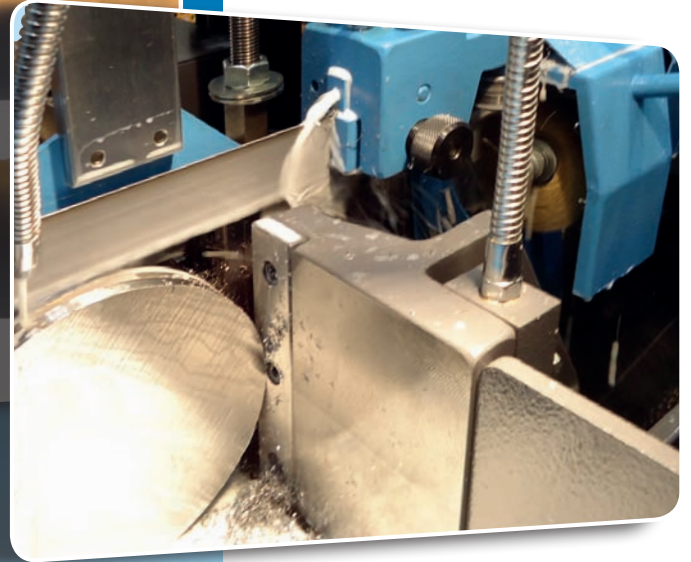
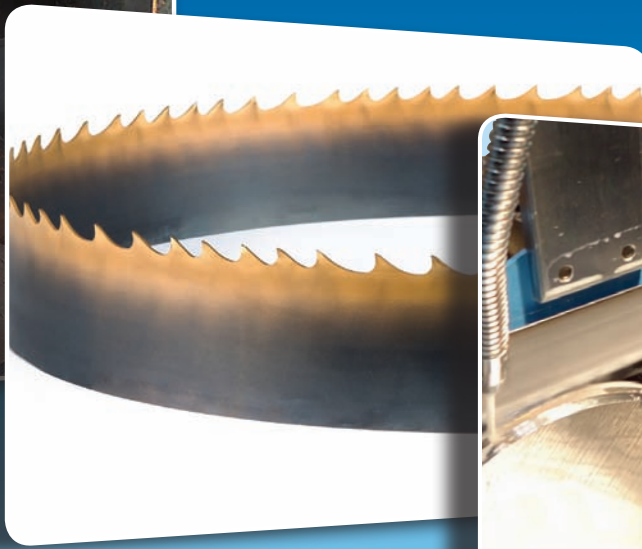
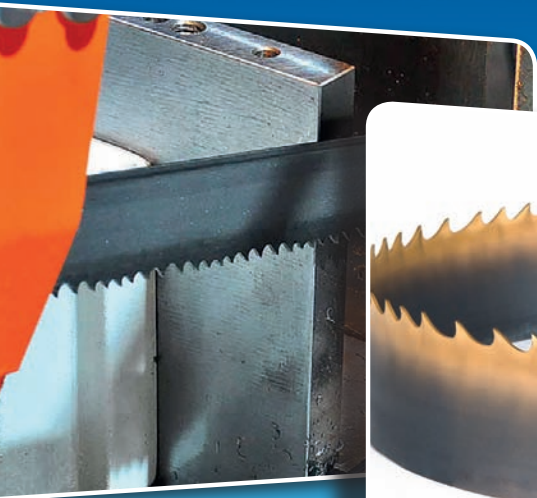


# BAND SAW BLADES



SAWING PRODUCTS



Products that are a cut above the rest!



FOR ALL YOUR SAWING NEEDS!

BAND SAW BLADES | CIRCULAR SAW BLADES | BAND SAWING MACHINES | CIRCULAR SAWING MACHINES | CUTTING FLUIDS





## EXPERTS

The DoALL brand is known for bandsawing from day one. DoALL invented the first metal cutting band saw and since then DoALL has continued to be a leader in band sawing innovations. We are the only manufacturer to offer all the sawing elements, including sawing machines, blades, cutting fluids and material handling. Products that are a cut above the rest!

With our years of experience we are true metalworking experts. Our DoALL technical support team and customer service team will work with you to find the right solution for your sawing application.

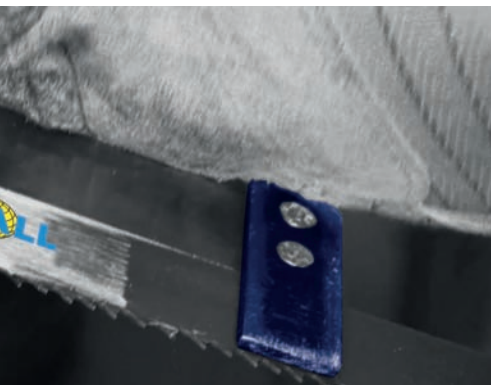
PAST - PRESENT - FUTURE - **DoALL**

MACHINES | BAND SAW  
; FLUIDS | CIRCULAR SA  
BLADES | BAND SAWING  
HINES | CIRCULAR SAW  
SAW BLADES | CUTTING

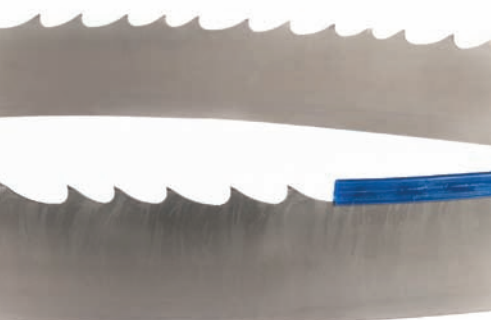


FOR ALL YOUR





BLADES | CUTTING FLU  
W BLADES | BAND SAWI  
G MACHINES | CUTTING  
ING MACHINES | BAND  
FLUIDS | CIRCULAR SAI



SAWING NEEDS!

