1/2" x 025	13 x 0.65	62130014	62131014	62130010				
1/2" x 035	13 x 0.90		64131014		64130812	64130610		
3/4" x 035	20 x 0.90		64201014			64200610	64200006	
1" x 035	27 x 0.90		64271014		64270812	64270610		64270004

Tube wall	10/14	8/12	6/10	5/8	4/6	3/4
1/16"	*					
1/8"	*	*				
1/4"		*	*			
1/2"				*	*	
3/4"					*	*
1"					*	*



SAFETY  
GLASSES/GLOVES



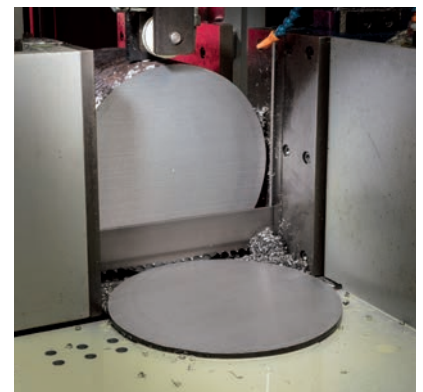
**STANDARD BI-METAL** ITEM CLASS 64

**Width x Thickness**

**Teeth per inch**

inch	mm	5/8	4/6	3/4	2/3	1.4/2	1.1/1.4	0.75/1.25	1.25
1" x 035	27 x 0.90	64270508	64270406	64270304	64270203				
1 1/4" x 042	34 x 1.10	64340508	64340406	64340304	64340203	64341402			64340125
1 1/2" x 050	41 x 1.30	64410508	64410406	64410304	64410203	64411402			64410125
2" x 063	54 x 1.60		64540406	64540304	64540203	64541402	64541114	64547512	64540125
2 5/8" x 063	67 x 1.60		64670406	64670304	64670203	64671402	64671114	64677512	
3 1/8" x 063	80 x 1.60					64801402	64801114	64807512	

Solids	5/8	4/6	3/4	2/3	1.4/2	1.1/1.4	0.75/1.25
1"	*	*					
2"		*	*				
4"			*	*			
6"			*	*			
8"				*			
10"				*	*		
12"				*	*		
16"					*		
20"					*	*	
24"					*	*	
30"						*	*
36"+						*	*



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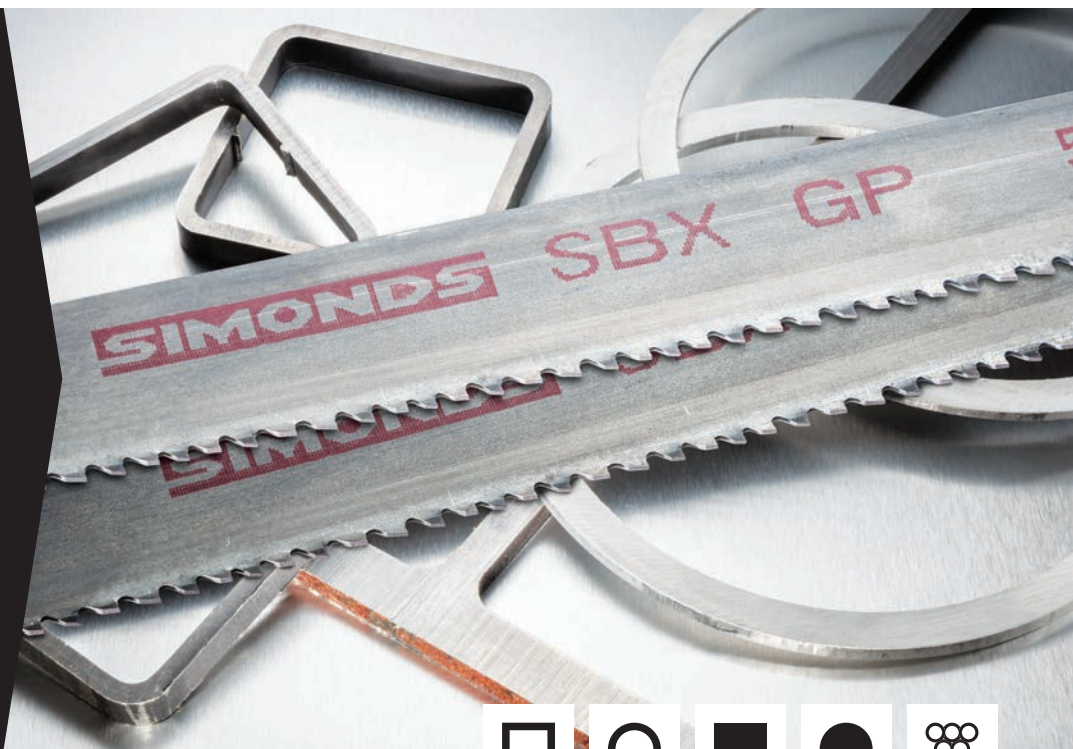


**ADVANTAGES**

- Robust tooth design improves resistance to shock for all-purpose applications.
- Wide range of tooth pitches for multiple applications.

