
OMNITABLE
BLU-MOL®
RemGrit
BLU-MOL XTREME by DISSTON
Aggressor®
BLU-MOL XTREME QUICKCORE
PRODUCT CATALOG
DISSTON®
DISSTONTOOLS.COM

OUR HANDMADE HISTORY

From the beginning, Henry Disston knew that to compete with the then superior English tools, he would need to make the best saw the world had ever known. That was 1840. With superior manufacturing, a vision for innovation, and an earnestness of spirit, Disston created saws manufactured to usher in a new industrial age.

Today, Disston is a global manufacturer of hole saws, bandsaw blades, jig saw blades, reciprocating saw blades, drill bits, and other hand and power tool related accessories for the DIY, contractor and industrial markets. Its domestic operation is located in Chicopee, MA. The company also operates fabrication and production enterprises overseas. Disston's international manufacturing and distribution capabilities combined with its history and tradition as a brand leader in the tool category for over 165 years provide its customers the optimum blend of value, performance and integrity.

DISSTON®

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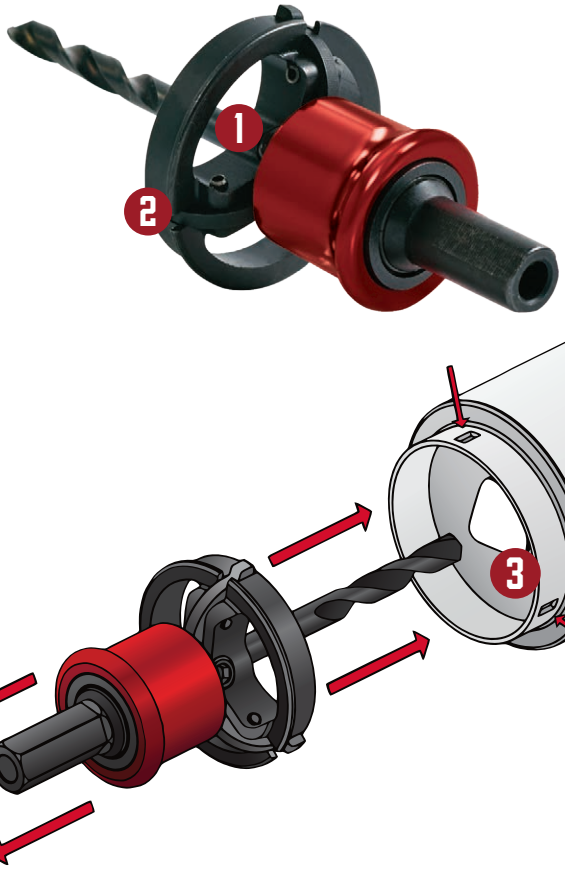
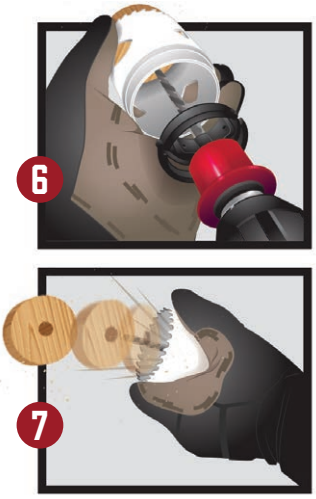
HOLE SAWS

QUICKCORE BI-METAL HOLE SAW

QuickCore's patented technology allows you to engage the quick-release feature exposing the unique open-ended design to immediately remove the plug withoutusing additional tools.

• 10x faster core ejection





HOW IT WORKS!

1. Open back arbor allows for increased visibility and cooling
2. One mandrel for hole saw diameters 3/4" to 6"
3. Open back design allows for easy plug removal
4. Aggressive tooth design 4/5 variable teeth, for fast cutting
5. Wide diamond slot design allows for increased visibility and cooling while cutting
6. Quick change sleeve and 3 pin locking sytem
7. 10x faster core ejection
8. 1-7/8 depth of cut

CUTS THROUGH

HOLE SAWS

BI-METAL QUICKCORE HOLE SAWS

MODEL #	SIZE		PRODUCT CODE
	INCHES	MM	
0200	3/4"	19	E0100200
0201	7/8"	22	E0100201
0202	1"	25	E0100202
0203	1-1/8"	29	E0100203
0204	1-1/4"	32	E0100204
0205	1-3/8"	35	E0100205
0206	1-1/2"	35	E0100206
0207	1-5/8"	38	E0100207
0208	1-3/4"	41	E0100208
0209	1-7/8"	48	E0100209
0210	2"	51	E0100210
0211	2-1/8"	54	E0100211
0212	2-1/4"	57	E0100212
0213	2-3/8"	60	E0100213
0214	2-1/2"	64	E0100214
0215	2-3/4"	70	E0100215
0216	2-7/8"	73	E0100216
0217	3"	76	E0100217
0218	3-1/4"	83	E0100218
0219	3-1/2"	89	E0100219
0220	4"	102	E0100220
0221	4-1/4"	108	E0100221
0222	4-1/2"	114	E0100222
0223	5"	127	E0100223
0224	5-1/4"	133	E0100224
0225	5-1/2"	140	E0100225
0226	5-3/4"	146	E0100226
0227	6"	152	E0100227

SEE **PAGE 5** FOR PRODUCT DETAILS

QUICKCORE ARBOR/ADAPTER

DESCRIPTION	MODEL #	SIZE	PRODUCT CODE
		INCHES	
Quick Change Arbor Assembly w/ pilot bit and hex key	0228	3/8"	E0100228
	0229	7/16"	E0100229
Quickcore Universal Adapter	0232	-	E0100232

SEE **PAGE 5** FOR PRODUCT DETAILS

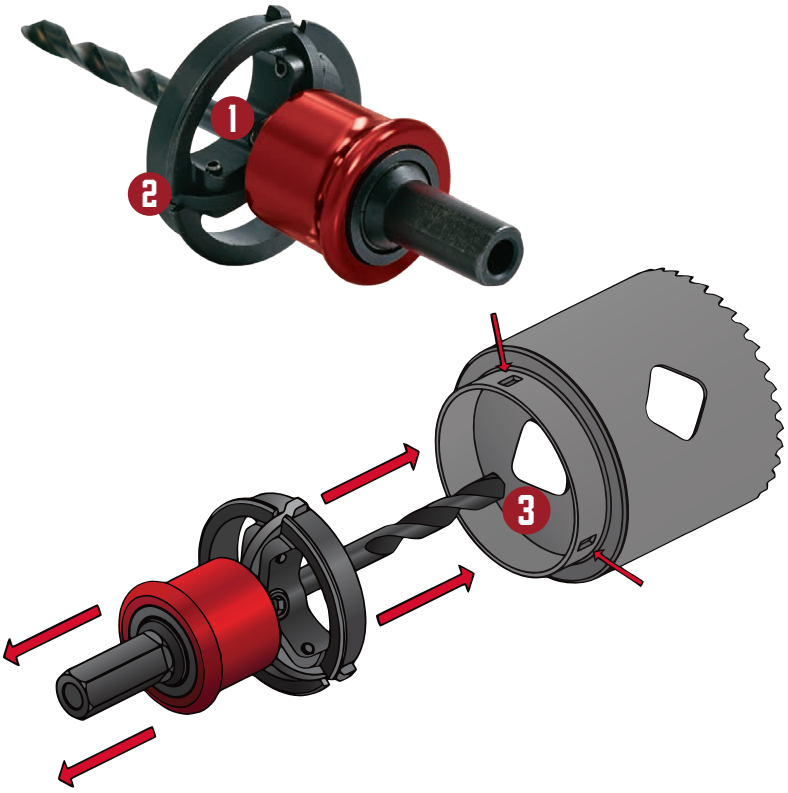
KITS

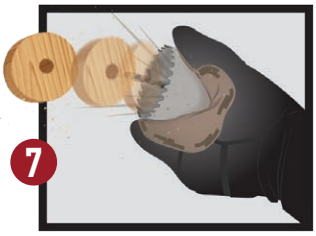
MODEL #	PC	SIZES	PRODUCT CODE
0233	7PC	1", 1-1/4", 1-1/2", 1-3/4", 2", and 2-12" Hole Saws, Arbor with a Pilot Drill Bit, Hex Key	E0100233
0231	13 PC	3/4", 7/8", 1-1/8", 1-3/8", 1-1/2", 1-3/4", 2", 2-1/8", 2-1/2" Hole Saws, (1) Arbor Assembly, (2) Pilot Drills, Hex Key	E0100231
0255	28PC	3/4", 7/8", 1", 1-1/8", 1 ¼", 1 3/8", 1-1/2", 1-5/8", 1-3/4", 1" 7/8", 2", 2 1/8", 2-1/4", 2-3/8", 2-1/2", 2-3/4", 2-7/8", 3", 3-1/2", 4", 4-1/2", 5", 5-1/2", 6", 3/8 Arbor Assembly, 7/16 Arbor Assembly, Pilot Bit, Universal Adapter	E0100255

QUICKCORE CARBIDE HOLE SAW

AVAILABLE IN 2023

- Up to 5X faster than standard hole saws
- Greater heat and wear resistance
- C3 carbide tipped provides extended life and clean cuts
- Sizes range from ¾" to 6" diameter, 7pc and 13pc sets
- 10x more life than standard hole saws
- 10x faster core ejection





HOW IT WORKS!

1. Open back arbor allows for increased visibility and cooling
2. One mandrel for hole saw diameters 3/4" to 6"
3. Open back design allows for easy plug removal
4. Aggressive tooth design 4/5 variable teeth, for fast cutting
5. Wide diamond slot design allows for increased visibility and cooling while cutting
6. Quick change sleeve and 3 pin locking sytem
7. 5x faster than bi-metal
8. Up to 2-3/8" depth of cut

CUTS THROUGH

HOLE SAWS

QUICKCORE CARBIDE HOLE SAWS

MODEL #	SIZE		PRODUCT CODE
	INCHES	MM	
0260	3/4"	19	E0100260
0261	7/8"	22	E0100261
0262	1"	25	E0100262
0263	1-1/16"	27	E0100263
0264	1-1/8"	29	E0100264
0265	1-3/16"	30	E0100265
0266	1-1/4"	32	E0100266
0267	1-3/8"	35	E0100267
0268	1-1/2"	38	E0100268
0269	1-5/8"	41	E0100269
0270	1-3/4"	44	E0100270
0271	1-7/8"	48	E0100271
0272	2"	51	E0100272
0273	2-1/8"	54	E0100273
0274	2-1/4"	57	E0100274
0275	2-3/8"	60	E0100275
0276	2-1/2"	64	E0100276
0277	2-9/16"	65	E0100277
0278	2-5/8"	67	E0100278
0279	2-3/4"	70	E0100279
0280	2-7/8"	73	E0100280
0281	3"	76	E0100281
0282	3-1/8"	79	E0100282
0283	3-1/4"	83	E0100283
0284	3-1/2"	89	E0100284
0285	3-5/8"	92	E0100285
0286	3-3/4"	95	E0100286
0287	4"	102	E0100287

SEE **PAGE 7** FOR PRODUCT DETAILS

QUICKCORE CARBIDE HOLE SAWS

MODEL #	SIZE		PRODUCT CODE
	INCHES	MM	
0288	4-1/8"	105	E0100288
0289	4-1/4"	108	E0100289
0290	4-1/2"	114	E0100290
0291	4-3/4"	121	E0100291
0292	5"	127	E0100292
0293	5-1/2"	140	E0100293
0294	5-3/4"	146	E0100294
0295	6"	152	E0100295

SEE **PAGE 7** FOR PRODUCT DETAILS

CARBIDE QUICKCORE PILOT DRILL

DESCRIPTION	MODEL #	SIZE	PRODUCT CODE
		INCHES	
Carbide Pilot Drill	0168	1/4"	E0100168
Carbon Steel QuickCore Pilot Bit.	0230	1/4"	E0100230

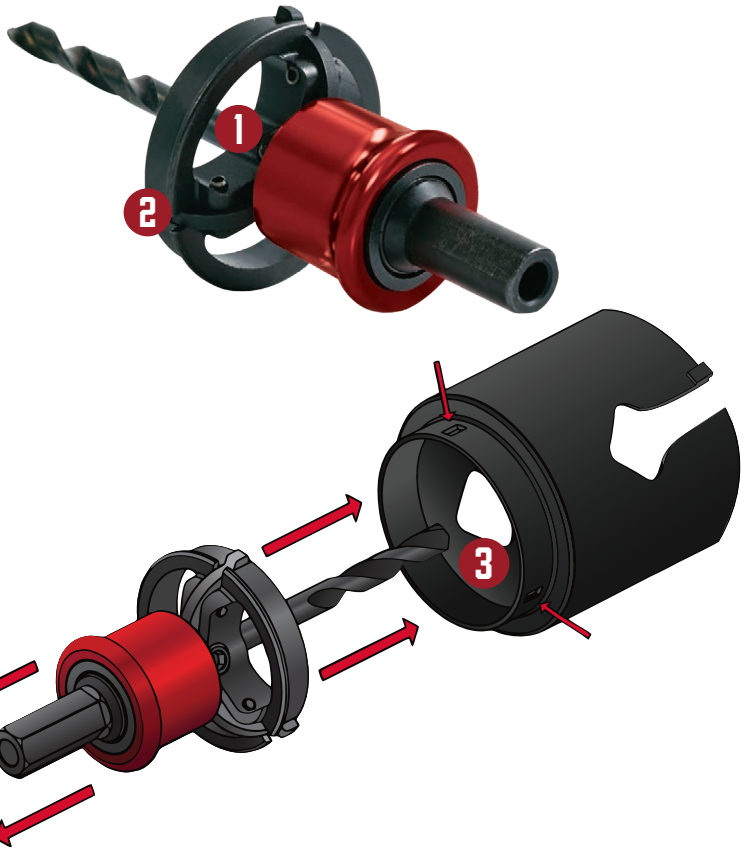
SEE **PAGE 7** FOR PRODUCT DETAILS

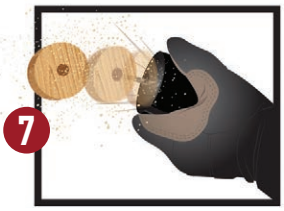
KITS

MODEL #	PC	SIZES	PRODUCT CODE
0297	7PC	1", 1 1/4", 1 1/2", 1 3/4", 2", 3/8 Arbor Assembly, 1 Carbide Pilot Drill, Hex Key	E0100297
0298	10 PC	7/8", 1 3/8", 1 1/2", 1 3/4", 2", 2 1/2", 3", 7/16 Arbor Assembly, 2 Carbide Pilot Bits, Hex Key	E0100298

QUICKCORE TCT HOLE SAW

- C10 Tungsten Carbide tipped provides extended life and clean cuts.
- Sizes range from ¾" to 6 5/8" diameter, 7pc and 13 pc sets.
- 10x more life
- 5x faster cutting
- 10x faster core ejection

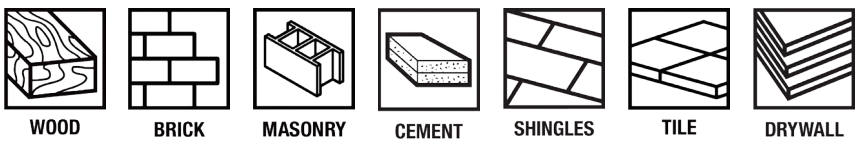




HOW IT WORKS!

1. Open back arbor allows for increased visibility and cooling
2. One mandrel for hole saw diameters 3/4" to 6"
3. Open back design allows for easy plug removal
4. 1 & 3 tooth design for aggressive cuts
5. Wide diamond slot design allows for increased visibility and cooling while cutting
6. Quick change sleeve and 3 pin locking sytem
7. 10x faster core ejection
8. Up to 2-3/8" depth of cut

CUTS THROUGH



QUICKCORE TCT HOLE SAWS

MODEL #	SIZE		NUMBER OF TEETH	MAX CUTTING DEPTH	PRODUCT CODE
	INCHES	MM			
0169	3/4"	19	1	2 1/8"	E0100169
0170	7/8"	22	1	2 1/8"	E0100170
0171	1"	25	1	2 1/8"	E0100171
0172	1-1/8"	29	1	2 1/8"	E0100172
0173	1-1/4"	32	1	2 1/8"	E0100173
0174	1-3/8"	35	1	2 1/8"	E0100174
0175	1-1/2"	38	1	2 1/8"	E0100175
0176	1-5/8"	41	2	2 1/4"	E0100176
0177	1-3/4"	44	2	2 1/4"	E0100177
0178	1-7/8"	48	2	2 1/4"	E0100178
0179	2"	51	2	2 1/4"	E0100179
0180	2-1/8"	54	3	2 3/8"	E0100180
0181	2-1/4"	57	3	2 3/8"	E0100181
0182	2-3/8"	60	3	2 3/8"	E0100182
0183	2-1/2"	64	3	2 3/8"	E0100183
0184	2-9/16"	65	3	2 3/8"	E0100184
0185	2-5/8"	67	3	2 3/8"	E0100185
0186	2-3/4"	70	3	2 3/8"	E0100186
0187	3"	76	3	2 3/8"	E0100187
0188	3-1/4"	83	3	2 3/8"	E0100188
0189	3-1/2"	89	3	2 3/8"	E0100189
0190	3-5/8"	92	3	2 3/8"	E0100190
0191	4"	102	3	2 3/8"	E0100191
0192	4-1/8"	105	3	2 3/8"	E0100192
0193	4-1/4"	108	3	2 3/8"	E0100193
0194	4-1/2"	114	3	2 3/8"	E0100194
0195	5"	127	3	2 3/8"	E0100195
0196	6"	152	3	2 3/8"	E0100196
0197	6-5/8"	168	3	2 3/8"	E0100197

SEE **PAGE 9** FOR PRODUCT DETAILS

KITS

MODEL #	PC	SIZES	PRODUCT CODE
0198	13 PC	1 EACH: 1-3/8", 1 1/2", 1 3/4", 2", 2 1/8", 2 1/2", 2 3/4", 3", 3 1/2", 4" TCT Hole Saws, 7/16" Arbor, (1) Carbide Pilot Bit, (1) Hex Key	E0100198

CARBIDE QUICKCORE PILOT DRILL

DESCRIPTION	MODEL #	SIZE INCHES	PRODUCT CODE
Carbide Pilot Drill	0168	1/4"	E0100168
Carbon Steel QuickCore Pilot Bit	0230	1/4"	E0100230

SEE **PAGE 9** FOR PRODUCT DETAILS

BLU-MOL XTREME BI-METAL HOLE SAWS

A revolutionary design that increases visibility, accuracy and improves battery and machine life. Diamond-shaped sidewall cutouts increase visibility while large openings on the backing plate allow for quick removal of cut materials. Fleem ground teeth for longer life. Patented design.