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Band speed & group selector

Material group	Group no	DIN	Werkstoff number	AISI (SAE)	GHOST	Cutting speed (m/min.)					
						Bi-Metal			Carbide		
						Diameter >>>	<4" (100 mm)	4"-16" (100-400 mm)	>16" (400 mm)	<4" (100 mm)	4"-16" (100-400 mm)
Blade width >>>		1 1/4" (34 mm)	1 1/2" (41 mm)	2" (54 mm)	1 1/4" (34 mm)	1 1/2" (41 mm)	2" (54 mm)				
Structural steels	1	St37/St42	1.0037/1.0042	1015	St3ps	70 - 90	60 - 80	50 - 70	120 - 160	110 - 150	100 - 140
		St52/St60	1.0050/1.0060	ASTM-A570	St6ps	45 - 60	40 - 55	40 - 55	90 - 120	85 - 120	95 - 125
Free machining		9S20	1.0711	1112/1212		60 - 80	50 - 65	50 - 65	120 - 160	110 - 150	120 - 160
Cementation steels		C10/C15	1.0301/1.0401	1010/1015	10	60 - 80	50 - 65	50 - 65	120 - 160	110 - 150	120 - 160
		16MnCr5	1.7131	5115	18XG	40 - 50	35 - 45	35 - 45	75 - 100	75 - 100	75 - 100
		20CrMo5	1.7264		20XM	40 - 50	35 - 45	35 - 45	75 - 100	75 - 100	75 - 100
		21NiCrMo2	1.6523	8620	20XGNM	40 - 50	35 - 45	35 - 45	75 - 100	75 - 100	75 - 100
Bearing steel	2	100Cr6	1.2067	52100	9x2	35 - 45	30 - 40	30 - 40	70 - 95	70 - 90	65 - 90
Spring steels		65Si7	1.5028	9260H	60S2	35 - 50	30 - 45	30 - 45	70 - 95	70 - 95	70 - 95
		50CrV4	1.8159	6150	50XFA	35 - 50	30 - 45	30 - 45	70 - 95	70 - 95	70 - 95
Hot working steels and case hardened steel	3	C35/C45	1.0501/1.0503	1035/1045	35/45	45 - 60	40 - 55	40 - 55	90 - 125	85 - 120	95 - 125
		42CrMo4	1.7225	4140	40XN2MA	40 - 50	35 - 45	35 - 47	77 - 105	75 - 100	75 - 103
		34CrNiMo6	1.6582	4337	38X2N2MA	25 - 35	23 - 31	24 - 33	50 - 70	50 - 68	55 - 75
Nitriding steel	4	34CrAl6	1.2581	H21	3X2V8F	24 - 32	21 - 28	23 - 31	48 - 65	46 - 63	51 - 69
High alloyed hot working steels		40CrMnMo7	1.2311			26 - 35	23 - 31	24 - 33	51 - 70	50 - 68	54 - 74
		X40CrMoV5-1	1.2344	H13	4X5MF1S	24 - 32	21 - 28	23 - 31	48 - 65	46 - 63	51 - 69
		56NiCrMoV7	1.2713	L6	5XNM	26 - 35	23 - 31	24 - 33	51 - 70	50 - 68	54 = 74
Unalloyed tool steels	5	C125W	1.1563	W112	U13-1	34 - 46	31 - 41	31 - 41	69 - 93	68 - 92	68 - 92
		C80W1	1.1525	W108	U8A-1	34 - 46	31 - 41	31 - 41	69 - 93	68 - 92	68 - 92
Cold working steels	6	X210Cr12	1.2080	D3	X12	20 - 27	17 - 23	19 - 26	40 - 55	38 - 52	42 - 57
		X155CrVMo12-1	1.2379	D2		20 - 27	17 - 23	19 - 26	40 - 55	38 - 52	42 - 57
		90MnCrV8	1.2842			34 - 46	31 - 41	31 - 41	69 - 93	68 - 92	68 - 92
High-speed steels	7	S 6-5-2	1.3343	M2	R6M5	29 - 39	24 - 33	26 - 35	58 - 78	54 - 74	58 - 78
		S 3-3-2	1.3333		R3AM3F2	29 - 39	24 - 33	26 - 35	58 - 78	54 - 74	58 - 78
		S 2-10-1-8	1.3247	M42		29 - 39	24 - 33	26 - 35	58 - 78	54 - 74	58 - 78
		S 10-4-3-10	1.3207		R12F3K10M3	29 - 39	24 - 33	26 - 35	58 - 78	54 - 74	58 - 78
		S 18-0-1	1.3355	T1	R18	29 - 39	24 - 33	26 - 35	58 - 78	54 - 74	58 - 78
Cast iron	8	GG30	0.6030	A48	Sc30	31 - 41	26 - 36	28 - 37	61 - 83	53 - 71	55 - 75
		GGG50	0.7050	A536	Vc50	31 - 41	26 - 36	28 - 37	61 - 83	53 - 71	55 - 75
Stainless steels	9	X8CrNiS18-9	1.4305	303	12X18N9	33 - 41	26 - 35	28 - 39	60 - 81	52 - 70	57 - 77
		X5CrNi18-10	1.4301	304	08X18N10	33 - 41	26 - 35	28 - 39	60 - 81	52 - 70	57 - 77
	10	X6CrNiMoTi17-12-2	1.4571	316Ti	10X17N13M2T	23 - 31	20 - 26	21 - 29	45 - 61	39 - 53	43 - 58
		X5CrNiMo17-12-2	1.4401	316		23 - 31	20 - 26	21 - 29	45 - 61	39 - 53	43 - 58
		X20Cr13	1.4021	420	20X13	27 - 36	24 - 32	27 - 36	54 - 73	48 - 65	63 - 72
Heat resistant steels	11	X45CrSi9-3	1.4718	HNv3	40Ch9S2	24 - 32	21 - 28	23 - 31	48 - 65	46 - 63	51 - 69
		X12CrCoNi21-20	1.4971	661		15 - 21	12 - 17	13 - 18	31 - 41	24 - 33	26 - 35
		X20CrMoWV12-1	1.4935	616		27 - 36	24 - 32	27 - 36	54 - 73	48 - 65	54 - 72
		X15CrNiSi25-20	1.4841	314	20X25N20S2	15 - 21	12 - 17	13 - 18	31 - 41	24 - 33	26 - 35
		X12NiCrSi36-16	1.4864	330		15 - 21	12 - 17	13 - 18	31 - 41	24 - 33	26 - 35
		X8CrNiAlTi20-20	1.4847	334		15 - 21	12 - 17	13 - 18	31 - 41	24 - 33	26 - 35
Nickel base alloys	12	NiCr19NbMo	2.4668	5596E(AMS)		10 - 13	9 - 12	10 - 13	20 - 26	17 - 23	20 - 27
		NiCr13Mo6Ti3	2.4662	5660J(AMS)		10 - 13	9 - 12	10 - 13	20 - 26	17 - 23	20 - 27
		NiCo20Cr20MoTi	2.4650	5872D(AMS)		10 - 13	9 - 12	10 - 13	20 - 26	17 - 23	20 - 27
Aluminium	13	6003				95 - 115	100 - 120	100 - 120	175 - 200	175 - 200	170 - 225
Copper	14	AA1100				95 - 115	100 - 120	100 - 120	175 - 200	175 - 200	170 - 225
Brass	15	CDA110				50 - 70	40 - 60	35 - 45	100 - 140	80 - 120	70 - 90
Alu-bronze	16	CuZn39Pb1AIB-B				73 - 110	73 - 110	85 - 115	175 - 200	175 - 200	170 - 225
Titanium alloys	17	Ti-6Al-4V				13 - 23	10 - 20	10 - 15	40 - 50	40 - 50	35 - 45
Steels with tensile strength more than 1.000 N/mm2	18	1000-1200 N/mm2				25 - 30	25 - 30	20 - 25	60 - 70	50 - 60	40 - 50
1200-1400 N/mm2					30 - 35	20 - 25	15 - 20	50 - 60	40 - 50	30 - 40	
1400-1600 N/mm2					20 - 25	15 - 20	10 - 15	40 - 50	30 - 40	20 - 30	
Abrasive building materials, non-ferro casting	19										
Silicon glass, glass fiber, ceramics	20	1	Standard	1	1	High performance	1	1	Special		
			Multi purpose tool			High production			Ultimate performance		