**APPLICATIONS GROUPS**

- 3 Carbon Steels.
- 4 Structural Steels.



STANDARD BI-METAL ITEM CLASS 68

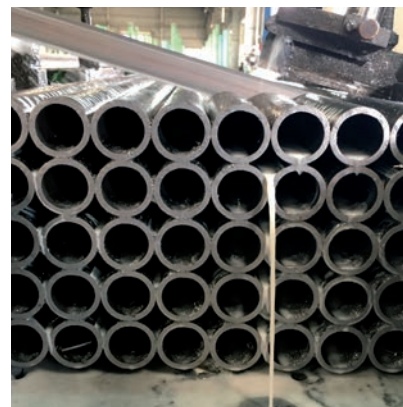


Width x Thickness		Teeth per inch				
inch	mm	8/11	6/9	5/7	4/6	3/4
3/4" x 035	20 x 0.90	68200811	68200609	68200507	68200406	
1" x 035	27 x 0.90	68270811	68270609	68270507	68270406	68270304
1 1/4" x 042	34 x 1.10	68340811	68340609	68340507	68340406	68340304

Tube wall	8/11	6/9	5/7	4/6	3/4
1/16"					
1/8"	*				
1/4"	*	*			
1/2"			*	*	
3/4"				*	*
1"				*	*

Beam width	8/11	6/9	5/7	4/6	3/4
<6"				*	*
6"- 8"					*
8"- 12"					
12"+					







**ADVANTAGES**

- Robust tooth design improves resistance to shock in beam cutting.
- Extra heavy set prevents pinching.

**APPLICATIONS GROUPS**

**4** Structural Steels.



**STANDARD BI-METAL ITEM CLASS 68**



Width x Thickness		Teeth per inch			
inch	mm	4/6	3/4	2/3	1.4/2
1-1/2" x 050	41 x 1.30	68410406	68410304	68410203	
2" x 063	54 x 1.60	68540406	68540304	68540203	
2 5/8" x 063	67 x 1.60		68670304	68670203	
3 1/8" x 063	80 x 1.60		68800304	68800203	68801402

Beam width	4/6	3/4	2/3	1.4/2
<6"	*			
6" - 8"	*	*		
8" - 12"		*	*	
12"+			*	*



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**ADVANTAGES**

- Special tooth geometry to increase penetration and reduce work hardening.
- Variable set to increase productivity.

**APPLICATIONS GROUPS**

- 7 High Alloy Steels.
- 8 Tool and Die Steels.
- 9 Stainless Steel.
- 10 Nickel Based Alloys.
- 11 Titanium & Titanium Alloys.



**SPECIAL BI-METAL ITEM CLASS 63**



Width x Thickness		Teeth per inch					
inch	mm	4/6	3/4	2/3	1.4/2	1.1/1.4	0.7/9
1" x 035	27 x 0.90	63544327	63543757	63542007			
1 1/4" x 042	34 x 1.10	63550107	63549607	63549007			
1 1/2" x 050	41 x 1.30		63552607	63552007	63551107		
2" x 063	54 x 1.60		63556507	63556007	63555007	63554107	
2 5/8" x 063	67 x 1.60				63558007	63557107	63568007
3 1/8" x 063	80 x 1.60					63559107	63569007

Solids	4/6	3/4	2/3	1.4/2	1.1/1.4	0,7/9
1"	*					
2"	*	*				
4"		*	*			
6"		*	*			
8"			*			
10"			*	*		
12"			*	*		
16"				*		
20"				*	*	
24"				*	*	
30"					*	*
36"+					*	*