COBALT INDUSTRIAL GRADE M42 STEEL

UP TO 24% LONGER LIFE

FEATURES

1. 1-7/8" (48mm) depth of cut
2. Wide slot design on side walls and backing plate for increased visibility while cutting
3. Fleem ground teeth for longer life
4. M42 cobalt bi-metal construction
5. 4/6 variable tooth configuration
6. Solid steel backing plate means no need for drive plate
7. Cat's eye opening for easy plug removal and line of sight visibility

CUTS THROUGH

BLU-MOL XTREME BI-METAL HOLE SAW

MODEL #	DIAMETER		PRODUCT CODE
	INCHES	MM	
5855B	9/16"	14	E0211309
5856B	5/8"	16	E0211311
5857B	11/16"	17	E0211312
5127B	3/4"	19	E0212714
5888B	25/32"	20	E0211342
5858B	13/16"	21	E0211313
5128B	7/8"	22	E0210492
5859B	15/16"	24	E0211314
5197B	1"	25	E0210642
5860B	1-1/16"	27	E0211315
5130B	1-1/8"	29	E0210509
5861B	1-3/16"	30	E0211316
5131B	1-1/4"	32	E0210511
5862B	1-5/16"	33	E0211317
5132B	1-3/8"	35	E0210513
5863B	1-7/16"	37	E0211318
5198B	1-1/2"	38	E0210644
5864B	1-9/16"	40	E0211319
5133B	1-5/8"	41	E0210515
5865B	1-11/16"	43	E0211320
5134B	1-3/4"	44	E0210517
M5134B	--	45	E0214033
5866B	1-13/16"	46	E0211321
5135B	1-7/8"	48	E0210519
M5136B	--	50	E0214034
5137B	2"	51	E0210521

SEE **PAGE 11** FOR PRODUCT DETAILS

BLU-MOL XTREME BI-METAL HOLE SAW

MODEL #	DIAMETER		PRODUCT CODE
	INCHES	MM	
5867B	2-1/16"	52	E0211322
5199B	2-1/8"	54	E0210646
M5199B	--	55	E0214035
5137B	2-1/4"	57	E0210523
5868B	2-5/16"	59	E0211323
5139B	2-3/8"	60	E0210527
5138B	2-1/2"	64	E0210525
5869B	2-9/16"	65	E0211324
5870B	2-5/8"	67	E0211325
M5149B	--	68	E0212405
5871B	2-3/4"	70	E0211327
5872B	2-7/8"	73	E0211328
M5150B	--	75	E0214036
5150B	3"	76	E0210560
5873B	3-1/8"	79	E0211329
5874B	3-1/4"	83	E0211330
5875B	3-3/8"	86	E0211331
5151B	3-1/2"	89	E0210562
5876B	3-5/8"	92	E0211332
5877B	3-3/4"	95	E0211333
5878B	3-7/8"	98	E0211334
M5152B	--	100	E0214037
5152B	4"	102	E0210564
5879B	4-1/8"	105	E0211335
5880B	4-1/4"	108	E0211336
5881B	4-3/8"	111	E0211337
5153B	4-1/2"	114	E0210566
5882B	4-3/4"	121	E0211338
5154B	5"	127	E0210567
5155B	5-1/2"	140	E0210568
5883B	5-3/4"	146	E0211339
5156B	6"	152	E0210569

SEE **PAGE 11** FOR PRODUCT DETAILS

KITS

MODEL #	PC	DETAILS	PRODUCT CODE
D9595	7PC	7 Pc. Handyman's Kit Kit Includes: 5 Hole Saws: 7/8"(22mm), 1"(25mm), 1-1/8"(29mm), 1-1/4"(32mm), 1-1/2"(38mm), Mandrel (1), Mandrel Adapter (1), in Heavy Duty Case.	E0212169
D9591	9 PC	9 Pc. Locksmith's Kit Kit Includes: 6 Hole Saws: 7/8"(22mm), 1"(25mm), 1-1/4"(32mm), 1-1/2"(38mm), 1-3/4"(44mm), 2-1/8"(54mm), Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	E0212165
D9592	9 PC	9 Pc. Plumber's Kit Kit Includes: 6 Hole Saws: 3/4"(19mm), 7/8"(22mm), 1-1/8"(29mm), 1-1/2"(38mm), 1-3/4"(44mm), 2-1/4"(57mm), Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	E0212166
D9593	9 PC	9 Pc. Electrician's Kit Kit Includes: 6 Hole Saws: 7/8"(22mm), 1-1/8"(29mm), 1-3/8"(35mm), 1-3/4"(44mm), 2"(51mm), 2-1/2"(64mm), Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	E0212167
D9593M	9 PC	9 Pc. Electrician's Kit - Metric Kit Includes: 6 Hole Saws: 16mm (5/8"), 20mm (25/32"), 25mm (1"), 32mm (1-1/4"), 40mm (1-9/16"), 51mm (2"), Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	E0212168
D9596	13 PC	13 Pc. Journeyman's Kit Kit Includes: 9 Hole Saws: 3/4"(19mm), 7/8"(22mm), 1-1/8"(29mm), 1-3/8"(35mm), 1-1/2"(38mm), 1-3/4"(44mm), 2"(51mm), 2-1/4"(57mm), 2-1/2"(64mm), Mandrels (2), Mandrel Adapter (1), Pilot Drill (1), in Heavy Duty Case.	E0212170
D9599	20 PC	20 Pc. Industrial Kit Kit Includes: 15 Hole Saws: 3/4"(19mm), 7/8"(22mm), 1-1/8"(29mm), 1-3/8"(35mm), 1-1/2"(38mm), 1-3/4"(44mm), 2"(51mm), 2-1/4"(57mm), 2-1/2"(64mm), 3"(76mm), 3-1/4"(83mm), 3-5/8"(92mm), 3-3/4"(95mm), 4-1/8"(105mm), 4-1/2"(114mm), Mandrels (2), Mandrel Adapter (1), Pilot Drill (1), 12" Extension (1), in Heavy Duty Steel Case.	E0212171

SEE **PAGE 11** FOR PRODUCT DETAILS

BLU-MOL BI-METAL HOLE SAWS

M42 cobalt bi-metal cutting edge provides shock resistant teeth and resists tooth strippage. 4/6 positive tooth configuration allows for fast, smooth cuts and less vibration.

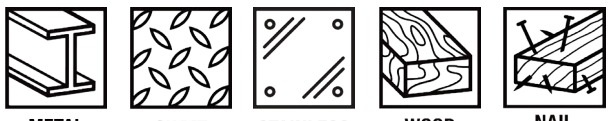
COBALT INDUSTRIAL GRADE M42 STEEL

UP TO 24% LONGER LIFE

FEATURES

1. 1-7/8" (48mm) depth of cut
2. 4/6 variable tooth configuration
3. 3/16" (5mm) thick heavy-duty backing plate eliminates need for drive plate
4. M42 cobalt bi-metal construction
5. Thin kerf design
   - 0.044" thickness for faster cutting
   - Prolongs battery life when used on cordless tools

CUTS THROUGH



BLU-MOL BI-METAL HOLE SAW

MODEL #	DIAMETER		PRODUCT CODE
	INCHES	MM	
509	9/16"	14	E0102399
510	5/8"	16	E0102400
511	11/16"	17	E0102401
512	3/4"	19	E0102402
M513	25/32"	20	E0102403
513	13/16"	21	E0102404
514	7/8"	22	E0102405
515	15/16"	24	E0102406
516	1"	25	E0102407
517	1-1/16"	27	E0102408
518	1-1/8"	29	E0102409
519	1-3/16"	30	E0102410
520	1-1/4"	32	E0102411
521	1-5/16"	33	E0102412
522	1-3/8"	35	E0102413
523	1-7/16"	37	E0102414
524	1-1/2"	38	E0102415
525	1-9/16"	40	E0102416
526	1-5/8"	41	E0102417
527	1-11/16"	43	E0102418
528	1-3/4"	44	E0102419
M528	--	45	E0102420

BLU-MOL BI-METAL HOLE SAW

MODEL #	DIAMETER		PRODUCT CODE
	INCHES	MM	
529	1-13/16"	46	E0102421
530	1-7/8"	48	E0102422
M532	--	50	E0102423
532	2"	51	E0102424
533	2-1/16"	52	E0102425
534	2-1/8"	54	E0102426
M534	--	55	E0102427
536	2-1/4"	57	E0102428
537	2-5/16"	59	E0102429
538	2-3/8"	60	E0102430
540	2-1/2"	64	E0102431
541	2-9/16"	65	E0102432
542	2-5/8"	67	E0102433
M542	--	68	E0102434
544	2-3/4"	70	E0102435
546	2-7/8"	73	E0102436
M548	--	75	E0102437
548	3"	76	E0102438
550	3-1/8"	79	E0102439
552	3-1/4"	83	E0102440
554	3-3/8"	86	E0102441
556	3-1/2"	89	E0102442
558	3-5/8"	92	E0102443
560	3-3/4"	95	E0102444
562	3-7/8"	98	E0102445
M564	--	100	E0102446
564	4"	102	E0102447
566	4-1/8"	105	E0102448
568	4-1/4"	108	E0102449
570	4-3/8"	111	E0102450
572	4-1/2"	114	E0102451
576	4-3/4"	121	E0102452
580	5"	127	E0102453
588	5-1/2"	140	E0102454
592	5-3/4"	146	E0102455
596	6"	152	E0102456

SEE **PAGE 14** FOR PRODUCT DETAILS

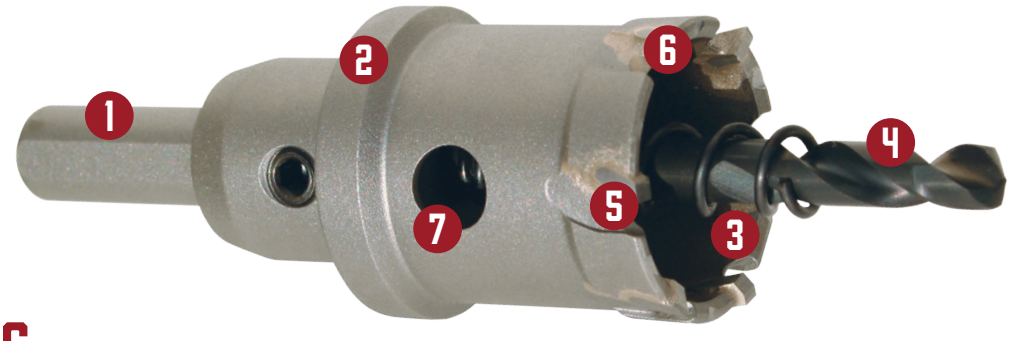
KITS

MODEL #	PC	DETAILS	PRODUCT CODE
9595	7PC	7 Pc. Handyman's Kit Kit Includes: 5 Hole Saws: 7/8"(22mm), 1"(25mm), 1-1/8"(29mm), 1-1/4"(32mm), 1-1/2"(38mm), Mandrel (1), Mandrel Adapter (1), in Heavy Duty Case.	E0103111
9591	9 PC	9 Pc. Locksmith's Kit Kit Includes: 6 Hole Saws: 7/8"(22mm), 1"(25mm), 1-1/4"(32mm), 1-1/2"(38mm), 1 3/4"(44mm), 2-1/8"(54mm), Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	E0103112
9592	9 PC	9 Pc. Plumber's Kit Kit Includes: 6 Hole Saws: 3/4"(19mm), 7/8"(22mm), 1-1/8"(29mm), 1-1/2"(38mm), 1-3/4"(44mm), 2-1/4"(57mm), Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	E0103113
9593	9 PC	9 Pc. Electrician's Kit Kit Includes: 6 Hole Saws: 7/8"(22mm), 1-1/8"(29mm), 1-3/8"(35mm), 1-3/4"(44mm), 2"(51mm), 2-1/2"(64mm), Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	E0103114
9593M	9 PC	9 Pc. Electrician's Kit - Metric Kit Includes: 6 Hole Saws: 16mm (5/8"), 20mm (25/32"), 25mm (1"), 32mm (1-1/4"), 40mm (1-9/16"), 51mm (2"), Mandrels (2), Mandrel Adapter (1), in Heavy Duty Case.	E0103115
9596	13 PC	13 Pc. Journeyman's Kit Kit Includes: 9 Hole Saws: 3/4"(19mm), 7/8"(22mm), 1-1/8"(29mm), 1-3/8"(35mm), 1-1/2"(38mm), 1-3/4"(44mm), 2"(51mm), 2-1/4"(57mm), 2-1/2"(64mm), Mandrels (2), Mandrel Adapter (1), Pilot Drill (1), in Heavy Duty Case.	E0103116
9599	20 PC	20 Pc. Industrial Kit Kit Includes: 15 Hole Saws: 3/4"(19mm), 7/8"(22mm), 1-1/8"(29mm), 1-3/8"(35mm), 1-1/2"(38mm), 1-3/4"(44mm), 2"(51mm), 2-1/4"(57mm), 2-1/2"(64mm), 3"(76mm), 3-1/4"(83mm), 3-5/8"(92mm), 3-3/4"(95mm), 4-1/8"(105mm), 4-1/2"(114mm), Mandrels (2), Mandrel Adapter (1), Pilot Drill (1), 12" Extension (1), in Heavy Duty Steel Case.	E0103117

SEE **PAGE 14** FOR PRODUCT DETAILS

BLU-MOL XTREME TRI-CUT TUNGSTEN CARBIDE TIPPED HOLE SAWS

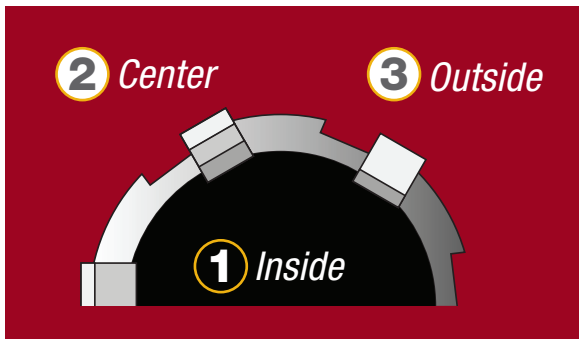
Tungsten carbide tips with three distinct cutting edges balances the cutting for longer blade life and heat resistance. For cutting thick steel, iron, aluminum, steel plate, pipe and stainless steel up to 1" (25mm) thick.



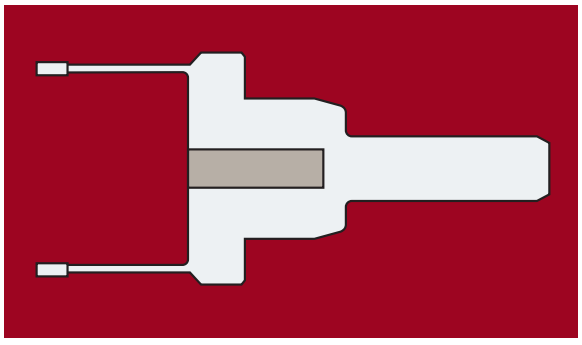
FEATURES

1. 3/8" (10mm) chuck shank dimensions
2. Safety collar stop prevents over-cutting for safer and faster performance
3. Self-ejecting plug removal
4. Special tungsten carbide tips have long edge life and excellent heat resistance
5. A set of three cutting edges balances the cutting for long blade life
6. 1" (25mm) depth of cut
7. Side hole effectively removes chips for added speed of operation

CUTS THROUGH METAL



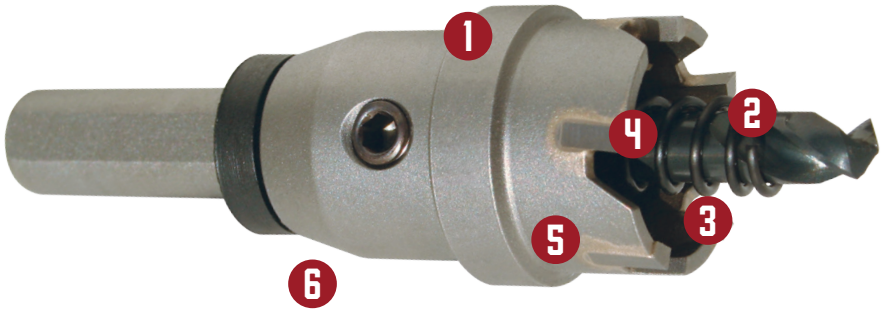
TRI-CUT SYSTEM
There are three different edged cutting blades. One blade slanted outward, one inward and one that peaks in the center. This arrangement balances the cutting effort for smooth boring, better control and less chance of excess drag.



UNI-BODY CONSTRUCTION
The arbored hole cutter has solid construction that eliminates play between the shank and the body, resulting in sharp, crisp, smooth cutting.

BLU-MOL STANDARD TUNGSTEN CARBIDE TIPPED HOLE CUTTERS

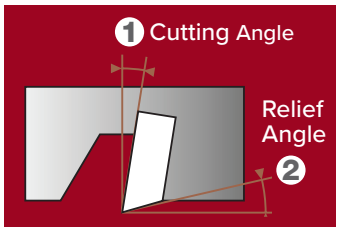
Tungsten carbide tips have excellent wear and heat resistance. Light, smooth-cutting entry with great boring speed. For cutting stainless steel, steel, aluminum and cast iron up to 3/16" (4,5mm) thick.



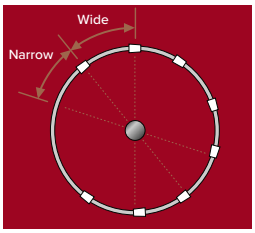
FEATURES

1. Safety collar stop prevents over-cutting for safer and faster performance
2. Strategically placed tips reduce vibration
3. Self-ejecting plug removal
4. Special tungsten carbide tips have long edge life and excellent heat resistance
5. 3/16" (4,5mm) depth of cut
6. 3/8" (10mm) chuck for sizes up to 2-1/2"
   1/2" (13mm) chuck for sizes 2-9/16" and up

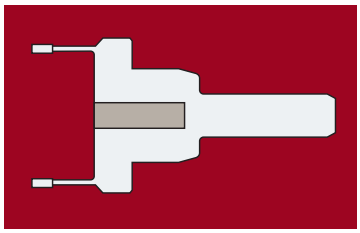
CUTS THROUGH METAL



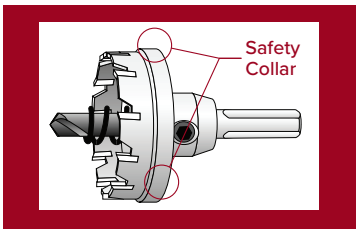
LIGHT AND SMOOTH CUTTING
The tungsten carbide tips are excellent in durability due to ideal blade angles based on the latest metal cutting technology.



Variable tip placement reduces vibration.

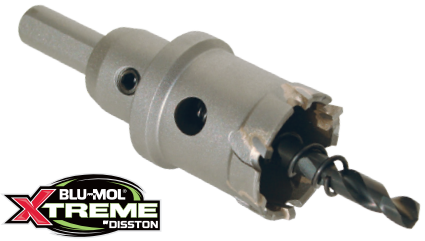


UNI-BODY CONSTRUCTION
The arbored hole cutter has solid construction that eliminates play between the shank and the body, resulting in sharp, crisp, smooth cutting.



SAFE DESIGN
For both safety and prevention of damage to the material being cut, there is a safety collar, which acts as a stop. It prevents over-cutting and loss of control.