Blade type	NON-METALS	NON-FERROUS	STEELS AND ALLOYS				Page
			Machinability				
			EASY	MODERATE	DIFFICULT	VERY DIFFICULT	
	<ul style="list-style-type: none"><li>• Wood</li><li>• Plastic</li><li>• Rubber</li></ul>	<ul style="list-style-type: none"><li>• Aluminium</li><li>• Copper</li><li>• Brass</li><li>• Free machining steels</li></ul>	<ul style="list-style-type: none"><li>• Mild steels</li><li>• Low carbon</li><li>• Alloy steels</li></ul>	<ul style="list-style-type: none"><li>• High carbon</li><li>• Tool steels</li><li>• Die steels</li></ul>	<ul style="list-style-type: none"><li>• Stainless steels</li><li>• Titanium</li><li>• Nickel based alloys</li></ul>	<ul style="list-style-type: none"><li>• High nickel alloys</li><li>• Super alloys</li></ul>	
<b>BI-METAL</b> For highest productivity and lowest costs in most metal sawing applications							
Silencer GP	Longer wear life		General purpose Bi-Metal blade with longer wearing tooth				12
Silencer Plus		Best all round choice for multi-purpose applications				13	
StructurALL		Best choice for structurals, tubing and bundles				14	
StructurALL Prime		StructurALL with improved heat and wear resistance				15	
Penetrator		Best choice for most high production sawing applications				16	
Penetrator Prime		Penetrator with improved heat and wear resistance				17	
TiN Penetrator		Penetrator with improved wear resistance				17	
Supreme				Most aggressive with varying tooth height and set			18
TiN Supreme				Supreme with improved wear resistance			19
<b>TUNGSTEN CARBIDE</b> For the toughest and most abrasive applications which generate high cutting temperatures and rapid tool wear							
STS			For high production and long tool life in solid steels				20
T3P		High production rate			Ultimate tooth for the toughest material		21
T7P					Enhanced penetration		22
STC	Very abrasive materials, cast aluminium						23
T3N				Case hardened rods			24
STW	Hard woods						25
<b>CARBON STEEL</b> For easier-to-cut materials which generate little heat or tool wear							
Dart	Hard back allows high band tension, heavy feed						26
Metal Master	Lowest cost blade						27
Friction			Special high-speed sawing of ferrous metals up to 25 mm				28
Olympia	Wood						29



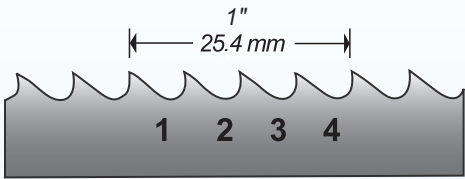
# Pitch selector solids

The pitch indicates the tooth spacing. The correct pitch choice ensures proper tooth pressure and adequate gullet capacity for chips. In most applications, a blade should engage no less than 3 teeth and no more than 25 teeth, in the cut.

### Single pitch

Single pitch blades have uniform tooth spacing and shape. Pitch (teeth per inch) is the number of gullets in a one-inch (25.4 mm) span.

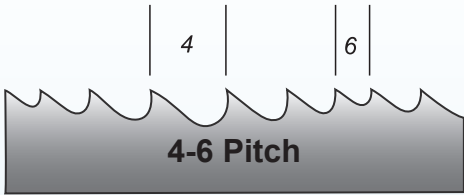
- Use primarily for solids on rigid machines.



### Multi pitch

Multi pitch blades have a varying tooth spacing to reduce vibrations. Pitch designation hyphenates single pitches of coarsest and finest teeth.

- Use for most sawing applications.
- Best for structurals, or any vibration-prone application.



		Workpiece Size in Diameter																												
in		1/8	1/4	3/8	0.59	1.18	1.77	2.36	3.15	3.94	4.72	5.91	7.87	9.84	11.81	13.78	15.75	19.69	23.62	27.56	31.50	35.43	39.37	47.24						
mm		3	6	10	15	30	45	60	80	100	120	150	200	250	300	350	400	500	600	700	800	900	1000	1200						
TPI		10 - 14						3 - 4																						
				8 - 12						2 - 3																				
						6 - 10					2 - 3			1.3 - 2																
							5 - 8							1.3 - 2					0.7 - 1											
								4 - 6									0.7 - 1													
									3 - 4																					
											2 - 3																			
													1.5 - 2																	
																	1 - 1.5													
																				0.8 - 1.2										

Bi-Metal

Tungsten Carbide

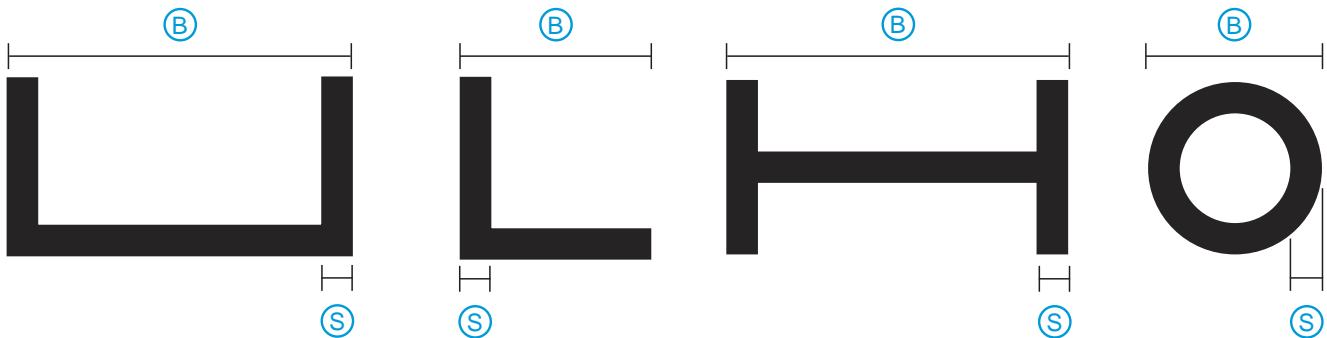




This selector can be used to easily find the correct pitch for cutting profiles and tubing.  
 Select the maximum dimension of the part to be cut on the horizontal scale.  
 Then check on the vertical column the wall thickness measured and find the advised pitch in the table.  
 For faster cutting, the next larger pitch can be used.  
 It is not advised to use a finer pitch as the overfilling gullets will break the teeth.

Cutting in bundles:

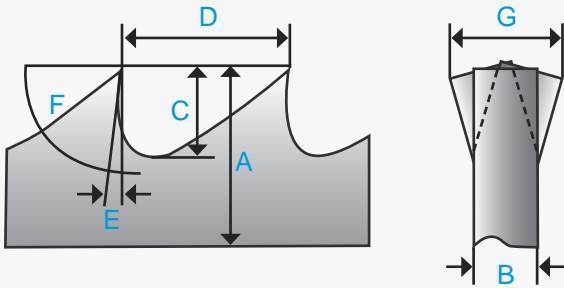
- For round tubing double the single wall thickness and find the correct pitch.
- For square and rectangular tubing, take in consideration the maximum distance to cut in the bundle and the combined wall thickness.