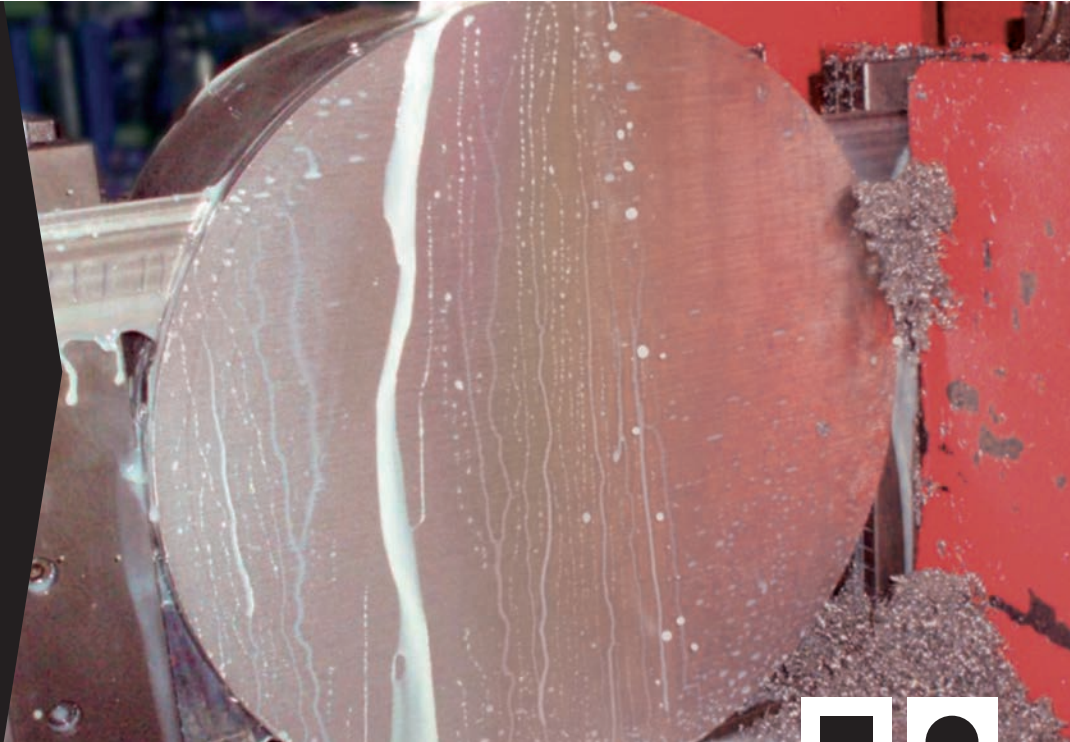
# SiClone<sup>®</sup>XP

## ADVANTAGES

- Powdered metal technology to increase wear resistance.
- Special tooth geometry to increase penetration and reduce work hardening.

## APPLICATIONS GROUPS

- 7 High Alloy Steels.
- 8 Tool and Die Steels.
- 9 Stainless Steel.
- 10 Nickel Based Alloys.
- 11 Titanium & Titanium Alloys.
- 12 High Nickel Alloys.

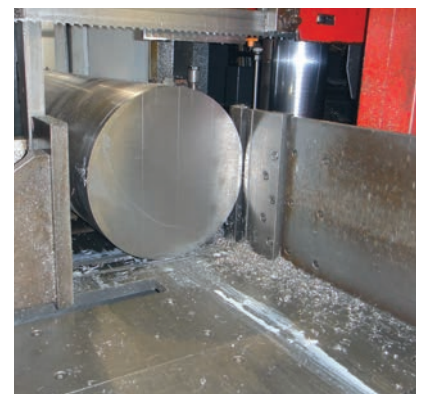


**SPECIAL BI-METAL ITEM CLASS 67**



Width x Thickness		Teeth per inch					
inch	mm	4/6	3/4	2/3	1.4/2	1.1/1.4	0.7/9
1" x 035	27 x 0.90	67270406	67270304				
1 1/4" x 042	34 x 1.10	67340406	67340304				
1 1/2" x 050	41 x 1.30			67410203	64411402		
2" x 063	54 x 1.60		67540304	67540203	67541402	67541114	
2 5/8" x 063	67 x 1.60				67671402	67671114	67670709
3 1/8" x 063	80 x 1.60					67801114	67800709

Solids	4/6	3/4	2/3	1.4/2	1.1/1.4	0,7/9
1"	*					
2"	*	*				
4"		*	*			
6"		*	*			
8"			*			
10"			*	*		
12"			*	*		
16"				*		
20"				*	*	
24"				*	*	
30"					*	*
36"+					*	*



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# PalletBuster®

## ADVANTAGES

- Robust tooth design for increased shock resistance.
- Flexible backer.