HOLE SAWS



BLU-MOL XTREME TRI-CUT TUNGSTEN CARBIDE TIPPED HOLE CUTTERS

MODEL #	DIAMETER		PRODUCT CODE
	INCHES	MM	
3140	5/8"	16	E0102336
3141	11/16"	17	E0102337
3142	3/4"	19	E0102338
3205	--	20	E0102554
3143	13/16"	21	E0102339
3144	7/8"	22	E0102340
3145	15/16"	24	E0102341
3146	1"	25	E0102342
3147	1-1/16"	27	E0102343
3148	1-1/8"	29	E0102344
3149	1-3/16"	30	E0102345
3150	1-1/4"	32	E0102346
3151	1-5/16"	33	E0102347
3152	1-3/8"	35	E0102348
3153	1-7/16"	37	E0102349
3154	1-1/2"	38	E0102350
3155	1-9/16"	40	E0102351
3156	1-5/8"	41	E0102352
3157	1-11/16"	43	E0102353
3158	1-3/4"	44	E0102354
3159	1-13/16"	46	E0102355
3160	1-7/8"	48	E0102356
3161	1-15/16"	49	E0102357
3162	2"	51	E0102358

KITS

HIT DESCRIPTION	MODEL #	PRODUCT CODE
Pilot Drill, Spring & Set Screw for Tri-Cut TCT Cutter	3163	E0102323

SEE **PAGE 18** FOR PRODUCT DETAILS

BLU-MOL STANDARD TUNGSTEN CARBIDE TIPPED HOLE SAW

MODEL #	DIAMETER		PRODUCT CODE
	INCHES	MM	
3164	9/16"	14	E0102359
3165	5/8"	16	E0102360
3166	11/16"	17	E0102361
3167	3/4"	19	E0102362
3206	--	20	E0102555
3168	13/16"	21	E0102363
3169	7/8"	22	E0102364
3170	15/16"	24	E0102365
3171	1"	25	E0102366
3172	1-1/16"	27	E0102367
3173	1-1/8"	29	E0102368
3174	1-3/16"	30	E0102369
3175	1-1/4"	32	E0102370
3176	1-5/16"	33	E0102371
3177	1-3/8"	35	E0102372
3178	1-7/16"	37	E0102373
3179	1-1/2"	38	E0102374
3180	1-9/16"	40	E0102375
3181	1-5/8"	41	E0102376
3182	1-11/16"	43	E0102377
3183	1-3/4"	44	E0102378
3184	1-13/16"	46	E0102379
3185	1-7/8"	48	E0102380
3186	1-15/16"	49	E0102381
3187	2"	51	E0102382
3188	2-1/16"	52	E0102383
3189	2-1/8"	54	E0102384
3190	2-3/16"	56	E0102385
3191	2-1/4"	57	E0102386
3192	2-5/16"	59	E0102387
3193	2-3/8"	60	E0102388
3194	2-7/16"	62	E0102389
3195	2-1/2"	64	E0102390
3196	2-9/16"	65	E0102391
3197	2-5/8"	67	E0102392
3198	2-11/16"	68	E0102393
3199	2-3/4"	70	E0102394
3201	2-7/8"	73	E0102396
3203	3"	76	E0102398

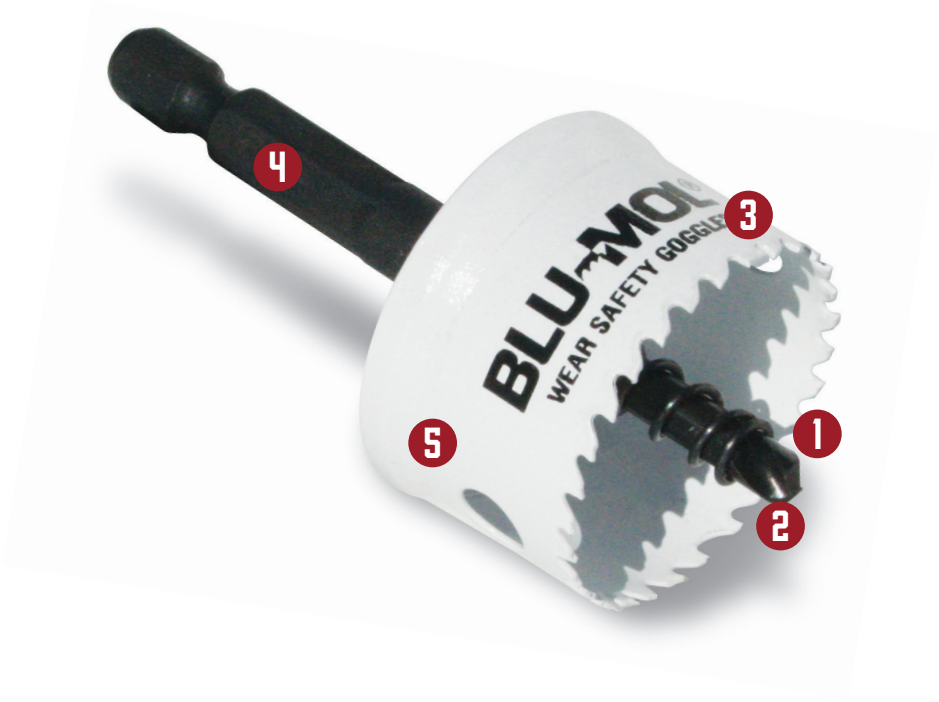
KITS

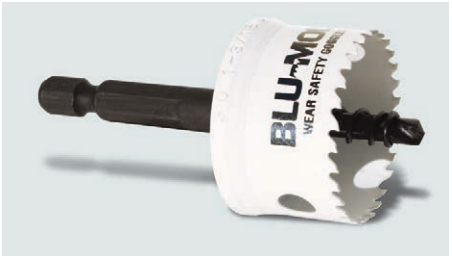
HIT DESCRIPTION	MODEL #	PRODUCT CODE
Pilot Drill, Spring & Set Screw for Std. TCT Cutter	3204	E0102324

SEE **PAGE 18** FOR PRODUCT DETAILS

BLU-MOL SHEET METAL HOLE SAWS

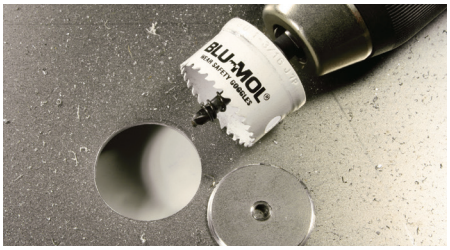
Ideal for the electrical and plumbing tradesman, construction, aircraft, maintenance and automotive applications. Hole saw has a thin 0.02" (0.5mm) sidewall blade thickness, allowing for faster cutting and longer battery life. Ideal for chargeable impact drivers. Use in thin applications of mild steel, brass, aluminum, stainless steel or plastic.





SMOOTH AND FAST CUTTING

Specially designed tooth geometry assures increased performance and better wear resistance.



THE POWER OF THE THIN BLADE

Lightweight blades maximize the use of chargeable impact drivers by using a reduced motor and operation load.

SAFETY COLLAR STOP

Safety collar stop helps prevent cutting too deep and damage to wires when drilling into electrical boxes.

FEATURES

1. Self-ejecting plug removal
2. 5/32" pilot drill for easy center locating and quicker cutting penetration
3. Special 8 TPI tooth design for smoother cuts in sheet metal
4. 1/4" quick change shank, ideal for use with battery operated impact drivers
5. M42 cobalt bi-metal construction

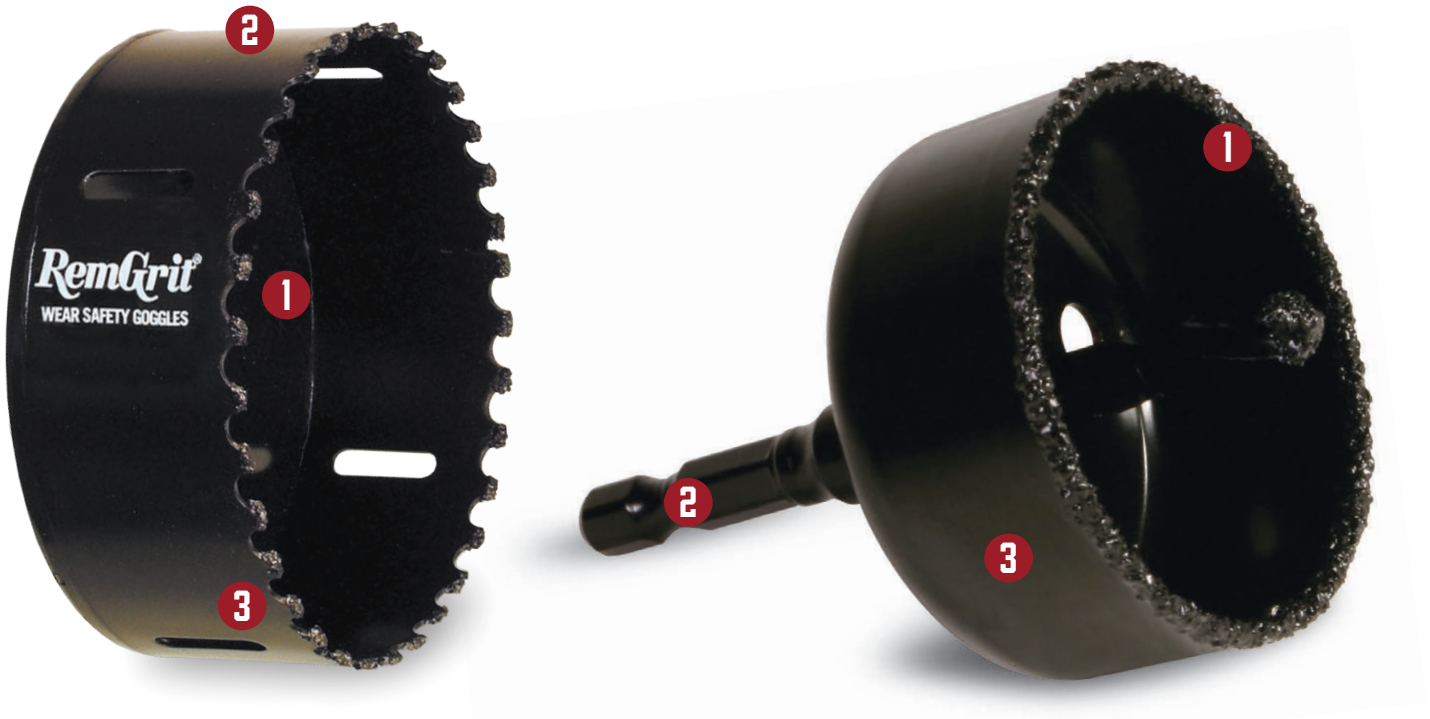
CUTS THROUGH SHEET METAL

BLU-MOL SHEET METAL HOLE SAW

MODEL #	DIAMETER		PRODUCT CODE
	INCHES	MM	
6918	5/8"	16	E0102325
6919	3/4"	19	E0102326
6920	--	20	E0102327
6921	7/8"	22	E0102328
6922	1"	25	E0102329
6923	1-1/16"	27	E0102330
6924	1-1/8"	29	E0102331
6925	1-3/16"	30	E0102332
6926	1-1/4"	32	E0102333
6927	1-3/8"	35	E0102334
6928	1-1/2"	38	E0102335

REMGRIT CARBIDE GRIT HOLE SAWS

Cuts extremely hard abrasive materials: laminates, fiberglass, ceramic tile, marble, slate, cast iron and composites. Cutting edge of tungsten carbide particles bonded to alloy steel back. High heat and abrasion resistance, no teeth to dull or chip, resists snagging, smooth cutting, greater wear resistance. Ideal for plumbing, construction, marine and aircraft applications.



FEATURES

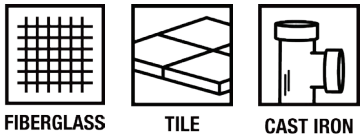
HOLE SAW (WITHOUT ARBOR)

1. 3/16" (5mm) thick heavy-duty backing plate eliminates drive hole elongation and the need for drive plate
2. 1-7/16" (37mm) depth of cut
3. RemGrit® hole saws (without arbors) feature a gulleted grit edge

ARBORED HOLE SAWS

1. RemGrit® arbored hole saws feature a continuous grit edge
2. 1/4" quick change shank
3. 7/8" (22mm) depth of cut

CUTS THROUGH



HOLE SAWS

REMGRIT CARBIDE GRIT HOLE SAWS

MODEL #	DIAMETER		PRODUCT CODE
	INCHES	MM	
G010M	5/8"	16	E0206026
G012	3/4"	19	E0206001
G013M	--	20	E0206027
G014	7/8"	22	E0206002
GO16	1"	25	E0206003
G018	1-1/8"	29	E0206004
G020	1-1/4"	32	E0206005
G022	1-3/8"	35	E0206006
GO24	1-1/2"	38	E0206007
GO28	1-3/4"	44	E0206008
G030	1-7/8"	48	E0206023
GO32	2"	51	E0206009
G034	2-1/8"	54	E0206010
G036	2-1/4"	57	E0206011
G038	2-3/8"	60	E0206024
GO40	2-1/2"	64	E0206022
G044	2-3/4"	70	E0206013
G048	3"	76	E0206014
G052	3-1/4"	83	E0206015
G054	3-3/8"	86	E0206016
G060	3-3/4"	95	E0206025
G064	4"	102	E0206017
G072	4-1/2"	114	E0206018

SEE **PAGE 21** FOR PRODUCT DETAILS

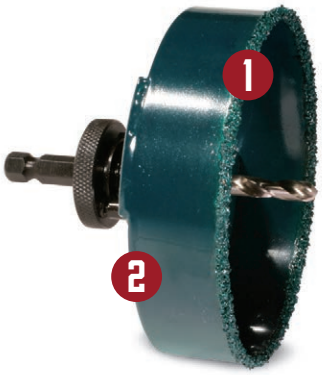
REMGRIT ARBORED CARBIDE HOLE SAWS

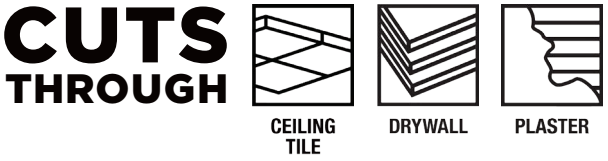
MODEL #	DIAMETER		MIN. ORDER QTY.	PRODUCT CODE
	INCHES	MM		
OGC16BL	1"	25	2	E0104577
OGC20BL	1-1/4"	32	2	E0104578
OGC24BL	1-1/2"	38	2	E0104579
OGC28BL	1-3/4"	44	2	E0104580
OGC32BL	2"	51	2	E0104581
OGC34BL	2-1/8"	54	2	E0104582
OGC36BL	2-1/4"	57	2	E0104583
OGC40BL	2-1/2"	64	2	E0104584

SEE **PAGE 21** FOR PRODUCT DETAILS

REMGRIT CARBIDE GRIT RECESSED LIGHT INSTALLATION KITS

Complete kits for any recessed light installation job. The carbide grit cutting edge easily cuts through ceiling tile and drywall. Recessed light kits are available for 4", 5" and 6" lighting fixtures.





SPECIFICATIONS

1. Features a continuous grit edge
2. Mandrel & pilot bit includued

CARBIDE GRIT RECESSED LIGHT INSTALLATION KITS

MODEL #	DIAMETER		PRODUCT CODE
	INCHES	MM	
GRL402	4-3/8"	111	E0101680
GRL502	5-3/8"	137	E0101681
GRL602	6-3/8"	162	E0101682

LOCK INSTALLATION KITS

6574

6575

6556

LOCK INSTALLATION KITS

TYPE/SIZE	MODEL #	MIN. ORDER QTY.	PRODUCT CODE
Blu-Mol® Professional Bi-Metal Lock Installation Kit Includes: 1 each 1" & 2-1/8" hole saws, guide, assembled mandrel and mandrel adapter	6574	5	E0101949
Blu-Mol® Door Latch Mortise Tool	6575	5	E0101959
Blu-Mol Xtreme® Bi-Metal Lock Installation Kit Includes: 1 each 1" & 2-1/8" hole saws, assembled mandrel and mandrel adapter	6556	6	E0114493

HOLE SAW ACCESSORIES

Accessories for use with our QuickCore®, BLU-MOL®, BLU-MOL Xtreme®, or RemGrit® Hole Saws.


0228


0229


5514


5519


5545


5546


5547


5519RG


5546RG

MANDRELS FOR BI-METAL, CARBIDE TIP AND REMGRIT HOLE SAWS

MODEL #	BRAND	FITS HOLE SAWS	SHANK	DESCRIPTION	PRODUCT CODE
0228	QuickCore®	QuickCore Hole Saws	3/8"	Quick Change Arbor Assembly w/ Pilot Bit and Hex Key	E0100228
0229	QuickCore®	QuickCore Hole Saws	7/16"	Quick Change Arbor Assembly w/ Pilot Bit and Hex Key	E0100229
5514	BLU-MOL®	Bi-Metal Hole Saws in Diameter 9/16" - 1-3/16"	3/8"	Hex Shank Mandrel. Includes 3-1/4" x 1/4" Pilot Drill. Packed 1/box.	E0102457
5519	BLU-MOL®	Bi-Metal Hole Saws in Diameter 1-1/4" - 4"	3/8"	Hex Shank Mandrel. Includes 3-1/4" x 1/4" Pilot Drill. Packed 1/box.	E0102458
5545	BLU-MOL®	Bi-Metal Hole Saws in Diameter 1-1/4" - 6"	7/16"	Hex Shank, Pin Drive Mandrel. Includes 3-1/4" x 1/4" Pilot Drill. Packed 1/box.	E0102459
5546	BLU-MOL®	Bi-Metal Hole Saws in Diameter 1-1/4" - 6"	3/8"	Hex Shank, Pin Drive Mandrel. Includes 3-1/4" x 1/4" Pilot Drill. Packed 1/box.	E0102460
5547	Xtreme®	--	1/4"	Hole Enlarger. Allows a smaller hole saw to become the pilot to enlarge an existing hole. Packed 1/card.	E0102465
5519RG	RemGrit®	RemGrit and Carbide Tip Hole Saws in Diameter 1-1/4" - 6"	3/8"	Hex Shank Mandrel. Includes Carbide Tip pilot drill. Packed 1/box.	E0102841
5546RG	RemGrit®	RemGrit and Carbide Tip Hole Saws in Diameter 1-1/4" - 6"	3/8"	Hex Shank Mandrel. Includes 3-1/4" x 1/4" Pilot Drill. Packed 1/box.	E0102855

HOLE SAW ACCESSORIES

Accessories for use with our QuickCore®, BLU-MOL®, BLU-MOL Xtreme®, or RemGrit® Hole Saws.