Wall thickness in inch (mm) <b>(S)</b>	TPI (teeth per inch) Dimension in inch (mm) <b>(B)</b>											
	25/32 (20)	1.58 (40)	2.36 (60)	3.15 (80)	3.94 (100)	4.72 (120)	5.91 (150)	7.87 (200)	11.81 (300)	19.69 (500)	29.53 (750)	39.37 (1000)
5/64 (2)	10 - 14	10 - 14	10 - 14	10 - 14	10 - 14	10 - 14	10 - 14	10 - 14	8 - 12	6 - 10	5 - 8	5 - 8
1/8 (3)	10 - 14	10 - 14	10 - 14	10 - 14	10 - 14	10 - 14	8 - 12	8 - 12	6 - 10	5 - 8	4 - 6	4 - 6
5/32 (4)	10 - 14	10 - 14	10 - 14	10 - 14	8 - 12	8 - 12	6 - 10	6 - 10	5 - 8	4 - 6	4 - 6	4 - 6
13/64 (5)	10 - 14	10 - 14	10 - 14	8 - 12	6 - 10	6 - 10	6 - 10	5 - 8	4 - 6	4 - 6	4 - 6	3 - 4
1/4 (6)	10 - 14	8 - 12	8 - 12	8 - 12	6 - 10	6 - 10	5 - 8	5 - 8	4 - 6	4 - 6	3 - 4	3 - 4
5/16 (8)		6 - 10	6 - 10	6 - 10	5 - 8	5 - 8	5 - 8	4 - 6	4 - 6	3 - 4	3 - 4	3 - 4
3/8 (10)		6 - 10	6 - 10	5 - 8	5 - 8	5 - 8	4 - 6	4 - 6	4 - 6	3 - 4	3 - 4	3 - 4
15/32 (12)		5 - 8	5 - 8	5 - 8	4 - 6	4 - 6	4 - 6	4 - 6	3 - 4	3 - 4	2 - 3	2 - 3
19/32 (15)			5 - 8	4 - 6	4 - 6	4 - 6	3 - 4	3 - 4	3 - 4	2 - 3	2 - 3	2 - 3
25/32 (20)			4 - 6	4 - 6	4 - 6	3 - 4	3 - 4	3 - 4	2 - 3	2 - 3	2 - 3	2 - 3
1.18 (30)				3 - 4	3 - 4	3 - 4	2 - 3	2 - 3	2 - 3	2 - 3	1.5 - 2	1.5 - 2
1.97 (50)						3 - 4	2 - 3	2 - 3	2 - 3	1.5 - 2	1.5 - 2	1.5 - 2
2.95 (75)								1.5 - 2	1.5 - 2	1.5 - 2	1.5 - 2	1 - 1.5
3.94 (100)									1.5 - 2	1 - 1.5	1 - 1.5	1 - 1.5
5.91 (150)										1 - 1.5	1 - 1.5	1 - 1.5
7.87 (200)										1 - 1.5	1 - 1.5	1 - 1.5

## BLADE GEOMETRY

### Terminology

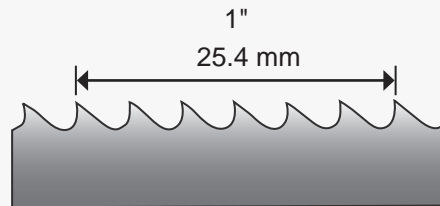


- A Width of the blade
- B Thickness (gauge)
- C Gullet depth
- D Tooth pitch
- E Rake angle
- F Clearance angle
- G Width of set

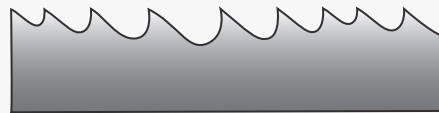
### TOOTH PITCH

Pitch (teeth per inch or TPI) is a measure of tooth spacing.

**Single pitch** blade for fast cutting materials. Single pitch blades have consistent tooth spacing. The number of teeth per one-inch length is the TPI.



**Multi pitch** blade for most metal sawing applications. Multi-pitch blades vary tooth spacing between two extremes. The pitch designation of a multi-pitch blade hyphenates the equivalent single pitch designations of those extremes.



### TYPES OF TOOTH SET

The sequence used in offsetting the teeth.

**Raker set**  
for sawing ferrous and tough metals.



**Straight set**  
for easily machined metals and non-metals.



**Straight raker set**  
is used for all multi pitch blades.



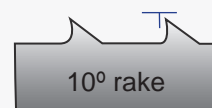
### TOOTH SHAPES

Tooth forms are combinations of rake angle and gullet shape.

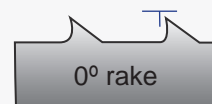
**Precision**  
for most sawing applications.











**Claw**  
to increase beam strength and penetration.



**Buttress**  
for woodworking applications.

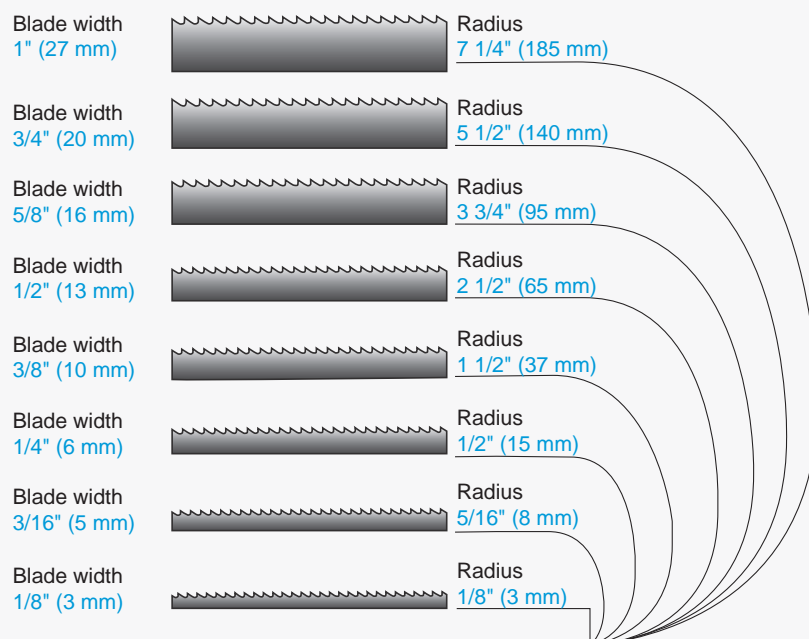




Chip form								
Condition	Thick, hard, short	Thick, hard, brittle	Thick, hard, springy	Thin, hard, springy	Thin, curly, springy	Thin, straight, springy	Powdery	Thin, tightly, curled
Color	Blue or brown	Blue or brown	Silver or light straw	Silver	Silver	Silver	Silver	Silver
Band speed	Reduce	Reduce	OK	Reduce slightly	OK	OK	Reduce	OK
Feed rate	Reduce	Reduce	Reduce slightly	Increase slightly	OK	Increase	Increase	Reduce
Other	Check cutting fluid & mix ratio	Check cutting fluid & mix ratio	Check for correct blade pitch	Check for correct blade pitch				Use a coarser pitch blade

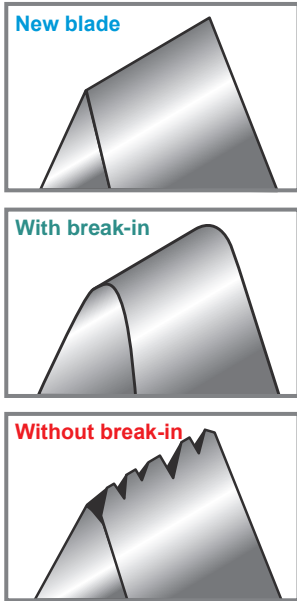
## Radius chart

- For contour cuts, use the widest blade that will cut the smallest radius needed for the job. The blade width is measured from the tooth tips to the back edge.