## APPLICATIONS GROUPS

**16** Wood/Plastic.



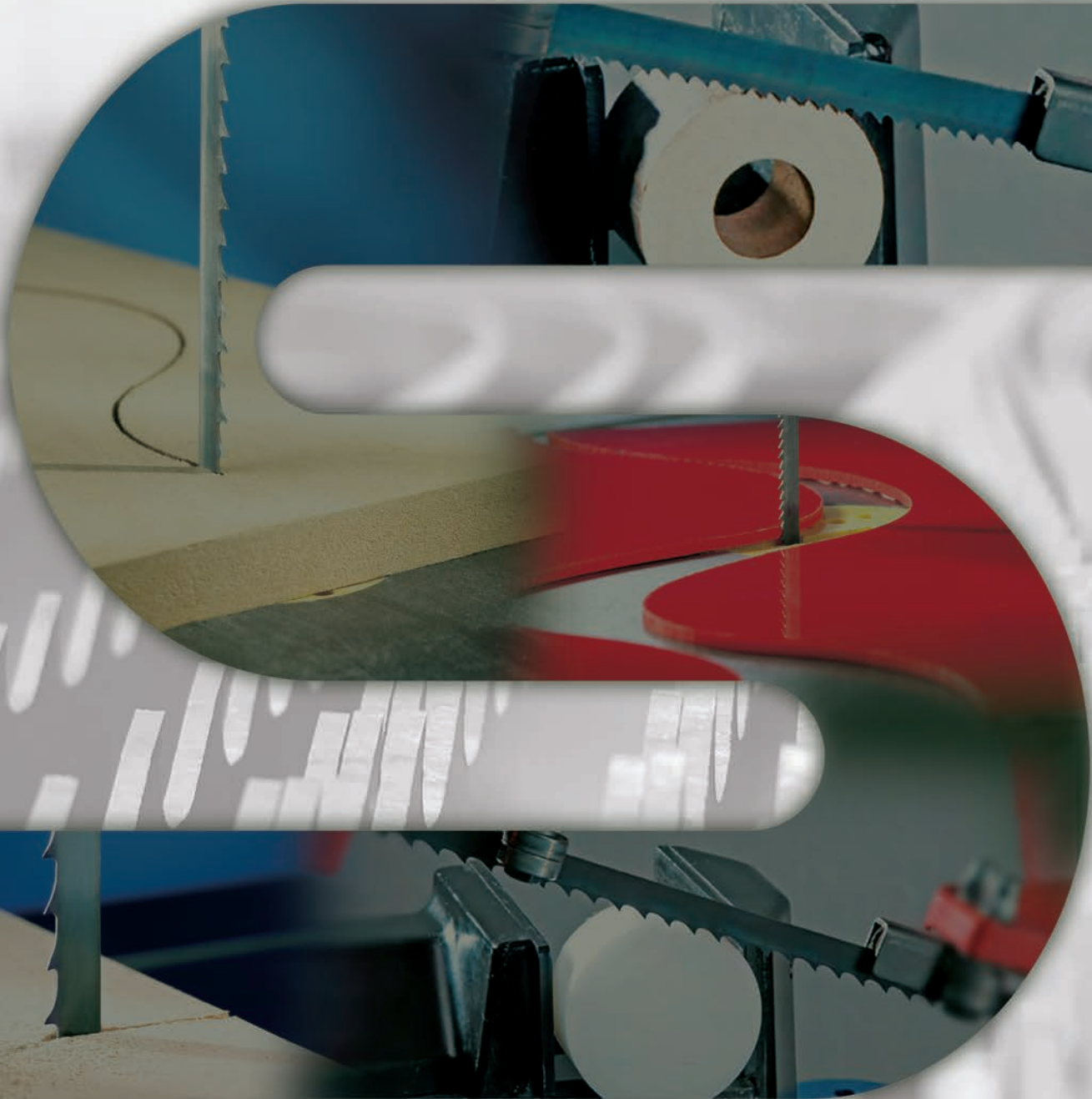
**SPECIAL BI-METAL** ITEM CLASS 64

Width x Thickness			Teeth per inch
inch	mm		5/8
1 1/4" x 042	34 x 1.10	<b>Coils</b>	64371527
1 1/4" x 042	34 x 1.10	<b>Bulk Packs</b>	643715N7



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***CARBON  
BANDSAW BLADE***