5500

5511

SS1

DB1

ACCESSORIES FOR BI-METAL, CARBIDE TIP AND REMGRIT HOLE SAWS

MODEL #	BRAND	FITS HOLE SAWS	SHANK	DESCRIPTION	PRODUCT CODE
5500	BLU-MOL®	7/16" x 12" Extension	7/16"	12" Extension. Used to assist drilling holes in hard-to-reach places. Packed 1/box.	E0102461
6558	BLU-MOL®	For use with mandrel: 5545	3/8"	12" Extension. Used to assist drilling holes in hard-to-reach places. Packed 1/box.	E0101668
SS1	Generic	For use with mandrels: 5514, 5519, 5546, 519RG & 5546RG	--	Mandrel Set Screws. Includes 6 screws (2 each of 3 sizes) to fit into any of our mandrels. Packed 6/envelope.	E0103109
DB1	BLU-MOL®	For use with any BLU-MOL®, Xtreme® or RemGrit® Mandrel	--	Clear Dust Bowl. Bowl collects dust and debris while driving overhead. Packed individually.	E0215000
5511	BLU-MOL®	For use with mandrels: 5514, 5519 & 5519RG		Mandrel Adapter. Adapter allows our smaller mandrels to be used with larger diameter hole saws. Packed 1/card.	E0102462

PILOT DRILLS FOR QUICK CORE, BIMETAL, CARBIDE TIP AND REMGRIT

MODEL #	BRAND	FITS HOLE SAWS	DESCRIPTION	PRODUCT CODE
8534	BLU-MOL®	Bi-Metal Hole Saws	Pilot Drill. 3-1/4" x 1/4" High Speed Steel. Packed 10/box.	E0102463
6524	BLU-MOL®	Bi-Metal Hole Saws	Pilot Drill. 3-1/4" x 1/4" High Speed Steel. Packed 1/card.	E0114470
8535	Generic	Bi-Metal Hole Saws	Pilot Drill. 4-1/4 x 1/4" High Speed Steel. Packed 10/box.	E0215261
8538RG	RemGrit®	RemGrit® and Carbide Tip Hole Saws	Pilot Drill. 3-1/4" x 1/4" Carbide Tip. Packed 1/card.	E0103107
0168	QuickCore®	QuickCore Carbide & TCT Hole Saws	1/4" Carbide Pilot drill for both Quick Core TCT and Carbide Hole saws.	E0100168
0230	QuickCore®	QuickCore Carbide & TCT Hole Saws	1/4" Carbon Steel QuickCore Pilot Bit.	E0100230

HOLE SAW INDEX

Disston offers a wide range of hole saw types and sizes to fit your job. Hole saws and accessories are available in individual packaging and convenient sets.

BLU-MOL Xtreme QuickCore® Bi-Metal Hole Saws
QuickCore's patented technology allows you to engage the quick-release feature exposing the unique open-ended design to remove the plug immediately using no added tools. Suitable for wood, metal, plastic, and sheet metal.

BLU-MOL Xtreme QuickCore® Carbide Hole Saws
Patented carbide holes saw system. Open back design for 10x faster core ejection. Suitable for metal, wood, cement board, and tile.

BLU-MOL Xtreme QuickCore® Tungsten Carbide Tipped Hole Cutters
Patented TCT hole saw system. 5x faster cutting & 10x faster core ejection. Suitable for wood, concrete block, cement board, shingles, tile, dry wall, and brick.

BLU-MOL Xtreme® Bi-Metal
Features a revolutionary design that increases visibility, accuracy and improves battery and machine life. Diamond-shaped sidewall cutouts increase visibility while large openings on the backing plate allow for quick removal of cut materials. Fleem ground teeth for longer life.

BLU-MOL® Bi-Metal
Features high speed steel teeth for a sharper and longer lasting tool. Suitable for both wood and metal cutting.

BLU-MOL® and BLU-MOL Xtreme® Tungsten Carbide Tipped Hole Cutters
Cutting is based on new metal cutting technology. Tungsten Carbide Tip (TCT) cuts holes in thick metals for very fast boring. Available in Tri-Cut and standard styles.

BLU-MOL® Sheet Metal
Special eight teeth per inch ensures smoother cuts in sheet metal. Made to work with impact drivers. Ideal for the electrical tradesman.

RemGrit® Carbide Grit
Carbide grit offers the greatest wear and heat resistance. Ideal for materials that other saws will not cut, this saw cuts extremely abrasive materials with no teeth to chip or dull.

RemGrit® Carbide Grit Recessed Light Installation Kit
Carbide grit cutting edge easily cuts through ceiling tile and drywall. Everything you need to install recessed lighting fixtures fast.

METAL CUTTING SAFETY

READ THIS BEFORE USING PRODUCTS

Modern metal cutting operations involve high energy, high spindle or cutter speeds, and high temperatures and cutting forces. Hot, flying chips may be projected from the workpiece during metal cutting. Although advanced cutting tool materials are designed and manufactured to withstand the high cutting forces and temperatures that normally occur in these operations, they are susceptible to fragmenting in service, particularly if they are subjected to overstress, severe impact or otherwise abused. Therefore, precautions should be taken to adequately protect workers, observers and equipment against hot, flying chips, fragmented cutting tools, broken workpieces or other similar projectiles. Machines should be fully guarded and personal protective equipment should be used at all times.

Disston has no control over the end use of its products or the environment into which those products are placed. Disston urges that its customers adhere to the recommended standards of use of their metal cutting operations. The information included throughout this catalog under the heading "Technical Data" and other recommendations on machining practices referred to herein are only advisory in nature and do not constitute representations or warranties and are not necessarily appropriate for any particular work environment or application.

TECH TIPS FOR HOLE SAWS

- Always wear eye protection.
- Always be sure that the pilot drill extends beyond the cutting edge of the saw by at least 1/8".
- Be sure to secure the material to be cut to keep it from spinning or slipping.
- Be sure to start the cutting process with the saw square to the material being cut. This will ensure that all teeth begin to cut at the same time and will help prevent premature wear and damage to the saw.
- Be sure to follow the recommended operating speed for the saw size and the material being cut.
- Operator should feed the saw in and out to allow the material shavings to clear out of the hole being cut.
- Cutting oils or lubricants should be used to extend the life of the saw, except when cutting wood or cast iron.
- Occasionally check the mandrel's drive pins to be sure they are still fully engaged in the saw and that they have not vibrated out of the drive holes in the saw.
- When sawing in wood, finish the hole from the opposite side to prevent splintering. Once the pilot drill has broken through the other side, you can use this hole to guarantee you are in line with where you have already started cutting.
- When sawing resistant and difficult to cut materials, drill a couple of small holes on the circumference to allow chips to clear.
- Keep an oil soaked sponge inside the hole saw if you:
  – Cannot lubricate in the normal way
  – Operate in stainless steel
  – Operate in a vertical position from above

TECH TIPS FOR PIPE TAP & PIPE ENTRANCE

- Pipe taps are used for threading holes created by a hole saw to receive a threaded pipe. Reference the product charts for proper selection. To cut a hole for a 1" pipe tap, select a 1-1/8" hole saw.
- Pipe entrance is the diameter for the hole through which a pipe of a given diameter will pass during installation or repair.
- Pipe size is defined by the inside diameter. Reference chart on page 16 for proper selection. To cut a hole through which a ¾" pipe may be passed, a 1-1/8" hole saw is used.
- Tubing size is defined by the outside diameter. To cut an entrance hole of a given tubing diameter, the same diameter hole saw should be used.

HOLE SAW SIZE REFERENCE CHART

DIAMETER		PIPE TAP DIAMETER		PIPE ENTRANCE DIAMETER		QUICK-CORE BIMETAL	QUICK-CORE CARBIDE	QUICK-CORE TCT	XTREME	BLU-MOL	SHEET METAL	XTREME TRI-CUT TCT	STD TCT	REMGRIT	REMGRIT ARBORED
INCHES	MM	INCHES	MM	INCHES	MM										
9/16	14	--	--	--	--				5855B	509			3164		
5/8	16	--	--	--	--				5856B	510	6918	3140	3165	G010M	
11/16	17	--	--	--	--				5857B	511		3141	3166		
3/4	19	1/2"	13	3/8"	10	0200	0260	0169	5127B	512	6919	3142	3167	G012	
--	20	--	--	--	--				5888B	M513	6920	3205	3206	G013M	
13/16	21	--	--	--	--				5858B	513		3143	3168		
7/8	22	3/4"	19	1/2"	13	0201	0261	0170	5128B	514	6921	3144	3169	G014	
15/16	24	--	--	--	--				5859B	515		3145	3170		
1	25	--	--	--	--	0202	0262	0171	5197B	516	6922	3146	3171	G016	0GC16BL
1-1/16	27	--	--	--	--		0263		5860B	517	6923	3147	3172		
1-1/8	29	1"	25	3/4"	19	0203	0264	0172	5130B	518	6924	3148	3173	G018	
1-3/16	30	--	--	--	--				5861B	519	6925	3149	3174		
1-1/4	32	--	--	--	--	0204	0266	0173	5131B	520	6926	3150	3175	G020	0GC20BL
1-5/16	33	--	--	--	--				5862B	521		3151	3176		
1-3/8	35	--	--	1"	25	0205	0267	0174	5132B	522	6927	3152	3177	G022	
1-7/16	37	--	--	--	--				5863B	523		3153	3178		
1-1/2	38	1-1/4"	32	--	--	0206	0268	0175	5198B	524	6928	3154	3179	G024	0GC24BL
1-9/16	40	--	--	--	--				5864B	525		3155	3180		
1-5/8	41	--	--	--	--	0207	0269	0176	5133B	526		3156	3181		
1-11/16	43	--	--	--	--				5865B	527		3157	3182		
1-3/4	44	1-1/2"	38	1-1/4"	32	0208	0270	0177	5134B	528		3158	3183	G028	0GC28BL
--	45	--	--	--	--				M5134B	M528					
1-13/16	46	--	--	--	--				5866B	529		3159	3184		
1-7/8	48	--	--	--	--	0209	0271	0178	5135B	530		3160	3185	G030	
--	49	--	--	--	--							3161	3186		
--	50	--	--	--	--				M5136B	M532					
2	51	--	--	1-1/2"	38	0210	0272	0179	5136B	532		3162	3187	G032	0GC32BL
2-1/16	52	--	--	--	--				5867B	533			3188		
2-1/8	54	--	--	--	--	0211	0273	0180	5199B	534			3189	G034	0GC34BL
--	55	--	--	--	--				M5199B	M534					
--	56	--	--	--	--								3190		
2-1/4	57	2"	51	--	--	0212	0274	0181	5137B	536			3191	G036	0GC36BL
2-5/16	59	--	--	--	--				5868B	537			3192		
2-3/8	60	--	--	--	--	0213	0275	0182	5139B	538			3193	G038	
2-7/16	62	--	--	--	--								3194		
2-1/2	64	--	--	2"	51	0214	0276	0183	5138B	540			3195	G040	0GC40BL
2-9/16	65	--	--	--	--		0277	0184	5869B	541			3196		
2-5/8	67	2-1/2"	64	--	--		0278	0185	5870B	542			3197		
--	68	--	--	--	--				M5149B	M542			3198		
2-3/4	70	--	--	--	--	0215	0279	0186	5871B	544			3199	G044	
2-7/8	73	--	--	--	--	0216			5872B	546			3201		
--	75	--	--	--	--				M5150B	M548					
3	76	--	--	2-1/2"	64	0217	0281	0187	5150B	548			3203	G048	
3-1/8	79	--	--	--	--		0282		5873B	550					
3-1/4	83	3	76	--	--	0218	0283	0188	5874B	552				G052	
3-3/8	86	--	--	--	--				5875B	554				G054	
3-1/2	89	--	--	--	--	0219	0284	0189	5151B	556					
3-5/8	92	--	--	3"	76		0285	0190	5876B	558					
3-3/4	95	3-1/2	89	--	--		0286		5877B	560				G060	
3-7/8	98	--	--	--	--				5878B	562					
--	100	--	--	--	--				M5152B	M564					
4	102	--	--	--	--	0220	0287	0191	5152B	564				G064	
4-1/8	105	--	--	3-1/2"	89		0288	0192	5879B	566					
4-1/4	108	4"	102	--	--	0221	0289	0193	5880B	568					
4-3/8	111	--	--	--	--				5881B	570					
4-1/2	114	--	--	--	--	0222	0290	0194	5153B	572				G072	
4-3/4	121	4-1/2"	114	4"	102		0291		5882B	576					
5	127	--	--	--	--	0223	0292	0195	5154B	580					
5-1/2	140	--	--	5"	127	0225	0293		5155B	588					
5-3/4	146	--	--	--	--	0226			5883B	592					
6	152	--	--	--	--	0227	0295	0196	5156B	596					

RECOMMENDED OPERATING SPEEDS FOR HOLE SAWS AND CUTTERS

These guidelines are provided by Disston Company as information on generally recommended operating speeds for hole saws and cutters. Disston Company recommends that users always follow the specific recommendations of the hole saw manufacturer concerning hole saw and cutter use and operating speeds.

BIMETAL HOLE SAW OPERATING SPEEDS (RPM TABLE)

INCHES	MM	LENGTH (FT)	MILD STEEL	TOOL STEEL & STAINLESS	CAST IRON	BRASS	ALUMINUM	WOOD
9/16	14	0.147	580	300	400	790	900	3000
5/8	16	0.164	550	275	365	730	825	3000
11/16	17	0.180	500	250	330	665	750	3000
3/4	19	0.196	460	230	300	600	690	3000
–	20	0.213	440	220	290	580	660	3000
7/8	22	0.229	390	195	260	520	585	3000
1	25	0.262	350	175	235	470	525	2700
1 1/16	27	0.278	325	160	215	435	480	2700
1 1/8	29	0.295	300	150	200	400	450	2700
1 3/16	30	0.311	285	145	190	380	425	2400
1 1/4	32	0.327	275	140	180	360	410	2400
1 5/16	33	0.344	260	135	175	345	390	2400
1 3/8	35	0.360	250	125	165	330	375	2400
1 7/16	37	0.376	240	120	160	315	360	2400
1 1/2	38	0.393	230	115	150	300	345	2400
1 9/16	40	0.409	220	110	145	290	330	2100
1 5/8	41	0.425	210	105	140	280	315	2100
1 11/16	43	0.442	205	100	135	270	305	2100
1 3/4	44	0.458	195	95	130	260	295	2100
1 13/16	46	0.475	190	95	125	250	285	2100
1 7/8	48	0.491	180	90	120	240	270	2100
2	51	0.524	170	85	115	230	255	2000
2 1/16	52	0.540	165	80	110	220	245	2000
2 1/8	54	0.556	160	80	105	210	240	2000
2 1/4	57	0.589	150	75	100	200	225	2000
2 5/16	59	0.605	145	75	95	195	225	2000
2 3/8	60	0.622	140	70	90	190	220	2000
2 1/2	64	0.655	135	65	85	180	205	1850
2 9/16	65	0.671	130	65	85	175	200	1850
2 5/8	67	0.687	130	65	85	170	195	1800
–	68	0.704	130	65	80	170	190	1800
2 3/4	70	0.720	125	60	80	160	185	1800
2 7/8	73	0.753	120	60	75	160	180	1800
3	76	0.785	115	55	70	150	170	1800
3 1/8	79	0.818	110	55	70	140	165	1500
3 1/4	83	0.851	105	50	65	140	155	1500
3 3/8	86	0.884	100	50	65	130	150	1500
3 1/2	89	0.916	95	45	60	130	145	1200
3 5/8	92	0.949	90	45	60	120	140	1200
3 3/4	95	0.982	90	45	60	120	135	1200
3 7/8	98	1.014	90	45	60	120	135	1200
4	102	1.047	85	40	55	110	130	1000
4 1/8	104	1.080	80	40	55	110	120	10000
4 1/4	108	1.113	80	40	55	110	120	900
4 3/8	111	1.145	80	40	50	100	120	900
4 1/2	114	1.173	75	35	50	100	105	900
4 3/4	121	1.244	75	35	50	92	95	900
5	127	1.303	65	30	45	90	90	800
5 1/2	140	1.440	60	25	40	85	85	800
5 3/4	146	1.505	55	25	35	75	75	800
6	152	1.571	55	25	35	75	75	800

BLU-MOL AND XTREME TCT CUTTER OPERATING SPEEDS (RPM TABLE)

DIAMETER		MATERIAL	
INCHES	MM	STEEL	STAINLESS STEEL
11/16 to 13/16	18mm to 21mm	700-1000	300-700
7/8 to 1 3/16	22mm to 30mm	500-800	200-450
1 1/4 to 1 9/16	31mm to 40mm	300-600	175-315
1 5/8 to 2	41mm to 50mm	200-500	120-225
2 1/16 to 2 3/8	51mm to 60mm	200-400	95-195
2 7/16 to 3	61mm to 76mm	150-300	80-150

REMGRIT HOLE SAW OPERATING SPEEDS (RPM TABLE)

INCHES	MM	BRICK CERAMIC	SLATE	REIN-FORCED PLASTICS	FIBER-GLASS
5/8	16	620	1540	2140	920
3/4	19	510	1280	1790	770
–	20	470	1180	1660	715
7/8	22	430	1090	1530	660
1	25	380	960	1340	580
1 1/8	29	340	850	1190	510
1 1/4	32	310	770	1070	460
1 3/8	35	280	700	980	420
1 1/2	38	260	640	890	390
1 3/4	44	220	550	770	330
1 7/8	48	200	510	720	310
2	51	190	480	670	290
2 1/8	54	180	450	630	280
2 1/4	57	170	430	600	270
2 3/8	60	160	400	570	250
2 1/2	64	150	380	540	230
2 3/4	70	140	350	500	210
3	76	130	320	450	190
3 1/4	83	120	295	415	180
3 3/8	86	115	285	400	175
3 3/4	95	102	255	350	160
4	102	95	240	330	150
4 1/2	114	82	215	290	125

RECIPROCATING BLADES

BLU-MOL XTREME BI-METAL RECIPROCATING SAW BLADES

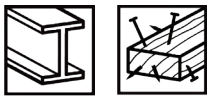
COBALT INDUSTRIAL GRADE M42 STEEL

UP TO 20% LONGER LIFE

BLU-MOL Xtreme® recip blades are designed for tough, heady-duty cutting jobs and are built to last. With aggressive cutting angle providing fast non-binding performance.