### Why break-in a band saw blade?

When producing a band saw blade, the teeth are razor sharp. In order to withstand the cutting pressures of band sawing, the tooth tip should be honed to form a very small edge radius. If however a proper break-in procedure has not been performed these tooth tips are damaged and blade life and performance are reduced significantly.



### Breaking in the blade

#### Bi-Metal



##### Procedure

1. Reduce feed force during first 20 minutes of cutting to 50% of normal feed.
2. Then gradually increase feed force in 4 steps to normal in about 10 minutes.
3. Run normal bandspeed

#### Carbide tipped STS / STC / STW



##### Procedure

1. Reduce bandspeed during first 20 minutes of cutting to 70% of normal speed.
2. Reduce feed force during first 20 minutes of cutting to 50% of normal feed.
3. Then gradually increase bandspeed and feed force in 4 steps to normal in about 10 minutes.

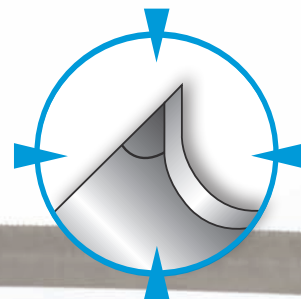
#### Triple Chip carbide tipped T3P / T7P / T3N



##### Procedure

1. Reduce feed force during first 40 minutes of cutting to 50% of normal feed.
2. Then gradually increase feed force in 4 steps to normal in about 10 minutes.
3. Run normal bandspeed





1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

## Silencer GP - M42

### FEATURES

- M42 HSS tooth
- Neutral rake angle

### BENEFITS

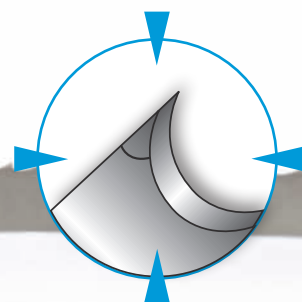
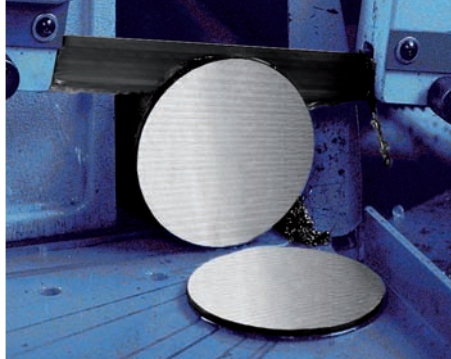
- Wide range of sizes and pitches
- Strong, wear-resistant tooth stays sharp longer

### APPLICATIONS

- All metals in tubing, profiles and small solids
- Best choice for manual / semi-automatic machines and short blade lengths

Inch (mm)		Silencer GP								
Width	Gauge	3-4	4-6	5-8	6	6-10	8-12	14	10-14	18
1/4" (6)	0.035" (0.9)								303-010	
3/8" (10)	0.035" (0.9)				303-011			303-034	303-014	
1/2" (13)	0.025" (0.6)					303-933	303-935	303-019	303-133	303-026
	0.035" (0.9)			303-932	303-020	303-934	303-936		303-028	
3/4" (20)	0.035" (0.9)		303-410	303-182		303-415	303-300		303-420	
1" (27)	0.035" (0.9)	303-903	303-900	303-905	303-743	303-901	303-400		303-769	
1 1/4" (34)	0.042" (1.1)	303-904	303-902	303-539	303-770	303-562	303-600			
			303-099*							
1 1/2" (41)	0.050" (1.3)		303-687*	303-729		303-610				

\* Wide Set precision teeth provide greater back clearance



1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

## Silencer Plus - M42

### FEATURES

- M42 HSS tooth
- Positive rake angle

### BENEFITS

- Aggressive, wear resistant, multi-purpose blade
- Also available in several wide pitches to limit pinching

### APPLICATIONS

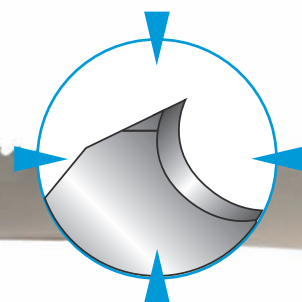
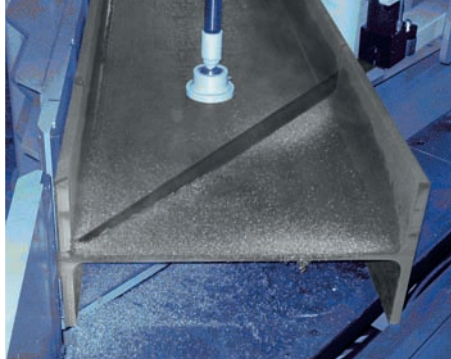
- All metals in tubing, profiles and small solids

Inch (mm)		Silencer Plus									
Width	Gauge	1-1.3	1.5-2	2	2-3	3	3-4	4	4-6	5-8	6
1/4" (6)	0.035" (0.9)										333-046
3/8" (10)	0.035" (0.9)							306-487			
1/2" (13)	0.035" (0.9)					333-023		306-488			333-026
3/4" (20)	0.035" (0.9)					333-103			333-146	333-158	
1" (27)	0.035" (0.9)			303-999*	333-223		333-234		333-246	333-258	
1 1/4" (34)	0.042" (1.1)				333-323		333-334		333-346	333-358	
1 1/2" (41)	0.042" (1.1)	336-413									
	0.050" (1.3)				333-423		333-434		333-446	333-458	
2" (54)	0.050" (1.3)		306-445		336-523		336-534		336-546	336-558	
	0.063" (1.6)	306-511	306-512		333-523		333-534		333-546	333-558	
							306-610*				
2 5/8" (67)	0.063" (1.6)	306-611	306-612		306-640						
3.15" (80)	0.063" (1.6)	306-711	306-712		306-723						

\* Wide Set precision teeth provide greater back clearance

Claw Tooth





1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

## StructurALL - M42

### FEATURES

- M42 HSS tooth
- Positive rake angle

### BENEFITS

- Controlled, quiet sawing on non-solid materials
- Strengthened teeth, superior blade life
- Teeth resist stripping in structurals and bundles