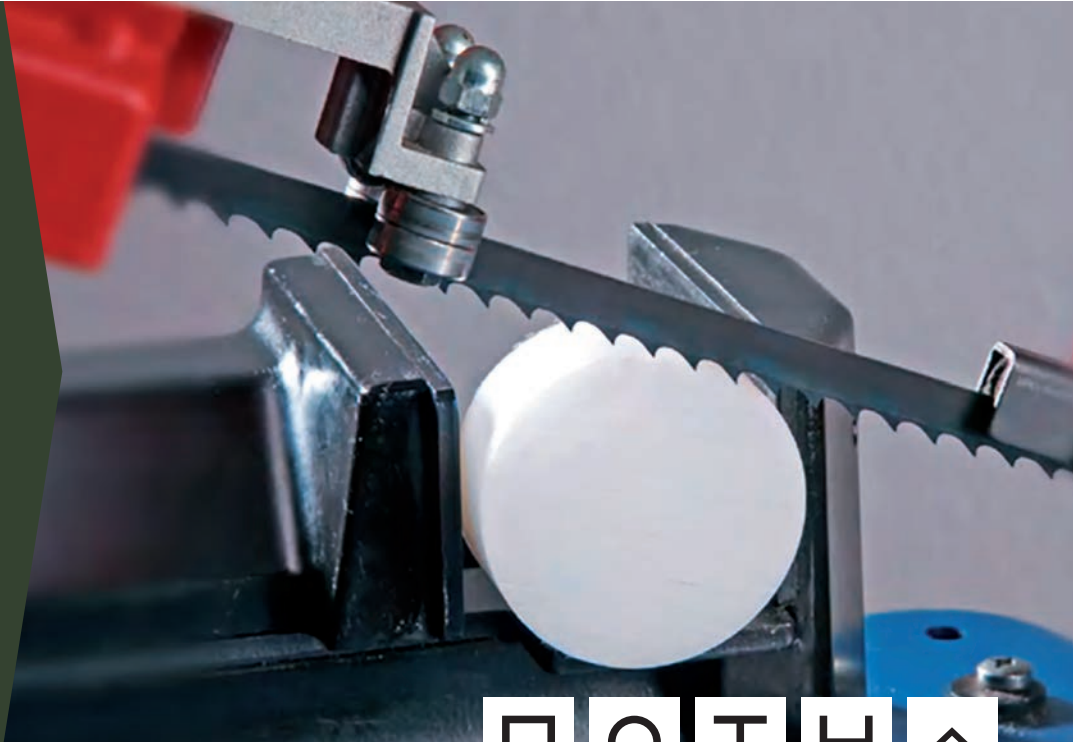
# Flex Back

### ADVANTAGES

- Hardened tooth tip prolongs cutting edge life.
- Flexible back extends the flex life of the blade.
- Raker set provides straighter cuts.

### APPLICATIONS GROUPS

- 1 Aluminum/Bronze.
- 16 Wood/Plastic.



CARBON CUTTING ITEM CLASS 37



Width x Thickness		Teeth per inch							
inch	mm	24	18	14	10	8	6	6 sab	4 sab
1/4" x 025	6 x 0.60		37390000	37388000	37382000			37379000	37373000
3/8" x 025	10 x 0.60		37425000	37421000	37418000			37412000	37409000
1/2" x 025	13 x 0.60	37469000	37466000	37460000	37454000		37451000	37448000	37445000
3/4" x 032	20 x 0.80			37529000	37517000	37511000	37508000	37505000	
1" x 035	27 x 0.90			37571000	37565000	37562000	37559000		37556000

# WoodMax



Width x Thickness		Teeth per inch	
inch	mm	4 ETS	3 EHS
3/8" x 032	13 x 0.80	37621600	37621200
1/2" x 032	13 x 0.80	37623500	37622300