WOOD / WOOD WITH NAILS

CUTS THROUGH



METAL

NAIL-EMBEDDED WOOD

BIMETAL

CUTS THROUGH

METAL

WOOD

PLASTIC

METAL

CUTS THROUGH

METAL

FEATURES

1. Aggressive 5° cutting angle produces faster cuts
2. Improved chip clearance with larger gullets reduces heat and provides up to 20% more life
3. 25% thicker blade for the toughest job applications
4. M42 cutting edge with 8% cobalt for longer life

RECIPROCATING BLADES

BLU-MOL XTREME BI-METAL DEMOLITION RECIPROCATING SAW BLADES

MODEL #	DESCRIPTION	LENGTH	TPI	BODY STYLE	BLADE WIDTH	BLADE THICKNESS	QTY.	PRODUCT CODE
WOOD CUTTING W/ NAILS								
8000	6" x 6 TPI	6"	6	Taper	3/4"	0.050	5	E0108000
8001							15	E0108001
8002							25	E0108002
8003	9" x 6 TPI	9"	6	Taper	3/4"	0.050	5	E0108003
8004							15	E0108004
8005							25	E0108005
8006	12" x 6 TPI	12"	6	Taper	3/4"	0.050	5	E0108006
8007							15	E0108007
8008							25	E0108008
8009	6" x 6 TPI	6"	6	Taper	7/8"	0.062	15	E0108009
8010	9" x 6 TPI	9"	6	Taper	7/8"	0.062	15	E0108010
8011	12" x 6 TPI	12"	6	Taper	7/8"	0.062	15	E0108011
METAL CUTTING								
8030	6" x 14/18 TPI	6"	14/18	Straight	3/4"	0.035	5	E0108030
8031							15	E0108031
8032							25	E0108032
8033	9" x 14/18 TPI	9"	14/18	Straight	3/4"	0.035	5	E0108033
8034							15	E0108034
8035							25	E0108035
8036	12" 14/18 TPI	12"	14/18	Straight	3/4"	0.035	5	E0108036
8037							15	E0108037
8038							25	E0108038
8039	6" x 14 TPI	6"	14	Straight	3/4"	0.035	5	E0108039
8040							15	E0108040
8041							25	E0108041
8042	9" x 14 TPI	9"	14	Straight	3/4"	0.035	5	E0108042
8043							15	E0108043
8044							25	E0108044
8045	12" x 14 TPI	12"	14	Straight	3/4"	0.035	5	E0108045
8046							15	E0108046
8047							25	E0108047
8048	6" x 18 TPI	6"	18	Straight	1"	0.042	5	E0108048
8049							15	E0108049
8050							25	E0108050
8051	9" x 18 TPI	9"	18	Straight	1"	0.042	5	E0108051
8052							15	E0108052
8053							25	E0108053
8054	6" x 14 TPI	6"	18	Straight	1"	0.042	15	E0108054
8055	9" x 14 TPI	9"	14	Straight	1"	0.042	15	E0108055
WOOD/METAL CUTTING								
8012	6" x 10 TPI	6"	10	Straight	3/4"	0.035	5	E0108012
8013							15	E0108013
8014							25	E0108014
8015	9" x 10 TPI	9"	10	Straight	1"	0.042	5	E0108015
8016							15	E0108016
8017							25	E0108017
8018	12" x 10 TPI	12"	10	Straight	1"	0.042	5	E0108018
8019							15	E0108019
8020							25	E0108020
8021	6" x 10/14 TPI	6"	10/14	Straight	3/4"	0.035	5	E0108021
8022							15	E0108022
8023							25	E0108023
8024	6" x 10/14 TPI	6"	10/14	Straight	3/4"	0.050	5	E0108024
8025							15	E0108025
8026							25	E0108026
8027	9" x 10/14 TPI	9"	10/14	Straight	3/4"	0.050	5	E0108027
8028							15	E0108028
8029	12" x 10/14 TPI	12"	10/14	Straight	3/4"	0.050	5	E0108029
PLASTER BLADES								
8057	6" Plaster Cut	6"	6	Straight	3/4"	0.035	5	E0108057
8058	6" Plaster Cut	6"	6	Straight	3/4"	0.035	10	E0108058
8059	6" Plaster Cut	6"	6	Straight	3/4"	0.035	50	E0108059

BLU-MOL XTREME PALLET RECIPROCATING SAW BLADES

COBALT INDUSTRIAL GRADE M42 STEEL

UP TO 20% LONGER LIFE

Reciprocating saw blades are designed for efficient cutting pallets and nail embedded wood. All have the 1/2" universal shank that fits all standard 1/2" shank reciprocating saws. Made for quick and accurate cutting.

PALLET RECIPROCATING SAW BLADE				
SIZE			BULK (250PK)	
LENGTH		TEETH PER INCH	MODEL #	PRODUCT CODE
INCHES	MM			
8" x 3/4" x .035"	203 x 19 x .9 25	10	8056	E0108056

FEATURES

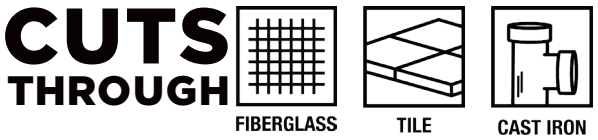
1. High performance cutting for pallet dismantling
2. Special heat treat for increased tooth life to withstand nails and keep cutting
3. Unique tooth design for fast cutting – M42 cutting edge with 8% cobalt for longer life
4. Rounded nose for easy cutting with the ability to access tight spaces and safe operation
5. Special blade backer for greater flexibility when cutting block pallets
6. Aggressive 5° cutting angle produces faster cuts

CUTS THROUGH

NAIL-EMBEDDED WOOD

REMGRIT CARBIDE GRIT RECIPROCATING SAW BLADES

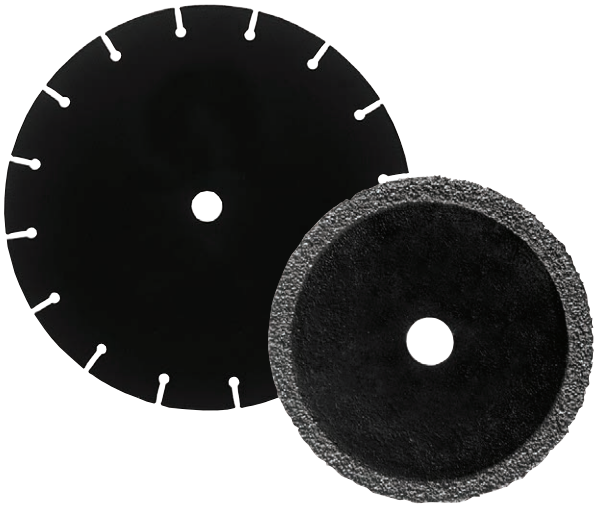
Cuts extremely hard abrasive materials. The cutting edge of tungsten carbide particles is permanently bonded to an alloy steel back. These blades have high heat and abrasion resistance. There are no teeth to dull or chip and the blades cut on both strikes. Resists snagging and are always smooth cutters.



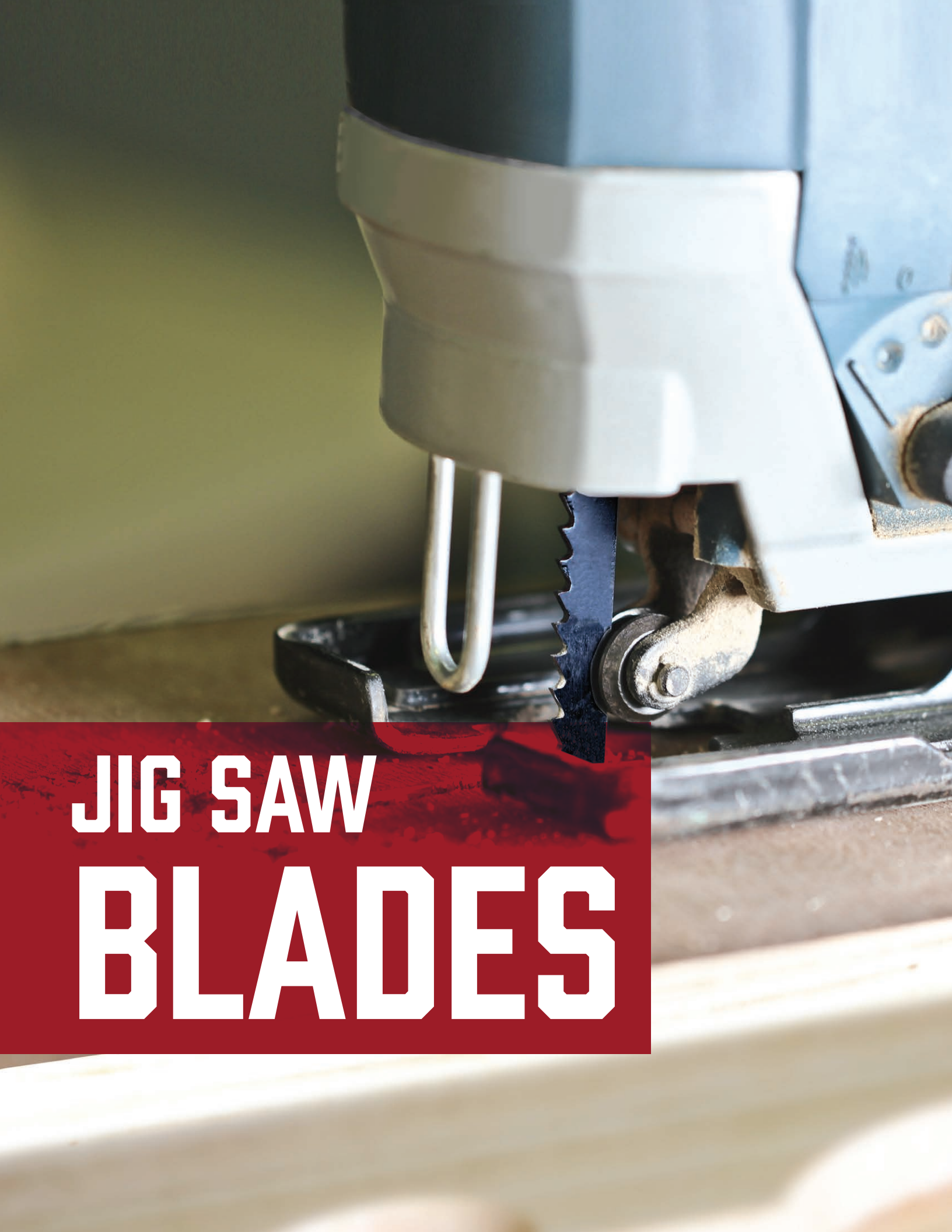
RECIPROCATING SAW BLADE								
SIZE			1/CARD		10/TUBE		BULK (50PK)	
LENGTH		GRIT	MODEL #	PRODUCT CODE	MODEL #	PRODUCT CODE	MODEL #	PRODUCT CODE
INCHES	MM							
6 x 3/4 x .032	150 x 20 x 0,90	Coarse	GR24BL	E0406122	GR24-10T	E0102835	GR24-50	E0206112
8 x 3/4 x .042	200 x 20 x 0,90	Coarse	GR26BL	E0406123	GR26-10T	E0102251	GR26-50	E0206113

REMGRIT CARBIDE GRIT CIRCULAR SAW BLADES

Cuts extremely hard abrasive materials. The cutting edge of tungsten carbide particles is permanently bonded to an alloy steel back. These blades have high heat and abrasion resistance. There are no teeth to dull or chip and the blades cut on both strikes. Resists snagging and are always smooth cutters.



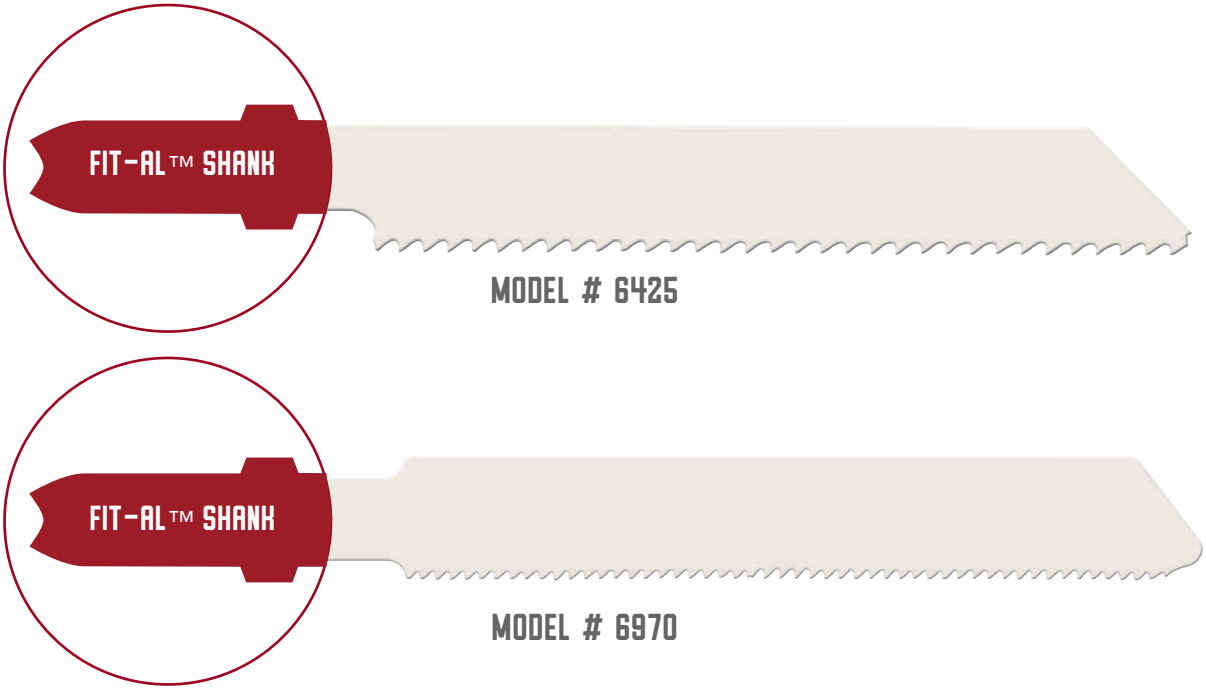
CIRCULAR SAW BLADE						
SIZE			1/CARD			
LENGTH		GRIT	ARBOR SIZE	MODEL #	PRODUCT CODE	MAX RPM
INCHES	MM					
1-3/4	44	FINE	1/4"	GC101	E0206220	26,200
1-3/4	44	MEDIUM	1/4"	GC103	E0206221	26,200
1-3/4	44	COARSE	1/4"	GC107	E0206223	26,200
2	51	MEDIUM	1/4"	GC200	E0206224	23,600
2-1/2	64	COARSE	7/16"	GC250	E0206226	18,400
3	76	COARSE	1/2"	GC302	E0206227	15,200
3	76	COARSE	3/8"	GC304	E0206228	15,200
4	102	COARSE	20mm	GC406	E0206229	11,500
4	102	COARSE	3/4"	GC404	E0206231	11,500
4	102	COARSE	5/8"	GC408	E0206232	11,500
6-1/2	165	COARSE	1/2"-5/8"	GC652	E0206234	7,000
7	178	MEDIUM	1/2"-5/8"	GC700	E0206235	6,500
7	178	COARSE	1/2"-5/8"	GC703	E0206236	6,500
8	203	MEDIUM	1/2"-5/8"	GC803	E0206237	5,700
8	203	COARSE	1/2"-5/8"	GC805	E0206238	5,700
10	254	COARSE	5/8"	GC507	E0206240	4,600
12	305	COARSE	3/4"-1" Rnd	GC915	E0206242	3,800



JIG SAW BLADES

BLU-MOL BI-METAL JIG SAW BLADES

Bi-metal jig saw blades are for cutting metals, steel and stainless steel. Their high-strength steel cutting edges are hardened and offer the flexibility required for durable, longer lasting blades. Made for heavy-duty cutting in wood and metal.



BI-METAL JIG SAW BLADES								
SIZE			APPLICATION		2/CARD		25/TUBE	
LENGTH		TEETH PER INCH	TYPE OF CUT	MATERIAL	MODEL #	PRODUCT CODE	MODEL #	PRODUCT CODE
INCHES	MM							
3-1/2"	89	6	Rough	Wood & Metal	6420	E0114415	6420-25T	E0102839
3-1/2"	89	10/14	All Purpose	Wood & Metal	6421	E0114416	--	--
3-1/2"	89	12	All Purpose	Wood & Metal	6422	E0114417	6422-25T	E0102840
3"	76	14	Rough	Metal	6425	E0101950	--	--
3"	76	18	All Purpose	Metal	6423	E0114418	--	--
3"	76	24	Smooth	Metal	6424	E0114419	--	--
3"	76	32	Smooth	Metal	6970	E0102843	6970-25T	E0102844
2-7/8"	73	Grit	Smooth	Tile, Cast Iron, & Fiberglass	6464	E0101299	--	--

CUTS THROUGH

BLU-MOL CARBON & HIGH SPEED STEEL JIG SAW BLADES

Carbon jig saw blades are used for cutting wood. These carbon jig saw blades provide a very clean and fast cut for most for general purpose cutting. High speed steel for cutting in metal.

SIZE			APPLICATION		2/CARD		BLADE TYPE
LENGTH		TEETH PER INCH	TYPE OF CUT	MATERIAL	MODEL #	PRODUCT CODE	
INCHES	MM						
CARBON							
3-1/8"	79	6	Rough	Wood	6412	E0114410	Carbon
3-1/2"	89	6	Rough	Wood	6401	E0114400	Carbon
6"	152	6	Rough	Wood	6434	E0102319	Carbon
2-3/4" - Flush	70	8	Flush	Wood	6453	E0102227	Carbon
3-5/8"	92	8	All Purpose	Plaster	6419	E0102228	Carbon
4-1/8"	105	8	Rough	Wood	6428	E0102229	Carbon
2-3/4"	70	10	All Purpose	Wood	6417	E0102232	Carbon
2-3/4" - Scroll	70	10	Rough	Wood	6441	E0102225	Carbon
3-1/8"	79	10	Smooth	Formica	6408	E0114406	Carbon
3-1/8"	79	10	Smooth	Wood	6418	E0102233	Carbon
3-1/8" - Scroll	79	10	Smooth	Wood	6411	E0114409	Carbon
3-1/2"	89	10	All Purpose	Wood	6407	E0114405	Carbon
3-1/8" - Reverse Tooth	79	12	Smooth	Wood	6465	E0102321	Carbon
2-3/4" - Scroll	70	14	Smooth	Wood	6406	E0114404	Carbon
2-3/4" - Scroll	70	19	Smooth	Wood	6444	E0102226	Carbon
HIGH SPEED STEEL							
2-3/4"	70	12	All Purpose	Metal	6413	E0114411	HSS
2-3/4"	70	21	Smooth	Metal	6415	E0114413	HSS
3-1/8"	79	24	Smooth	Metal	6454	E0102318	HSS
2-3/4"	70	32	Smooth	Metal	6416	E0114414	HSS

CUTS THROUGH

BLU-MOL JIG SAW BLADE SETS

BLU-MOL® jig saw blade assorted sets give you the right blades for any project you might have. Each set has been expertly matched to cut traditional wood, plastic or metal materials, from thin to thick, rough to smooth cut.