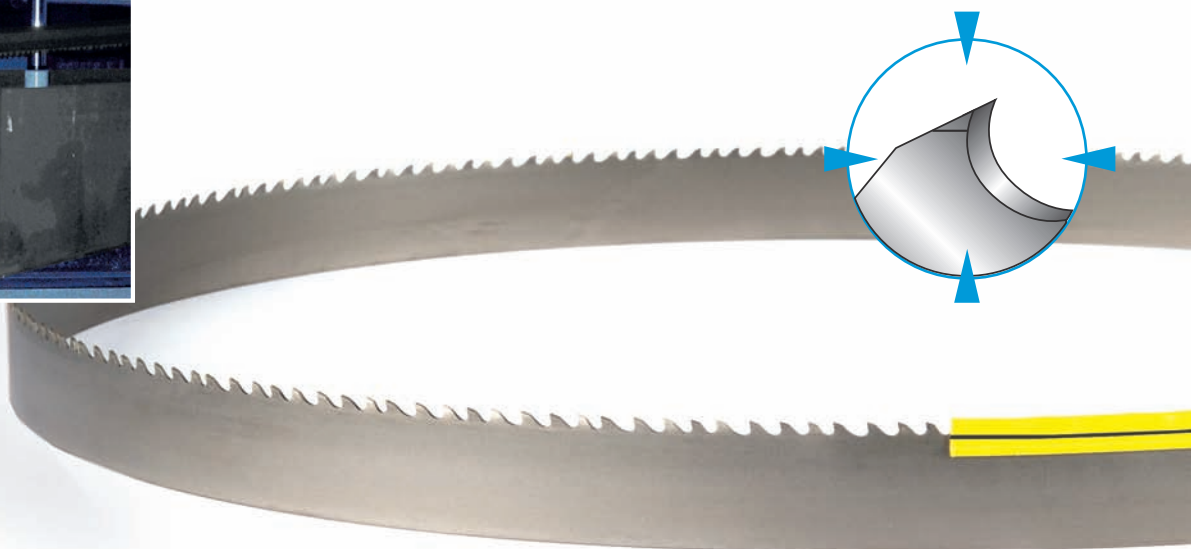
### APPLICATIONS

- Specially designed for tubing and structurals, including single and bundle or nest

Inch (mm)		StructurALL			
Width	Gauge	2-3	3-4	4-6	5-8
1" (27)	0.035" (0.9)		320-234	320-246	320-258
1 1/4" (34)	0.042" (1.1)		320-334	320-346	320-358
1 1/2" (41)	0.050" (1.3)	320-423	320-434	320-446	320-458
2" (54)	0.050" (1.3)	340-523	340-534	340-546	
	0.063" (1.6)	320-523	320-534	320-546	
			320-535**		
2 5/8" (67)	0.063" (1.6)	320-623	320-634	320-646	
		320-625*			

\* Extra Wide set

\*\* Narrow set



1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

## StructurALL Prime - Powder Metal

### FEATURES

- Powder Metal HSS tooth tip
- Positive rake angle
- Special ground tooth form
- Extreme shock proof design

### BENEFITS

- Controlled, quiet sawing on non-solid materials
- Strengthened teeth, superior blade life
- Teeth resist stripping in structurals and bundles

### APPLICATIONS

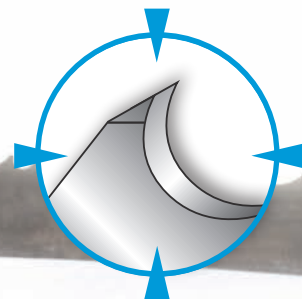
- Tubing and structurals both single and bundle or nest

Inch (mm)		StructurALL Prime			
Width	Gauge	2-3	3-4	4-6	5-8
1 1/4" (34)	0.042" (1.1)		338-334	338-346	338-358
1 1/2" (41)	0.050" (1.3)	338-423	338-434	338-446	338-458
2" (54)	0.063" (1.6)	338-523	338-534	338-546	
			338-535**		
2 5/8" (67)	0.063" (1.6)	338-623	338-634	338-646	
		338-625*			

\* Extra Wide set

\*\* Narrow set





1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

## Penetrator - M42

### FEATURES

- M42 HSS tooth
- High positive rake angle, curvilinear tooth form

### BENEFITS

- Fast cutting, wear resistant blade
- Designed for production sawing

### APPLICATIONS

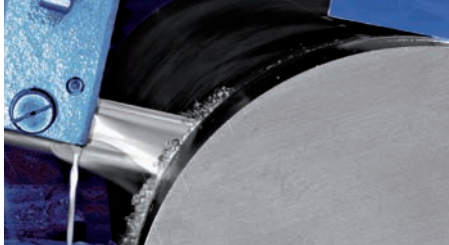
- Moderate to difficult alloys on power saws for high production cutting

Inch (mm)		Penetrator								
Width	Gauge	0.8-1.2	1-1.5	1.3	1.5-2	2	2-3	3-4	4-6	5-8
1" (27)	0.035" (0.9)						301-423	301-598	301-615	301-656
1 1/4" (34)	0.042" (1.1)			301-594		301-842	301-689	301-739	301-748	301-789
1 1/2" (41)	0.050" (1.3)		301-330		301-880		301-879	301-887	301-375	
2" (54)	0.050" (1.3)				301-977		301-381			
	0.063" (1.6)	301-072	301-071		301-070		301-069	301-085	301-384	
									301-091*	
2 5/8" (67)	0.063" (1.6)	301-183	301-185		301-186		301-184	301-187	301-181	
3.15" (80)	0.063" (1.6)	301-430	301-433					301-990		

\* Wide Set precision teeth provide greater back clearance

Claw Tooth





1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20



## Penetrator Prime - Powder Metal

### FEATURES

- Powder metal tooth with hardness of 70 HRC
- High positive rake angle, curvilinear tooth form

### BENEFITS

- Most wear-resistant Bi-Metal tooth
- Production sawing

### APPLICATIONS

- Moderate to difficult alloys on power saws for high production rates with extended blade life

Inch (mm)		Penetrator Prime					
Width	Gauge	1-1.5	1.5-2	2-3	3-4	4-6	5-8
1" (27)	0.035" (0.9)				307-660	307-665	307-670
1 1/4" (34)	0.042" (1.1)			307-689	307-739	307-759	307-760
1 1/2" (41)	0.050" (1.3)		307-877	307-879	307-887	307-893	
2" (54)	0.063" (1.6)		307-901	307-902	307-903	307-546	
2 5/8" (67)	0.063" (1.6)	307-911		307-912			



1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20



## TiN Penetrator - M42

### FEATURES

- Low surface friction

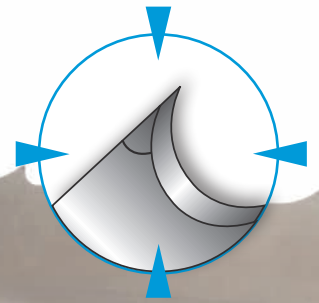
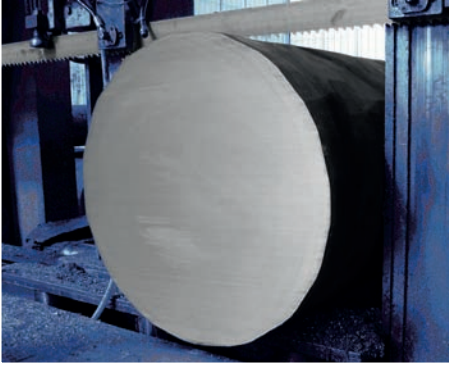
### BENEFITS