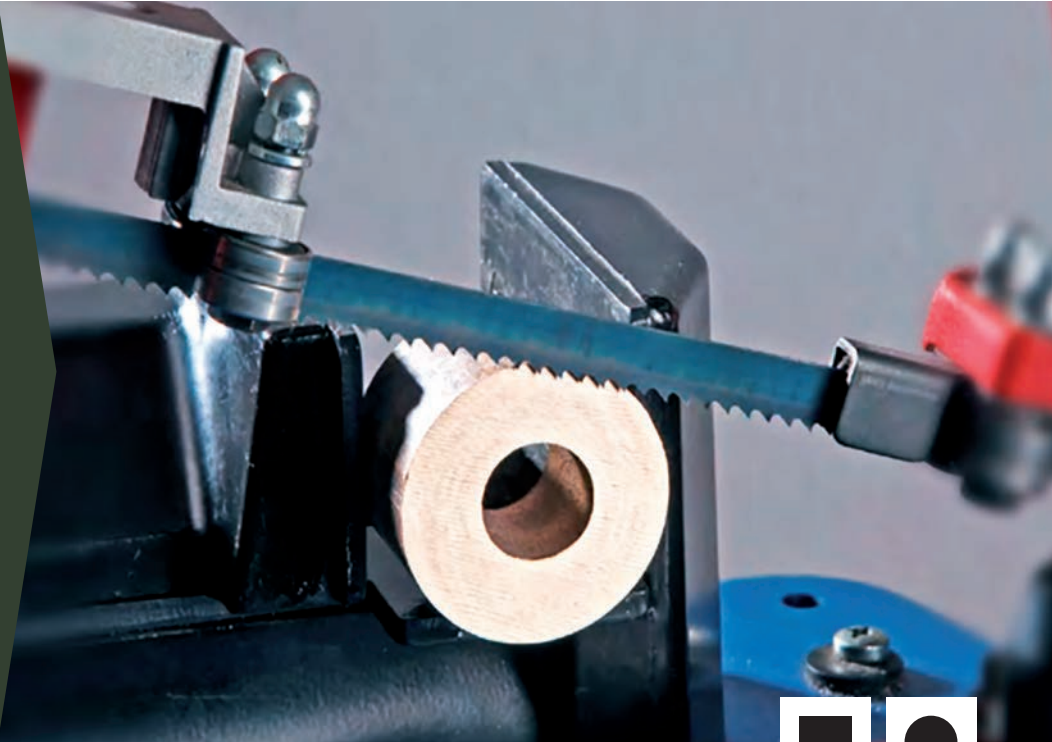
# Hard Back

## ADVANTAGES

- Spring-tempered backer increases beam strength for straighter, faster cuts and longer life.
- Hardened tooth tip improves wear resistance.

## APPLICATIONS GROUPS

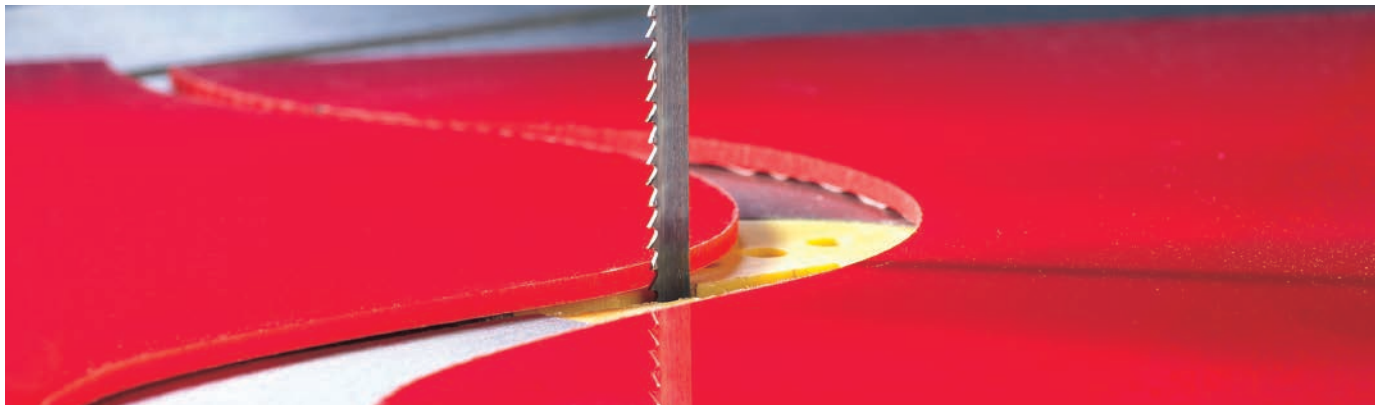
- 1 Aluminum/Bronze.
- 16 Wood/Plastic.



**CARBON CUTTING** ITEM CLASS 40



Width x Thickness		Teeth per inch			
inch	mm	10	8	4	3
1/2" x 025	13 x 0.65	40818000	40817500		
3/4" x 032	20 x 0.90	40827300			40825800
1" x 035	27 x 0.90	40832400		40831700	40831500



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# Other SIMONDS Products



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