MODEL # 6437

JIG SAW BLADE KITS

KIT DESCRIPTION	TYPE OF CUT	MATERIAL	MODEL #	PRODUCT CODE
3Pc Bi-Metal Blades: (1) 3" x 14T, (1) 3" x 18T, (1) 3" x 24T	All Purpose	Metal	6426	E0102234
5Pc Carbon Blades: (1) 3-1/2" x 6T, (2) 3-1/2" x 10T, (2) 2-3/4" x 14T Scroll	All Purpose	Wood	6440	E0101729
5Pc Bi-Metal Blades: (2) 3" x 14T, (2) 3" x 18T, (1) 3" x 24T	All Purpose	Metal	6443	E0101958
7Pc Bi-Metal Blades: (2) 3-1/2" x 6T, (2) 3-1/2" x 10/14T, (1) 3" x 14T, (1) 3" x 18T, (1) 3" x 24T	All Purpose	Wood & Metal	6427	E0102235
10Pc Carbon Blades: (2) 3-1/2" x 6T, (2) 3-1/2" x 10T, (1) 3-1/8" x 10T, 2-3/4" x 10T, (1) 2-3/4" x 14T Scroll HSS Blades: (1) 2-3/4" x 12T, (1) 2-3/4" x 18T, (1) 2-3/4" x 21T	All Purpose	Wood & Metal	6433	E0102231
12Pc Carbon Blades: (2) 3-1/2" x 6T, (2) 3-1/2" x 10T, (2) 2-3/4" x 14T scroll, Bi-Metal Blades: (1) 3-1/2" x 10/14T, (2) 3" x 14T, (2) 3" x 18T, (1) 3" x 24T	All Purpose	Wood & Metal	6442	E0101730
25Pc Carbon Blades: (5) 3-1/2" x 6T, (5) 3-1/2" x 10T, (5) 2-3/4" x 14T scroll, Bi-metal Blades: (5) 3-1/2" x 10/14T, (5) 3" x 18T	All Purpose	Wood & Metal	6437	E0114425
98pc Display Set includes: Bi-Metal Blades: (5) 3"x32T, (5) 3"x14T, (5) 3-1/2"x6T, (5) 3-1/2"x10/14T, (5) 3"x18T, (5) 3"x24T, (5) 3-1/2"x12; Carbon Blades: (5) 3-5/8"x8T, (5) 2-3/4"x14T, (5) 3-1/2"x10T, (5) 3-1/8"x6T, (5) 3-1/8"x10T, (5) 2-3/4"x8T, (5) 3-1/8"x10T, (5) 6"x6T; HSS Blades: (5) 3-1/8"x24T, (5) 2-3/4"x32T, (5) 2-3/4"x21T; 3 Piece Blade Set, 25 Piece Set, 20 Prong Rack, Header Card				E0320105

CUTS THROUGH

REMGRIT CARBIDE GRIT JIG SAW BLADES

Carbide grit jig saw blades cut extremely hard abrasive materials. Cutting edge of tungsten carbide particles bonded to alloy steel back. High heat and abrasion resistance; no teeth to dull or chip; resists snagging; smooth cutting; greater wear resistance.

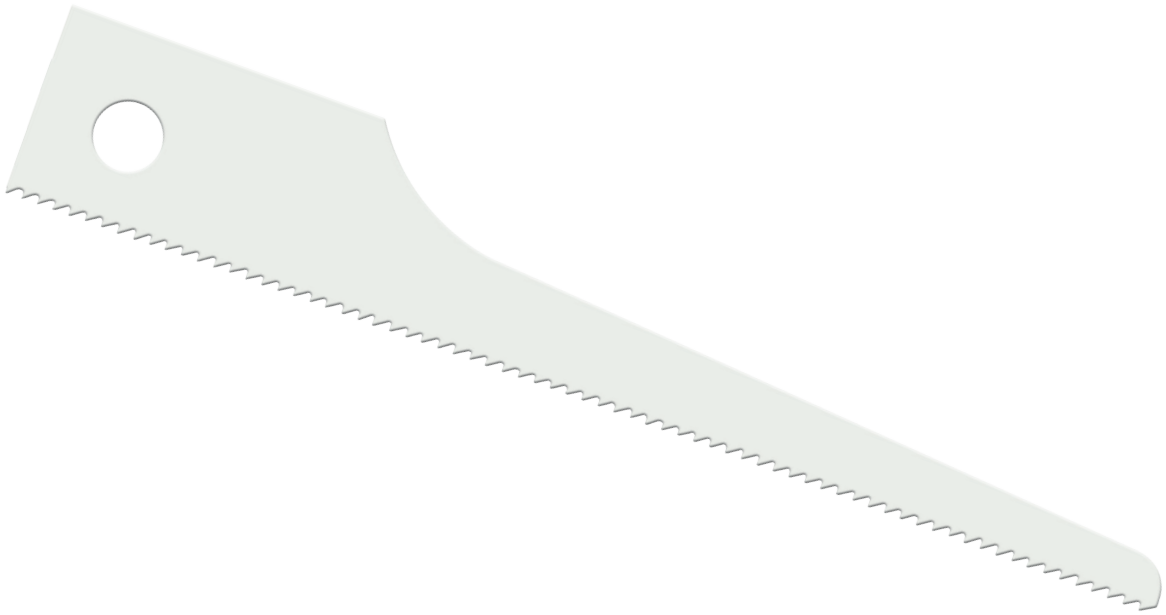
SIZE			APPLICATION		1/CARD			BULK (50PK)	
LENGTH INCHES	LENGTH MM	GRIT	TYPE OF CUT	MATERIAL	MODEL #	MIN ORDER QTY	PRODUCT CODE	MODEL #	PRODUCT CODE
UNIVERSAL SHANK									
2-7/8"	73	Coarse	Rough	Tile, Slate, Fiberglass	GJ6BL	5	E0406142	GJ6-50	E0206132
2-7/8"	73	Medium	All Purpose	Tile, Slate, Fiberglass	GJ4BL	5	E0406141	GJ4-50	E0206131
2-7/8"	73	Fine	Smooth	Tile, Slate, Fiberglass	GJ2BL	5	E0406140	--	--
2-7/8" Scroll	73	Coarse	Rough	Tile, Slate, Fiberglass	GJ10BL	5	E0406144	--	--
2-7/8" Scroll	73	Fine	Smooth	Tile, Slate, Fiberglass	GJ8BL	5	E0406143	--	--
4" - Flush	102	Medium	Rough	Tile, Slate, Fiberglass	GJ18BL	5	E0406146	--	--
T-SHANK									
3"	76	Medium	All Purpose	Tile, Slate, Fiberglass	GJ12BL	5	E0406148	GJ12-50	E0206138
3"	76	Coarse	Rough	Tile, Slate, Fiberglass	GJ14BL	5	E0406147	GJ14-50	E0206137

ASSORTMENT PACKS	
Assortment #1 includes: Qty 1 circular saw in 7" diameter, Qty 2 arbored hole saws in sizes: 1-1/4", 1-1/2" 2" & 2-1/2", Qty 5 jig saw blades in sizes: 2-7/8", 2-7/8" scroll, 3" T-shank, Qty 5 reciprocating blades in sizes: 6" & 8", Qty 10 hack saw blades size 12", Qty 10 rod saws size 12".	E0320062
Assortment #2 includes: Qty 4 arbored hole saws in sizes: 1-1/4", 1-1/2", 2" & 2-1/2", Qty 5 jig saw blades in sizes: 2-7/8", 2-7/8" scroll, 3" T-shank	E0320063
Assortment #3 includes: Qty 2 arbored hole saws in sizes: 1-1/4", 1-1/2", 2" & 2-1/2", Qty 2 jig saw blades in sizes: 2-7/8", 2-7/8" scroll, 3" T-shank	E0320065

CUTS THROUGH

BLU-MOL BI-METAL AIR SAW BLADES

Specially designed blades for use in pneumatic saws. Air saw blades have fine teeth for cutting metal.



SIZE			5/TUBE	
LENGTH		TEETH PER INCH	MODEL #	PRODUCT CODE
INCHES	MM			
AIR SAW BLADES				
3" x 1/2" x .025"	75 x 12.5 x 0.64	18	6982	E0103178
3" x 1/2" x .025"	75 x 12.5 x 0.64	24	6983	E0103179
3" x 1/2" x .025"	75 x 12.5 x 0.64	32	6984	E0103180
4" x 1/2" x .025"	100 x 12.5 x 0.64	18	6985	E0103181
4" x 1/2" x .025"	100 x 12.5 x 0.64	32	6986	E0103182
5" x 1/2" x .025"	125 x 12.5 x 0.64	18	6987	E0103183

AIR SAW BLADE SET		
AIR BLADE SET	MODEL #	PRODUCT CODE
Includes (1) each of the following blades: 3" x 18T, 3" x 24T, 3" x 32T, 4" x 32T	6472	E0101319

CUTS THROUGH

METAL

NAIL-EMBEDDED WOOD

BLU-MOL BI-METAL HACKSAW BLADES

Bi-metal hacksaw blades for heavy-duty cutting. Cut medium gauge metals (1/16" to 1/4") such as sheet metal, angle iron, bolts, channels, drill rods, threaded rod, pipes and tubing. Blade is shatter resistant.

BLU-MOL HACKSAW BLADES								
SIZE			2/CARD		10/CARD		100/TUBE	
LENGTH		TEETH PER INCH	MODEL #	PRODUCT CODE	MODEL #	PRODUCT CODE	MODEL #	PRODUCT CODE
INCHES	MM							
12" x 1/2" x .025"	304 x 12,5 x 0,64	18	1218UL-2	E0102865	1218UL-10	E0102866	1218UL	E0102867
12" x 1/2" x .025"	304 x 12,5 x 0,64	24	1224UL-2	E0102868	1224UL-10	E0102869	1224UL	E0102870
12" x 1/2" x .025"	304 x 12,5 x 0,64	32	1232UL-2	E0102871	1232UL-10	E0102872	1232UL	E0102873

REMGRIT BI-METAL HACKSAW BLADES

Carbide particles bonded to a steel blade. This saw cuts extremely abrasive materials with no teeth to chip or dull. Carbide grit offers the greatest wear and heat resistance. Cuts on both strokes.

REMGRIT HACKSAW BLADES						
SIZE			1/CARD		50/TUBE	
LENGTH		GRIT	MODEL #	PRODUCT CODE	MODEL #	PRODUCT CODE
INCHES	MM					
10" x 3/4" x .025"	250 x 19 x 0,64	MEDIUM	GH10	E0406161	GH10-50T	E0206151
12" x 3/4" x .025"	304 x 19 x 0,64	MEDIUM	GH12	E0406160	GH12-50T	E0206150

REMGRIT CARBIDE GRIT ROD SAW BLADES

Carbide particles bonded to an alloy steel rod. This saw cuts extremely abrasive materials with no teeth to chip or dull. Carbide grit offers the greatest wear and heat resistance. Ideal for materials that other saws will not cut. Rod design gets into tight areas and cuts on both strokes. Fits any standard hack frame.

REMGRIT CARBIDE GRIT ROD SAW BLADES						
SIZE			1/CARD		50/TUBE	
LENGTH		GRIT	MODEL #	PRODUCT CODE	MODEL #	PRODUCT CODE
INCHES	MM					
10" x .100"	250 x 2,5	FINE GRIT	GG10	E0406181	GG10-50T	E0106174
12" x .100"	300 x 2,5	MEDIUM	GG12	E0406180	GG12-50T	E0106175

CUTS THROUGH


BANDSAW
BLADES

AGGRESSOR PORTABLE BANDSAW BLADES

All teeth have uniform spacing and gulleted depth. Improved cut quality and shock resistance. Blades resist tooth strippage. Cuts aluminum, cast iron, chrome, stainless steel, tungesten steel, and other problem materials at lower speed.

REMGRIT CARBIDE GRIT ROD SAW BLADES						
PRODUCT CODE	SIZE LENGTH X WIDTH X THICKNESS INCHES	SIZE LENGTH X WIDTH X THICKNESS MM	QTY PER BOX	PITCH	TPI	MODEL #
E0102953	44-7/8 x 1/2 x .020	1140mm x 12.5mm x .50mm	3	Variable	10/14	AG4412
E0102960	44-7/8 x 1/2 x .020	1140mm x 12.5mm x .50mm	100	Variable	10/14	AG4412-100
E0102954	44-7/8 x 1/2 x .020	1140mm x 12.5mm x .50mm	3	Variable	14/18	AAG4416
E0102961	44-7/8 x 1/2 x .020	1140mm x 12.5mm x .50mm	100	Variable	14/18	AAG4416-100
E0102955	44-7/8 x 1/2 x .020	1140mm x 12.5mm x .50mm	3	Variable	18/24	AG4420
E0102962	44-7/8 x 1/2 x .020	1140mm x 12.5mm x .50mm	100	Variable	18/24	AG4420-100
E0102956	44-7/8 x 1/2 x .020	1140mm x 12.5mm x .50mm	3	Constant	10 Raker	B4410
E0102963	44-7/8 x 1/2 x .020	1140mm x 12.5mm x .50mm	100	Constant	10 Raker	B4410-100
E0102957	44-7/8 x 1/2 x .020	1140mm x 12.5mm x .50mm	3	Constant	14 Raker	B4414
E0102964	44-7/8 x 1/2 x .020	1140mm x 12.5mm x .50mm	100	Constant	14 Raker	B4414-100
E0102958	44-7/8 x 1/2 x .020	1140mm x 12.5mm x .50mm	3	Constant	18 Raker	B4418
E0102965	44-7/8 x 1/2 x .020	1140mm x 12.5mm x .50mm	100	Constant	18 Raker	B4418-100
E0102959	44-7/8 x 1/2 x .020	1140mm x 12.5mm x .50mm	3	Constant	24 Raker	B4424
E0102966	44-7/8 x 1/2 x .020	1140mm x 12.5mm x .50mm	100	Constant	24 Raker	B4424-100

CUTS THROUGH

METAL

NAIL-EMBEDDED WOOD

AGGRESSOR BI-METAL BANDSAW BLADES

Bi-Metal bandsaw blades have high speed steel teeth for a sharper cut and give you a longer lasting blade. HSS edge contains 8% cobalt. Available in coils or custom-welded to length.

Cut stainless steels with a positive rake angle whenever possible.

NARROW WIDTH BANDS (M-42 & MATRIX II)

5° Positive Rake

- Solids and thick wall tubing of medium to difficult material, such as stainless steels
- 5° positive rake for easier penetration and reduced vibration
- Narrow width from 1/4" to 1/2" for contour and miter cutting
- Narrow width and gauge can be welded by customer for die building and internal cutting re-use
- HSS edge contains 8% cobalt

WIDTH X GAUGE			VARIABLE PITCH						CONSTANT PITCH			
INCHES	MM	COIL LENGTH	MODEL #									
			6/10	8/12	10/14	4 HOOK	6 POSITIVE	10 RAKER	14 RAKER	18 WAVY	24 RAKER	24 WAVY
1/4" x .035"	6,00 x 0,90	250 ft.	--	--	--	--	--	A906	A907	--	--	--
3/8" x .035"	10,0 x 0,90	250 ft.	--	--	A915	A911	--	--	--	--	--	--
1/2" x .020"	12,5 x 0,51	250 ft.	--	--	A821*	--	--	A822*	A823*	A824*	A826*	A825*
1/2" x .025"	12,5 x 0,64	250 ft.	A902	A905	A901	--	--	--	A931	A900	--	--
1/2" x .035"	12,5 x 0,90	250 ft.	--	A919	A936	A937	A908	--	A933	--	--	--

M-1000 M-42 (STRAIGHT TOOTH)

0° Rake

- All-purpose band for moderate to difficult to cut materials
- Provides higher heat and wear durability
- 0° for smoother cutting and general applications

WIDTH X GAUGE			VARIABLE PITCH						CONSTANT PITCH	
INCHES	MM	COIL LENGTH	MODEL #							
			3/4	4/6	5/8	6/10	8/12	10/14	10 RAKER	14 WAVY
3/4" x .035"	19,0 x 0,90	250 ft.	--	--	--	A934	A932	A952	A943	A944
1" x .035"	27,0 x 0,90	250 ft.	A976	A974	A975	A970	A971	A920	--	A973
1-1/4" x .042"	34,0 x 1,10	250 ft.	A965	A964	A966	--	--	--	--	--
1-1/2" x .050"	41,0 x 1,27	150 ft.	--	A980	--	--	--	--	--	--

M-2000 M-42 (POSITIVE RAKE TOOTH)

5° Positive Rake

- Solids and thick wall tubing of medium to difficult material, such as stainless steels
- 5° positive rake for easier penetration and reduced vibration

WIDTH X GAUGE			VARIABLE PITCH					CONSTANT PITCH	
INCHES	MM	COIL LENGTH	MODEL #						
			2/3	3/4	4/6	5/7	2 HOOK	6 RAKER	8 WAVY
3/4" x .035"	19,0 x 0,90	250 ft.	--	--	A9035	A904	--	--	--
1" x .035"	27,0 x 0,90	250 ft.	A9275	A9285	A9295	A930	A916	A922	A923
1-1/4" x .042"	34,0 x 1,10	250 ft.	A9605	A9615	A9625	A963	--	A955†	--
1-1/2" x .050"	41,0 x 1,27	150 ft.	A9775	A9785	A9795	--	--	--	--

* Denotes Matrix II material.
† Denotes this size also available in 450 ft.
When ordering custom welded lengths use the Model # followed by a "W" and your exact welded band length.

M-3000 M-42 (HIGH POSITIVE RAKE TOOTH)

- High production band for difficult to cut materials, such as monels, titanium, inconels, and stainless steels, etc.
- Greater beam strength
- Specially engineered relief angle
- 10° high positive rake for faster cutting time
- Designed for maximum strength when cutting difficult materials such as super alloys

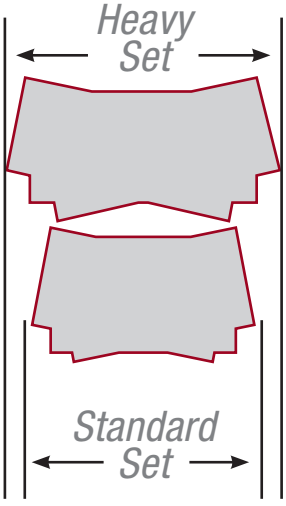
10° High Positive Rake with DUPLEX Tooth

WIDTH X GAUGE			VARIABLE PITCH		
			MODEL #		
INCHES	MM	COIL LENGTH	2/3	3/4	4/6
3/4 x .035	19,0 x 0,90	250 ft.	--	--	A903
1 x .035	27,0 x 0,90	250 ft.	A927	A928	A929
1-1/4 x .042	34,0 x 1,10	250 ft.	A960	A961	A962
1-1/2 x .050	41,0 x 1,27	150 ft.	A977	A978*	A979
2 x .063	54,0 x 1,60	150 ft.	A981	A982	A983

M-4000 M-42 (HEAVY SET)

- For large and bundle cutting of structural steel
- Ideal for applications where a larger kerf is needed to prevent blade pinching and stalling from material stresses and movement

Positive Rake

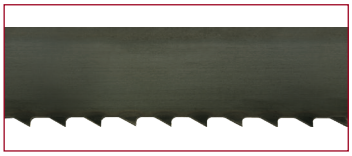


WIDTH X GAUGE			VARIABLE PITCH			
			MODEL #			
INCHES	MM	COIL LENGTH	2/3	3/4	4/6	5/7
1" x .035"	27,0 x 0,90	250 ft.	AXS927	--	AXS929	AXS930
1-1/4" x .042"	34,0 x 1,10	250 ft.	--	AXS961	AXS962	AXS989
1-1/2" x .050"	41,0 x 1,27	150 ft.	--	AXS978*	AXS979	AXS9885
2" x .063"	54,0 x 1,60	150 ft.	--	--	AXS983	--
2" x .063"	54,0 x 1,60	150 ft.	A981	A982	A983	

*This size stocked & shipped as 250 ft. coils.
When ordering custom welded lengths use the Model # followed by a "W" and your exact welded band length.

AGGRESSOR CARBON BANDSAW BLADES

Carbon bandsaws are made for general cutting applications. They are ideal for straight and contour cutting. Use to cut carbon tool steels, tubing, solids, structurals, cast iron, and non-ferrous metals.