- Improved wear resistance
- Extended blade life

### APPLICATIONS

- Use these blades to saw any material recommended for Penetrator blades
- For large volume cutting jobs

Inch (mm)		TiN coated Penetrator					
Width	Gauge	1-1.5	1.5-2	2-3	3-4	4-6	5-8
1" (27)	0.035" (0.9)			319-423	319-598	319-615	319-645
1 1/4" (34)	0.042" (1.1)			319-558	319-533	319-567	319-789
1 1/2" (41)	0.050" (1.3)		319-880	319-640	319-319	319-375	
2" (54)	0.063" (1.6)	319-071	319-070	319-327	319-085		
2 5/8" (67)	0.063" (1.6)	319-185		319-184			
3.15" (80)	0.063" (1.6)	319-433					



1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

## Supreme - Powder Metal

### FEATURES

- M81 powder metal tooth with hardness of 70 HRc
- High positive rake angle

### BENEFITS

- Long tool life on difficult to cut materials
- Improved penetration
- Higher cutting rates

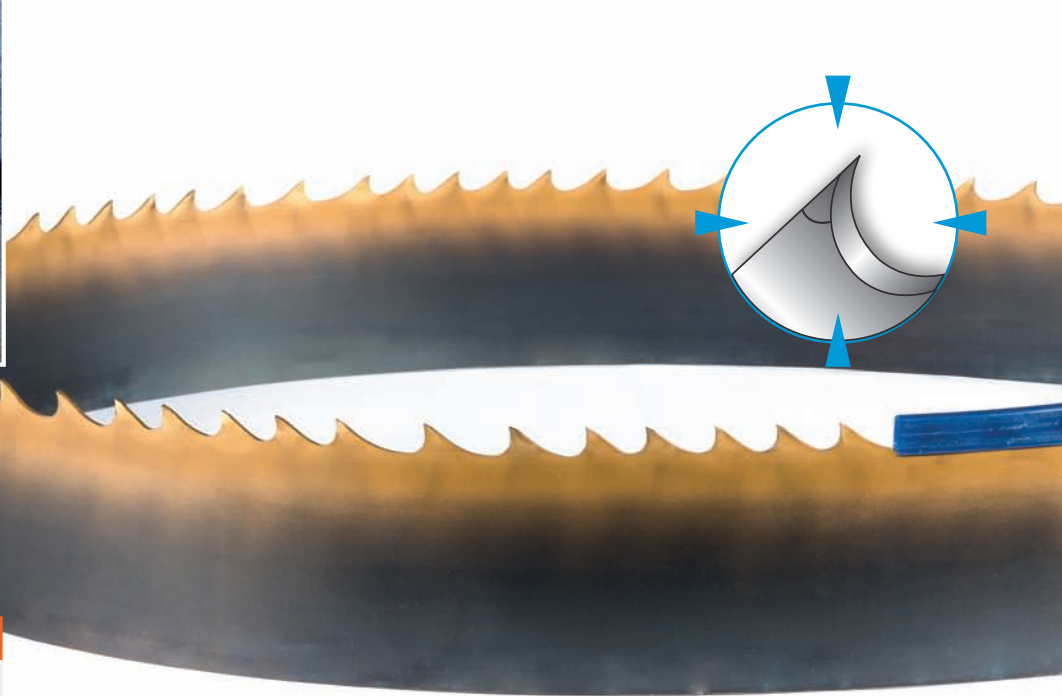
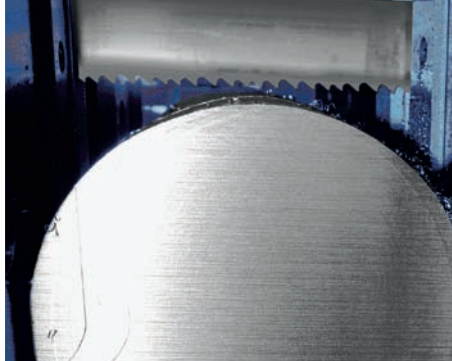
### APPLICATIONS

- Difficult to cut materials like nickel based alloys and other exotics

Inch (mm)		Supreme					
Width	Gauge	0.8-1.2	1-1.3	1.5-2	2-3	3-4	4-6
1" (27)	0.035" (0.9)					381-234	381-246
1 1/4" (34)	0.042" (1.1)				381-323	381-334	381-346
1 1/2" (41)	0.050" (1.3)			381-412	381-423	381-434	381-446
2" (54)	0.063" (1.6)	381-581	381-511	381-512	381-523		
				381-512WS*			
2 5/8" (67)	0.063" (1.6)	381-681	381-611	381-612			
				381-612WS*			
3.15" (80)	0.063" (1.6)	381-781	381-711				

\* Wide set





1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

# TiN Supreme - Powder Metal

## FEATURES

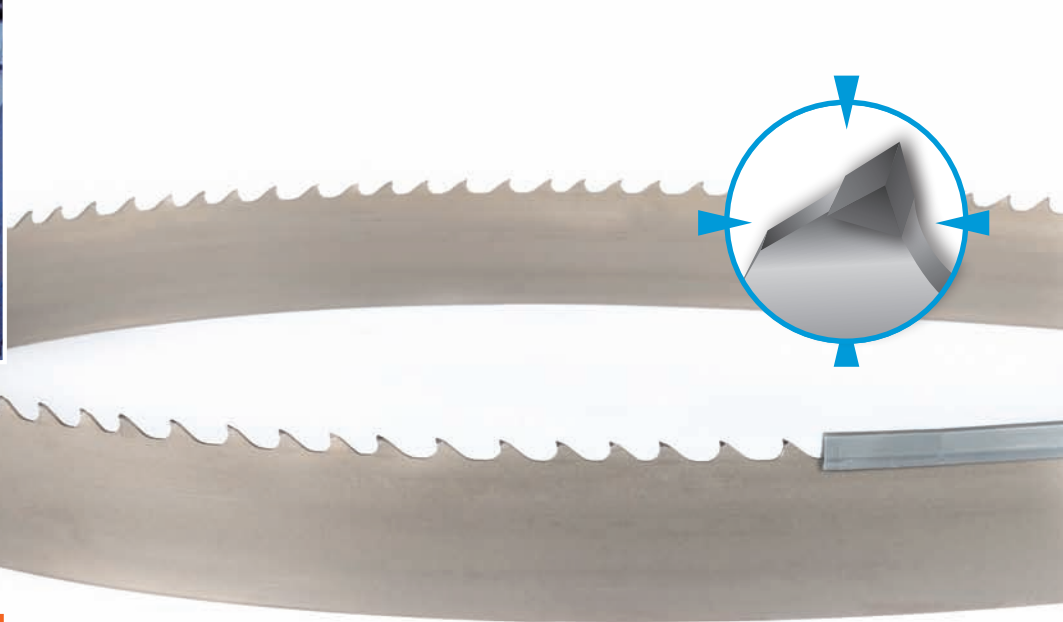
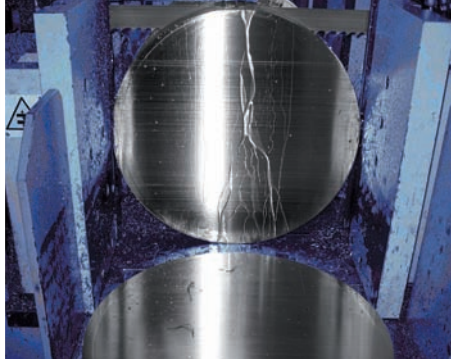
## BENEFITS