HARDBACK CARBON

- Solid carbon steel
- Tooth hardness 62 HRc - 66 HRc
- Back hardened up to 45 HRc for straight cuts
- Supports heavier feed pressure

WIDTH X GAUGE			CONSTANT PITCH								
			MODEL #								
INCHES	MM	COIL LENGTH	3 SKIP	4 SKIP	6 SKIP	6 RAKER	8 RAKER	10 RAKER	14 RAKER	18 RAKER	24 RAKER
1/4 x .025	6,00 x 0,64	250 ft.	--	211	213	--	--	214	215	216	217
3/8 x .025	10,0 x 0,64	250 ft.	--	223	--	--	--	226	227	228	--
1/2 x .025	12,5 x 0,64	250 ft.	--	234	--	236	--	237	239	241	243
3/4 x .032	19,0 x 0,81	250 ft.	262	--	--	264	265	267	271	--	--
1 x .035	25,0 x 0,89	250 ft.	--	--	--	280	--	282	284	--	--
1 1/4 x .042	32 x 1,07	500 ft.	--	--	--	295	--	--	--	--	--
			2 HOOK	3 HOOK	4 HOOK	6 HOOK	10 WAVY	14 WAVY	18 WAVY	24 WAVY	
1/4 x .025	6,0 x 0,64	250 ft.	--	--	210	212	--	--	--	--	
3/8 x .025	10,0 x 0,64	250 ft.	--	220	222	224	--	--	--	--	
1/2 x .025	12,5 x 0,64	250 ft.	--	231	233	235	238	240	--	242	
3/4 x .032	19,0 x 0,81	250 ft.	--	261	--	263	268	272	273	--	
1 x .035	25,0 x 0,89	250 ft.	275	277	--	--	283	--	--	--	

FLEXBACK CARBON

- Solid carbon steel
- Tooth hardness 62 HRc - 66 HRc
- Back hardened up to 38 HRc for contour cutting
- Available in 250 ft. coils or custom-welded to length
- Cuts wood, cast iron, brass, aluminum, zinc, copper, mild steels, non-ferrous metals, fiberglass, plastic, bronze, and lead

WIDTH X GAUGE			CONSTANT PITCH								
			MODEL #								
INCHES	MM	COIL LENGTH	3 SKIP	4 SKIP	6 SKIP	6 RAKER	8 RAKER	10 RAKER	14 RAKER	18 RAKER	24RAKER
1/4 x .025	6,0 x 0,64	250 ft.	--	041	043	--	--	044	046	047	048
3/8 x .025	10,0 x 0,64	250 ft.	--	063	--	--	065	066	068	069	--
1/2 x .025	12,5 x 0,64	250 ft.	--	094	--	097	--	098	100	102	104
3/4 x .032	19,0 x 0,81	250 ft.	142	--	--	144	146	148	152	154	--
1 x .035	25,0 x 0,89	250 ft.	172	--	--	174	175	176	--	--	--
			2 HOOK	3 HOOK	4 HOOK	6 HOOK	14 WAVY	24 WAVY			
1/4 x .025	6,0 x 0,64	250 ft.	--	--	040	042	--	--			
3/8 x .025	10,0 x 0,64	250 ft.	--	060	062	064	--	--			
1/2 x .025	12,5 x 0,64	250 ft.	--	091	093	096	101	105			
3/4 x .032	19,0 x 0,81	250 ft.	--	141	139	143		--			
1 x .035	25,0 x 0,89	250 ft.	170	171	--	--	--	--			

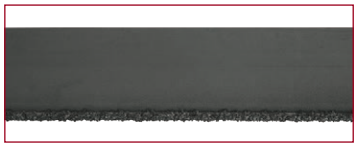
When ordering custom welded lengths use the Model # followed by a "W" and your exact welded band length.

REMGRIT CARBIDE GRIT BANDSAW BLADES

RemGrit® cuts through materials conventional tooth blades can't penetrate! Recommended for use in super alloys, fiberglass, honeycomb, foamed glass, hardened steel, graphite composites, fiber cement board and composite deck material.

GULLETED EDGE

- Tungsten carbide grit bonded to an alloy steel back
- Carbide particle placement enables band to be run in either direction
- Unequalled life and cutting performance for hard or abrasive material



CONTINUOUS EDGE

- Use continuous edge for material less than 1/4" thick or for hard material with a tendency to fracture, crack, or chip easily
- Carrier wheels should be a minimum of 24" diameter

WIDTH X GAUGE			VARIABLE PITCH						CONTINUOUS		
			MODEL #								
INCHES	MM	COIL LENGTH	MEDIUM	MEDIUM COARSE	COARSE (EXTRA TEMPER) TIRE CUTTING	COARSE	COARSE (SHORT TOOTH)	COARSE (DEEP GULLET)	MEDIUM	MEDIUM COARSE	COARSE
1/4 x .020	6,00 x 0,51	250 ft.	308	--	--	--	--	--	310	--	--
3/8 x .025	10,0 x 0,89	250 ft.	322	324	--	--	--	--	328	--	--
1/2 x .020	12,5 x 0,51	250 ft.	335	--	--	--	--	--	337	338	--
1/2 x .025	12,5 x 0,64	250 ft.	330	331	--	--	--	--	333	334	--
3/4 x .032	19,0 x 0,81	250 ft.	341	--	--	344	--	--	346	--	349
1 x .035	25,0 x 0,89	250 ft.	--	350	381	351	--	352	--	--	357
1-1/4 x .035	32,0 x 0,89	250 ft.	--	--	--	--	--	362	--	--	363
1-1/4 x .042	32,0 x 1,07	250 ft.	--	--	--	--	--	365	--	--	--
1-1/2 x .042	38,0 x 1,07	250 ft.	--	--	--	--	374	--	--	--	--

RECOMMENDED BAND SPEEDS

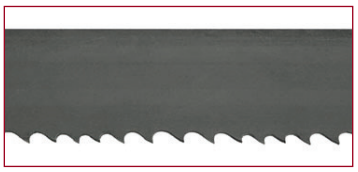
BLADE	SFPM	MATERIAL	BLADE	SFPM	MATERIAL
Coarse	150 - 200	Tool Steel (HrC 42-65)	Medium	200-1200	Green Unfired Ceramics
Med. Coarse	150 - 300	Nitride Case Hardened and Inductive Hardened Steels	Med. Coarse	800-1500	Fiber Reinforced Cement
Coarse	150 - 400	High-Temp Nickel and Iron Base Super Alloys	Med. Coarse	1000-3000	Friction Materials
Coarse	120 - 300	Hastelloys	Medium	4000-6000	Fiberglass Honeycomb
Med. Coarse	150 - 500	Aircraft and Sheet Stainless	Medium	1000-3000	Fiberglass Reinforced Plastics (polymers, epoxies, melamine, phenolics)
Coarse	150 - 600	Beryllium	Medium	1500-3000	Graphite Composites
Med. Coarse	125 - 700	Sintered Tungsten, Molybdenum, Iron, and Stainless	Medium	200-1000	Aircraft Tooling and Molding Compounds
Med. Coarse	125 - 300	Welds and Met-Lab Specimens	Coarse	1000-4000	Carbon and Graphite
Coarse	150 - 350	White and High Alloy Cast Iron	Medium	500-1000	Glass
Coarse	150 - 300	Grey Cast Iron	Coarse	1200-3000	Wire Reinforced Rubber
Coarse	150 - 400	Titanium	Medium	1200-3000	Cable and Wire Rope
Med. Coarse	1000 - 3000	Foamed Glass	Coarse	400-1600	Compressed Perlite Molding Compounds
Med. Coarse	300 - 700	Syntactic Foam	Med. Coarse	120-500	Cement Lined Steel and Cast Iron Pipe
Medium	500 - 1500	Low Density Ceramics	Coarse	150-600	Soapstone, Chalk, Lava, Slate, and Coal

Shading indicates coolant recommended.
When ordering custom welded lengths use the Model # followed by a "W" and your exact welded band length.

BANDSAW BLADES

BANDSAW INDEX

Disston offers a complete range of bandsaws in various widths, pitches and tooth configurations for most cutting applications. We have a full offering of bi-metal bands, carbon bands and for highly abrasive materials. We offer our RemGrit® carbide grit bands in both continuous and gulleted edges.

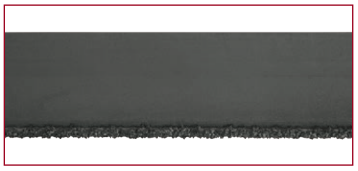


AGGRESSOR BI-METAL BANDSAW BLADES

Bi-metal bandsaw blades have high speed steel teeth for a sharper cut and give you a longer lasting blade. HSS edge contains 8% cobalt. Available in coils or custom-welded to length.

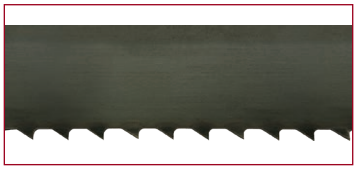
REMGRIT CARBIDE GRIT GULLETED EDGE BANDSAW BLADES

RemGrit® cuts through materials conventional tooth blades can't penetrate! Recommended for use in super alloys, fiberglass, honeycomb, foamed glass, hardened steel, graphite composites, fiber cement board and composite deck material.



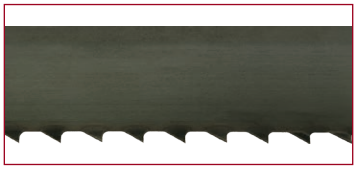
REMGRIT CARBIDE GRIT CONTINUOUS EDGE BANDSAW BLADES

RemGrit® cuts through materials conventional tooth blades can't penetrate! Recommended for use in super alloys, fiberglass, honeycomb, foamed glass, hardened steel, graphite composites, fiber cement board and composite deck material.



AGGRESSOR HARDBACK CARBON BANDSAW BLADES

Carbon bandsaws are made for general cutting applications. They are ideal for straight and contour cutting. Use to cut carbon tool steels, tubing, solids, structurals, cast iron, and non-ferrous metals.



AGGRESSOR FLEXBACK CARBON BANDSAW BLADES

Carbon bandsaws are made for general cutting applications. They are ideal for straight and contour cutting. Use to cut carbon tool steels, tubing, solids, structurals, cast iron, and non-ferrous metals.

BANDSAW BLADES

GUIDELINES FOR SUCCESSFUL BANDSAW OPERATION

BLADE WIDTH SELECTION

The dimension from tooth tip to back edge of the blade is the blade width. The greater the width, the greater the resistance to deflection while cutting. For straight cutting applications, use the widest blade the machine can accept. For contour cutting use the widest blade that the contour radius will permit. To cut close tolerance radii the following factors must be considered: blade width, material thickness, machinability, feed force, and location of pivot point.

TEETH PER INCH

The pitch of the blade is defined by the number of teeth per inch (TPI). Nonferrous materials such as brass, bronze and aluminum require a large chip area. A low TPI, or "coarse pitch," prevents the chips from clogging and binding together in the gullets, which can diminish sawing and damage the blade.

On thin walled pipe, tubing, and sheet goods, many teeth per inch are required to avoid damaging or breaking the teeth. A low TPI blade is the best blade for cutting large cross-sections. The ability of each tooth to cut into the workpiece is increased because the saw's feed pressure is distributed over fewer teeth. A coarse pitch blade increases productivity and provides large chip clearing gullets.

BLADE BREAK-IN

Set bandsaw machine at recommended speed for material to be cut. When cutting easily machined metals, cutting rate should be set at 1/3 to 1/2 the recommended rate for the first 50 to 75 square inches.

When cutting difficult to machine metals, such as tool steels or work hardened alloys, set cutting rate at 75% of the recommended rate for the first 25 square inches. Gradually increase the feed until you achieve the recommended cutting rate after 50 to 60 square inches.

TOOTH SELECTION

Tooth selection is based on the principle that there is a tooth pitch best suited for the cutting job. Blade selection should be based on the size, shape accuracy, material and cutting rate expected.

Keep in mind these numbers: 3, 6, 12, and 24. There should be a minimum of three teeth in the work at all times for bi-metal bands and a minimum of six teeth for carbon bands. Ideally, 6 – 12 teeth should be in contact with the work; 24 teeth in the work is too many.

FEED PRESSURE

Chips tell you what is happening with your feed pressure and your blade. Powdery or fine chips indicate that not enough feed pressure is being applied. Heavy, thick or blue burned chips mean you're pushing the blade too hard, creating too much heat and load for the teeth. Loosely curled chips tell you everything is going well. Speed should be determined by the class of material (this should remain constant.) Feed would be adjusted until desired chip formation is achieved.

MACHINE CHECKLIST

- The blade tension with a tension meter
- The performance of the chip brush
- The wear and alignment of the blade guides
- The band speed with a tachometer
- The cutting fluid concentration with a refractometer

CUTTING FLUID

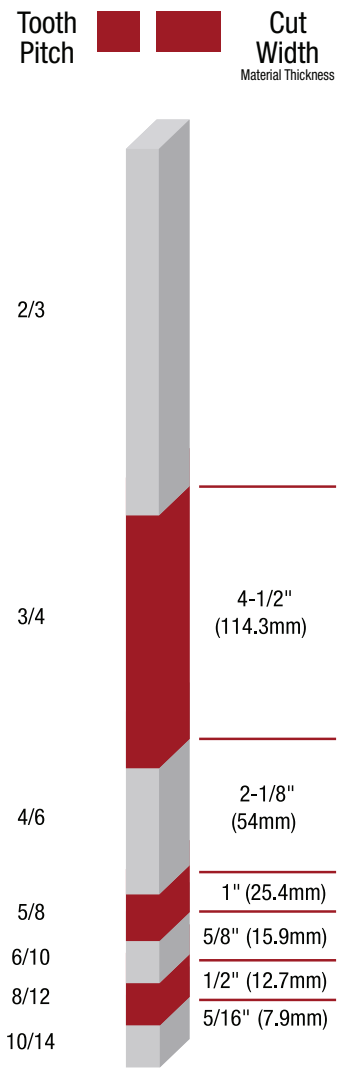
The cutting fluid keeps the blade teeth cool, it prevents the chips from welding to the tooth, and also lubricates the chips, allowing them to move through the cut.

- Use a high quality cutting fluid
- Make sure the cutting fluid is distributed throughout the cut

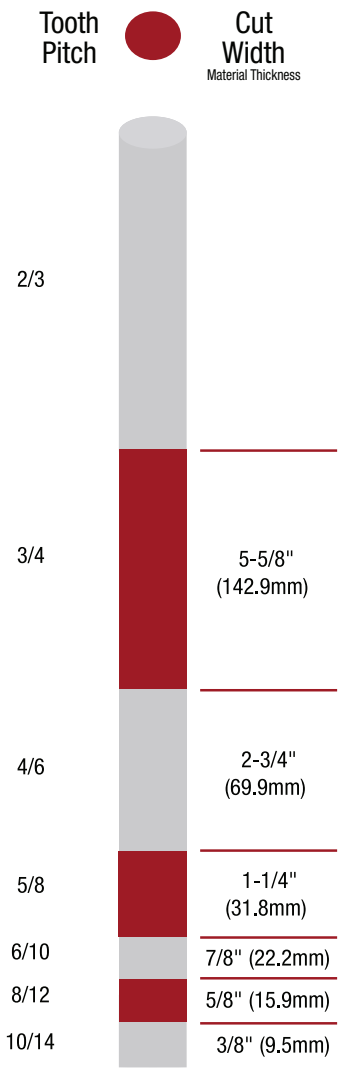
TOOTH PITCH SELECTION

For lowest cost per cut, always select the narrowest cross section of the material to be cut for added beam strength, more teeth in cut, longer life, higher band speed, and shortest cut time.

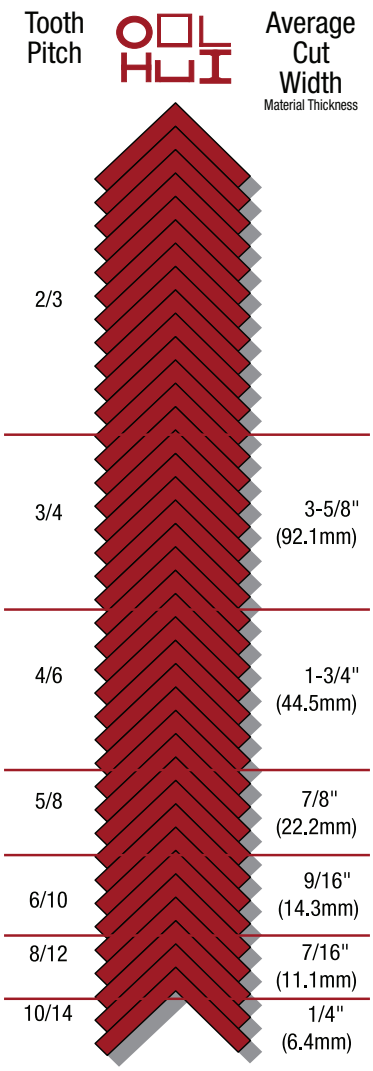
Solid Square & Rectangle



Solid Round

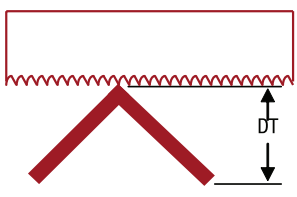


Structurals

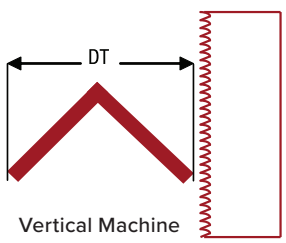


Area = pounds per foot x .294

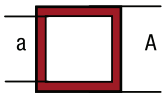
Aluminium Structural Area - pounds per foot x .85



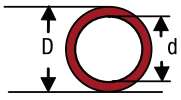
Horizontal Machine



Vertical Machine



A - a = area



D = .7854 x D ^{2}
d = .7854 x d ^{2}
D - d = area
πr^2 = area

$$\frac{\text{area}}{\text{(DT) distance of travel}} = \text{average cut width}$$

BANDSAW BLADES

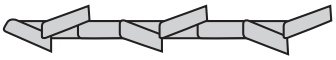
BANDSAW TERMS

TOOTH FORM

Positive Rake. A positive rake tooth angles forward in the direction of the cutting action. Higher positive rake angles give the most aggressive tooth penetration for easier chip formation. This tooth form is recommended for cutting difficult-to-machine materials, solids, and solid cross sections.

Straight Tooth. A straight tooth has a 0° cutting face, and is recommended for cutting easy-to-cut, low alloy materials as well as interrupted cuts.

TOOTH SET



Raker Set. These are individually set teeth – first right then left – followed by an unset tooth. The unset tooth (raker tooth) allows for fast chip removal and a straight cutting action. This tooth set is recommended for general purpose cutting applications.

Wavy Set. Wavy set teeth are set in groups, right and left, in varying degrees. Wavy set teeth are recommended for cutting light metal sections, such as sheet, tubing and small solid shapes.

Modified Raker Set. Variable set teeth are set in alternating groups with a single unset tooth (raker tooth). When these are combined with the varying set angles of the teeth, a faster, smoother, and quieter cutting action is achieved. Variable tooth blades perform extremely well on most applications and provide fast cutting on solids, shapes, structurals and piping.

TOOTH TYPE

Regular. This is a conventional tooth with a 0° rake angle, ideal for a wide range of general purpose cutting applications.

Hook. This tooth type has a 10° positive rake angle for fast cutting with less feed pressure. The rounded gullets allow for fast chip removal and are generally used for cutting nonmetallics and nonferrous metals.

Skip. This tooth type has a 0° rake angle with shallow gullets and evenly spaced teeth for efficient chip removal. It is used for cutting large sections of soft, nonferrous metal and nonmetal material, such as wood, composition materials, cork and plastic.

Variable. A traditional tooth form that offers a 0° rake angle, varying gullet depths and tooth sizes. Designed to reduce harmonic vibration, this blade efficiently removes chips, extending blade life in solids and structurals.

Variable Positive. Variable positive tooth form offers varying gullet depth, tooth sizes and a positive rake angle for maximum cutting speeds and better tooth penetration in harder to machine materials.

Duplex. Duplex blades offer deep, chip clearing gullets, increased tooth strength, and a high positive rake angle. This results in faster sawing rates and improved finishes. Duplex blades are recommended for production cutting work hardened metals, tool steels, and exotic alloys.

BANDSAW BLADES

RECOMMENDED BANDSAW OPERATING SPEEDS (FPM TABLE)

BAND SPEEDS
based on 4" material

INCREASE
for smaller sizes 2" +10%

DECREASE
for larger sizes 6" -10%

CARBON STEELS		ALLOY STEELS		TOOL & MOLD STEELS		STAINLESS STEEL		SUPER ALLOTS	
MATERIAL	FPM	MATERIAL	FPM	MATERIAL	FPM	MATERIAL	FPM	MATERIAL	FPM
1008	320	150	250	A10	160	230	150	A286	90
1015	320	1330	220	A2	180	303	140	Astroloy	60
1018	300	1345	210	A6	200	304	120	Hastelloy	70
1020	320	4130	270	D2	90	309	90	Incoloy 800	90
1021	300	4140	250	H11	190	310	80	Incoloy 900	60
1022	300	4145	210	H12	190	316	100	Inconel	60
1025	320	4340	220	H13	190	324	100	Inconel 625	100
1026	300	5160	220	L6	190	347	110	Monel	70
1030	330	6150	210	M1	110	410	140	Nickel 200	80
1035	310	8616	240	M42	100	414	110	Pyromet X15	120
1040	270	8620	240	O1	200	416	190	Titanium	70
1042	250	8630	220	O6	190	420	190	Waspalloy	70
1044	220	8640	200	P20	230	430	150	WF11	60
1045	220	9310	170	S1	200	431	90		
1060	200	52100	160	S5	140	450	80		
1095	180	300M	160	S7	120	502	140		
1117	340	41L40	270	T1	100	2205	80		
1137	290	A242	280	T15	70	18-8-2	90		
1141	280	e.t.d.	250	W1	220	22-13-5	60		
1144	280	HP 9-4-20	100			440C	80		
1213	380	HP 9-4-25	100			440F	160		
1215	380	HY-100	160			M225	90		
1513	300	HY-80	160			Nitronic 50	60		
1541	250					Nitronic 60	60		
A36	270					SS-PH	80		

BLADE BREAK-IN

It is important to run all new bandsaw blades at a reduced rate to break them in. This helps to remove any uneven edges that are imparted on cutting tools during the manufacturing processes, and can double the life of the blade.

To break in a blade:

1) Set machine to the recommended band speed for the material being cut.

2) Multiply the recommended cut time by:
   a. 2 – for band speeds 250 fpm and higher
   b. 1.75 – for band speeds 175 to 250 fpm
   c. 1.5 – for band speeds 120 to 175 fpm
   d. 1.25 – for band speeds 80 to 120 fpm
   e. Band speeds less than 80 fpm require minimal break-in

3) Gradually increase cutting rate to proper cut time over the next:
   a. 80 to 100 sq. in.
   b. 60 to 80 sq. in.
   c. 40 to 60 sq. in.
   d. 20 to 40 sq. in.
   e. 20 or less sq. in.

BANDSAW BLADES

FEEDS

Tooth Pitch	10/14	8/12	6/10	5/8	5/7	4/6	3/4	2/3
Multiplier Rate (MR)	.047	.039	.031	.025	.024	.020	.014	.010
(mm)	(1.19)	(.99)	(.79)	(.64)	(.61)	(.51)	(.36)	(.25)

After determining proper tooth pitch and band speed, select the rate MR (multiplier rate) for the tooth pitch being considered and use this formula to determine feedrate:

Band Speed x MR = Linear Inches per Minute Rate

For the lowest cost per cut, always select/position the material to obtain the narrowest cross section to be cut for added beam strength, more teeth in cut, longer tool life, higher band speed, and quickest cut time.

When stacking material, multiply the area of each piece by the number of pieces, then divide by the DT (distance of travel) to obtain average cut width for selection of proper tooth pitch.

When using a smaller tooth pitch than normal, use the MR (multiplier rate) listed for the proper selection to minimize over-filling the gullets of the smaller teeth.

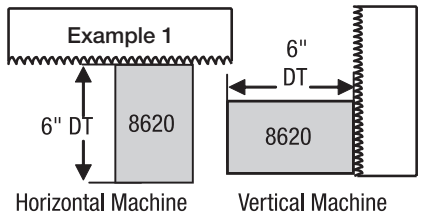
For increased production, after determining the beam strength, material clamping, coolant, tooth pitch, and machine condition are all appropriate, the MR (multiplier rate) can be increased up to 25%.

$$\frac{\text{(DT) distance of travel}}{\text{Linear in/min}} = \text{(CT) cut time}$$

Example 1:

4" X 6" 8620, band speed 240 fpm, recommended tooth pitch 3/4 cutting the 4" width = MR .014

240 X .014 = 3.36 linear in/min

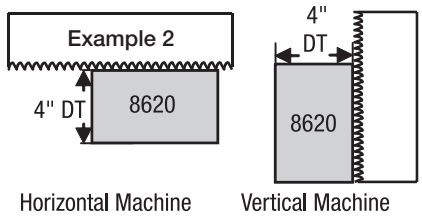


$\frac{\text{6" (DT)}}{\text{3.36 L in/min}}$ = 1.79 min (CT) (1 min. 47 sec.)

Example 2:

4" X 6" 8620, band speed 215 fpm, recommended tooth pitch 2/3 cutting the 6" width = MR .010

215 X .010 = 2.15 linear in/min

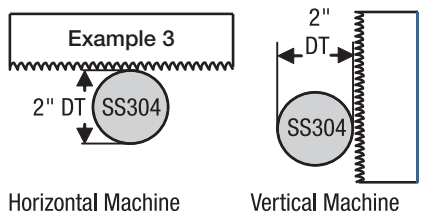


$\frac{\text{4" (DT)}}{\text{2.15 L in/min}}$ = 1.86 min (CT) (1 min. 52 sec.)

Example 3:

2" dia. SS304, band speed 132 fpm, recommended tooth pitch 4/6 cutting the 2" width = MR .020

132 X .020 = 2.64 linear in/min

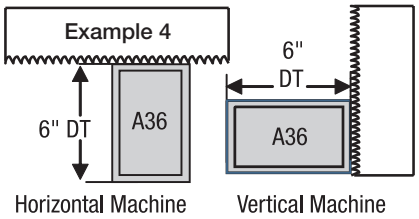


$\frac{\text{2" (DT)}}{\text{2.64 L in/min}}$ = .75 min (CT) (45 sec.)

Example 4:

4" X 6", 1/4" wall A36, band speed 270 fpm, recommended tooth pitch 5/8 cutting the .79" avg. cut width = MR . 025

270 X .025 = 6.75 linear in/min

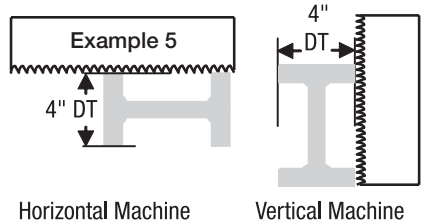


$\frac{\text{6" (DT)}}{\text{6.75 L in/min}}$ = .88 min (CT) (53 sec.)

Example 5:

"I" beam, 37.41 lbs/ft A36, band speed 240 fpm, recommended tooth pitch 3/4 cutting the 1.83" avg. cut width = MR .014

240 X .014 = 3.36 linear in/min

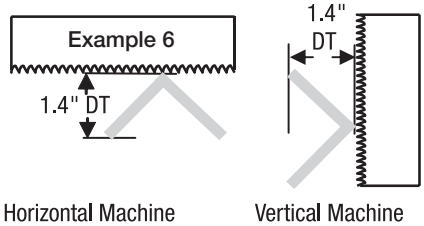


$\frac{\text{4" (DT)}}{\text{3.36 L in/min}}$ = 1.19 min (CT) (1 min. 11 sec.)

Example 6:

2" angle 1/4" wall A36, band speed 300 fpm, recommended tooth pitch 5/8 cutting the .7" avg. cut width = MR .025

300 X .025 = 7.5 linear in/min



$\frac{\text{1.4" (DT)}}{\text{7.5 L in/min}}$ = .19 min (CT) (11 sec.)


DRILL BITS

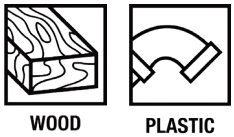
BLU-MOL XTREME THREADED SPADE BITS

Threaded spade bits are up to 10x faster than standard spade bits.

FEATURES

1. Hex shank for quick change and no-slip shank
2. Black oxide coating prevents rust and extends life
3. Twin spurs and reamer for cleaner holes
4. Threaded tip for fast, effortless drilling

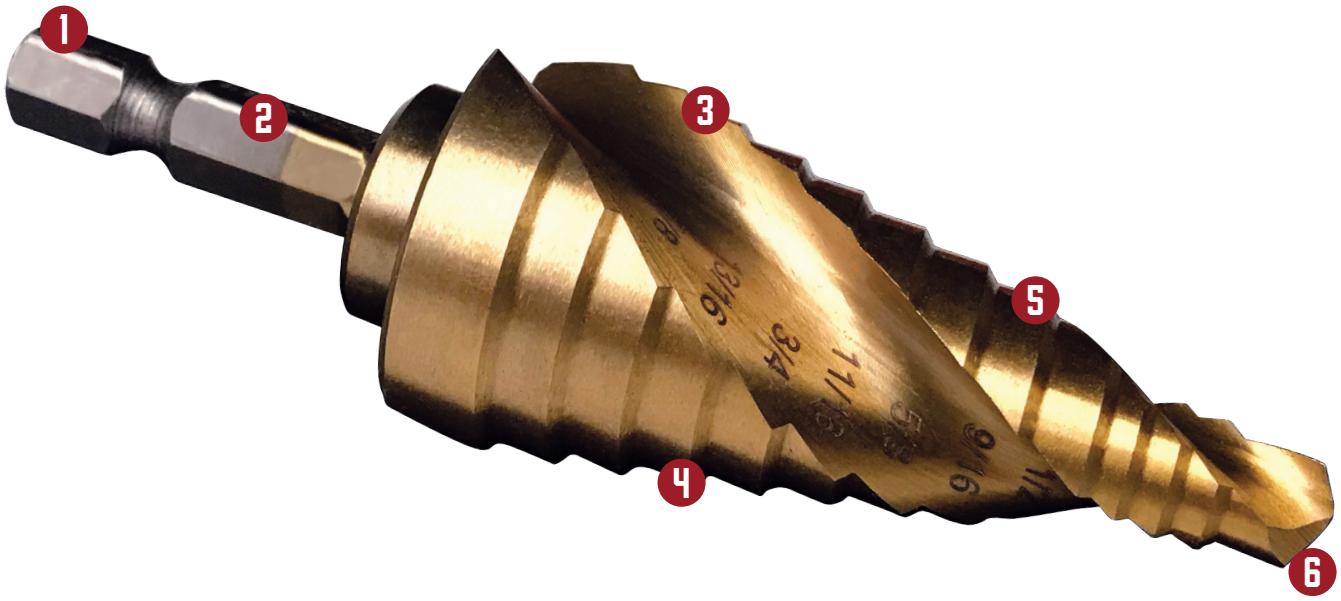
DRILLS THROUGH



MODEL #	DIA.	BIT LENGTH	PRODUCT CODE
2677	3/8"	6"	E0102677
2678	7/16"	6"	E0102678
2679	1/2"	6"	E0102679
2680	9/16"	6"	E0102680
2681	5/8"	6"	E0102681
2682	11/16"	6"	E0102682
2683	3/4"	6"	E0102683
2684	13/16"	6"	E0102684
2685	7/8"	6"	E0102685
2686	15/16"	6"	E0102686
2687	1"	6"	E0102687
2688	1-1/8"	6"	E0102688
2689	1-1/4"	6"	E0102689
2690	1-3/8"	6"	E0102690
2691	1-1/2"	6"	E0102691
2692	3/8"	16"	E0102692
2693	1/2"	16"	E0102693
2694	5/8"	16"	E0102694
2695	3/4"	16"	E0102695
2696	7/8"	16"	E0102696
2697	1"	16"	E0102697
2698	6PC: 3/8", 1/2", 5/8", 3/4", 7/8", and 1"	6"	E0102698
2699	13PC: 1/4", 5/16", 3/8", 7/16", 1/2", 9/16", 5/8", 11/16", 3/4", 13/16", 7/8", 15/16", 1"	6"	E0102699

BLU-MOL XTREME SPIRAL STEP DRILLS

Impact-rated for high torque applications, the BLU-MOL Xtreme® Spiral Step Drills provide up to 4x faster cutting than standard two fluted step drills. The Spiral Step Drill's continuous cutting action delivers faster and cleaner hole enlargement, while the self-start dual cutting split point creates engagement and minimized walking. Built tough, the M35 cobalt provides strength and durability that makes these bits last.



FEATURES

1. Impact rated for high torque applications
2. 1/4" quick change shank for quick change and no-slip drilling
3. Titanium nitride coating extends the life of the bit
4. M35 cobalt provides strength and durability
5. Continuous cutting action allows for faster, cleaner hole enlargement
6. Self-start dual cutting split point provides engagement and minimizes walking

MODEL #	PRODUCT DESCRIPTION	# OF STEPS	SIZES	PRODUCT CODE
2780	#1 spiral step drill	13 steps	1/8" to 1/2"	E0102780
2781	#3 spiral step drill	9 steps	1/4" to 3/4"	E0102781
2782	#4 spiral step drill	11 steps	3/16" to 7/8"	E0102782
2783	#5 spiral step drill	13 steps	1/2" to 1"	E0102783
2784	#9 spiral step drill	15 steps	1/4" to 1-1/8"	E0102784
2785	#6 spiral step drill	15 steps	1/4" to 1-3/8"	E0102785
2786	4-piece spiral step drill premium kit		(1/8"-1/2", 1/4"-7/8", 1/4"-1 1/8", 1/4"-1 3/8")	E0102786

DRILLS THROUGH

BLU-MOL XTREME QUAD-TIPPED GLASS & TILE DRILL BITS

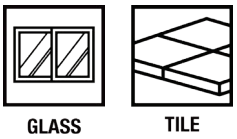
BLU-MOL Xtreme® glass & tile bits feature quad-tipped carbide tips which improve durability, accuracy and speed above standard glass & tile bits.

FEATURES

1. Polished bright finish provides maximum dust ejection
2. Solid high-grade tungsten carbide quad-tipped bit creates smooth holes

DIA.	MODEL #	MIN. ORDER QTY.	PRODUCT CODE
3/16"	4430	6	E0104969
1/4"	4431	6	E0104970
5/16"	4432	6	E0104971
3/8"	4433	6	E0104972
1/2"	4434	6	E0104973
5/8"	4435	6	E0104974
3/4"	4436	6	E0104975
1"	4437	6	E0104976

DRILLS THROUGH



WORK TABLES

OMNITABLE | 4-IN-1 PORTABLE TABLE

4-in-1 portable worktable with 500 lb capacity. Lightweight at only 33 lbs with a large work surface at 37" x 18".

MODEL # 30140 | E0130140

A WORKTABLE

B SCAFFOLD

C CREEPER

D DOLLY

FEATURES

1. Non-slip surface
2. Reversible top panel
3. Three adjustable heights
4. 500 lb capacity

OTHER BENEFITS

- Carry handle
- Cutting groove
- Durable cutting surface
- Built-in protractor
- Accessory storage tray
- Drill hole
- Steel hammer surface

OMNITABLE PLUS | 5-IN-1 PORTABLE TABLE

5-in-1 portable worktable with 330 lb capacity. Lightweight at only 28 lbs with a large work surface at 37" x 19".

MODEL # 0145 | E0130145

A WORKTABLE

B CLAMPING TABLE

C SCAFFOLD

D CREEPER

E DOLLY

FEATURES

1. Telescopic legs
2. Clamping system for quick release bar clamps
3. Four adjustable heights
4. Leg supporting bars

OTHER BENEFITS

- Built-in protractor
- Accessory storage tray
- Dividing ruler
- Carry handle
- Wheels
- Rope connector
- Screwdriver holder
- (2) 110V outlets & (2) USB

WARRANTY INFORMATION

ONE-YEAR LIMITED WARRANTY POLICY

1. DEFINITIONS

"Product" or "Products" means any product(s) manufactured for or by Disston Company (hereinafter "Disston"). "Date of Original Retail Purchase" is the date the customer first bought the Product.

2. SCOPE OF WARRANTY

DISSTON WARRANTS that its Products are free from defective materials and workmanship for a period of ONE (1) YEAR from the Date of Original Retail Purchase. This warranty does not extend to Products that have been damaged by accident, abuse, misuse, or misapplication; or to Products that have been modified or altered.

3. WARRANTY PROCEDURES

Disston will, at its option, repair, replace or credit an amount equal to the purchase price of the Product in addition to any shipping paid by the customer, provided that the customer first contacts Disston's customer service department for return authorization and instructions. Upon return authorization, the Product should be returned to Disston with shipping prepaid for review and evaluation. The contact information for Disston's customer service department is as follows:

Disston Company
45 Plainfield Street
Chicopee, MA 01013
Phone: 800-272-4436 800-446-8890
Fax: 800-654-1972 888-729-3004
Email: customer.service@disstontools.com

International Phone: 413-523-1883
International Fax: 413-523-1854

Disston reserves the right to require reimbursement for shipping costs if the Product received by Disston is not covered by this warranty and the customer requests that the product be returned.

4. LIMITATIONS ON WARRANTY

THE WARRANTY AND REMEDIES SET FORTH ABOVE ARE EXCLUSIVE AND IN LIEU OF ALL OTHERS, WHETHER ORAL OR WRITTEN, EXPRESSED OR IMPLIED. DISSTON COMPANY SPECIFICALLY DISCLAIMS ANY AND ALL IMPLIED WARRANTIES, INCLUDING, WITHOUT LIMITATION, WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. NO DISSTON COMPANY REPRESENTATIVE, EMPLOYEE, DEALER, RESELLER, OR AGENT IS AUTHORIZED TO MAKE ANY MODIFICATION, EXTENSION OR ADDITION TO THIS WARRANTY. DISSTON IS NOT RESPONSIBLE FOR SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES RESULTING FROM ANY BREACH OF WARRANTY, OR UNDER ANY OTHER LEGAL THEORY.

Some states do not allow the exclusion or limitation of incidental or consequential damages or exclusions of implied warranties, so the above limitations or exclusion may not apply to you. This warranty gives you specific legal rights, and you may also have other rights that vary from state to state.

Lead times may vary. Please contact your Sales Representative for more information.

NOTES

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