## APPLICATIONS

- Low surface friction
- Improved wear resistance
  - Extended blade life
- Use these blades on any material recommended for Supreme blades
  - For large volume cutting jobs

Inch (mm)		TiN coated Supreme		
Width	Gauge	2-3	3-4	4-6
1" (27)	0.035" (0.9)		319-634	319-635
1 1/4" (34)	0.042" (1.1)	319-656	319-658	319-346
1 1/2" (41)	0.050" (1.3)	319-809	319-814	





1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

STS - Carbide

## FEATURES

- Tungsten Carbide tooth
- Left, right, center and chamfered raker tooth
- Great back clearance

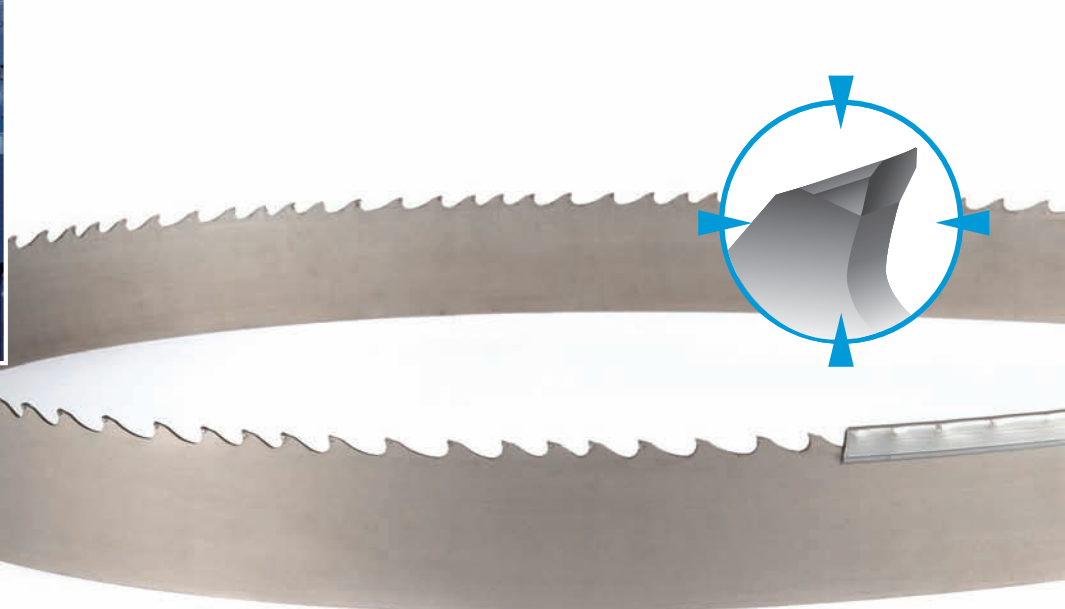
## BENEFITS

- Special double set cutting operation
- Reduced pinching

## APPLICATIONS

- High performance cutting on difficult alloys like nickel steels and non-ferrous metals

Inch (mm)		STS				
Width	Gauge	0.7-1	1-1.3	1.3-2	2-3	3-4
1" (27)	0.035" (0.9)					366-140
1 1/4" (34)	0.042" (1.1)				366-230	366-240
1 1/2" (41)	0.050" (1.3)			366-320	366-330	366-340
2" (54)	0.063" (1.6)		366-410	366-420	366-430	
2 5/8" (67)	0.063" (1.6)	366-505	366-510	366-520		
3.15" (80)	0.063" (1.6)	366-605	366-610			



1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

## T3P - Carbide

### FEATURES

- Tungsten Carbide tooth
- Positive rake angle

### BENEFITS

- Most heat resistant
- Aggressive sawing with a smooth finish

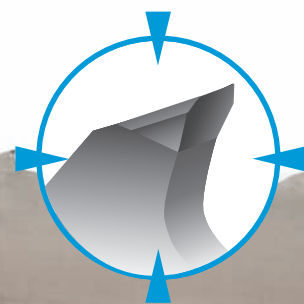
### APPLICATIONS

- Super alloys, high nickel alloys such as titanium
- Production sawing

Inch (mm)		T3P					
Width	Gauge	0.7-1	1-1.3	1.3-2	2-3	3	3-4
3/4" (20)	0.035" (0.9)					326-025	
1" (27)	0.035" (0.9)				328-223	326-035	328-234
1 1/4" (34)	0.042" (1.1)			328-331	328-323	326-045	328-334
							328-335*
1 1/2" (41)	0.050" (1.3)			328-431	328-422	326-074	328-434
2" (54)	0.063" (1.6)	328-571	328-511	328-532	328-523		
2 5/8" (67)	0.063" (1.6)	328-671	328-611	328-672	328-623		
3.15" (80)	0.063" (1.6)	328-771	328-711				
		328-773*					

\* Wider kerf





1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

## T7P - Carbide

### FEATURES

- Tungsten Carbide tooth
- Positive rake tooth

### BENEFITS

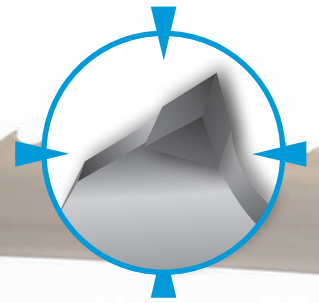
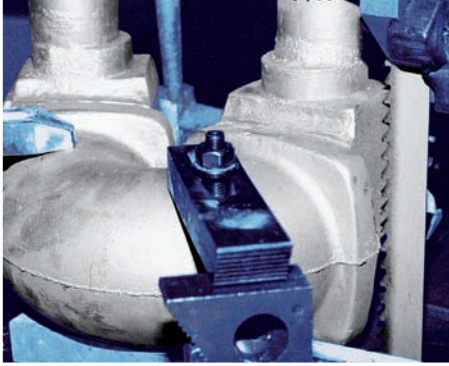
- Most heat resistant
- Aggressive sawing with a smooth finish
- Enhanced penetration in the toughest metals

### APPLICATIONS

- Large diameter super alloys, high nickel alloys, titanium, etc.

Inch (mm)		T7P				
Width	Gauge	0.7-1	1-1.3	1.3-2	2-3	3-4
1" (27)	0.035" (0.9)					332-234
1 1/4" (34)	0.042" (1.1)				332-323	332-334
1 1/2" (41)	0.050" (1.3)			332-432	332-423	332-434
2" (54)	0.063" (1.6)	332-571	332-511	332-532	332-523	
2 5/8" (67)	0.063" (1.6)	332-671	332-611	332-632		
3.15" (80)	0.063" (1.6)	332-771	332-711			





1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

## STC - Carbide

### FEATURES

- Tungsten Carbide tooth
- Positive rake angle

### BENEFITS

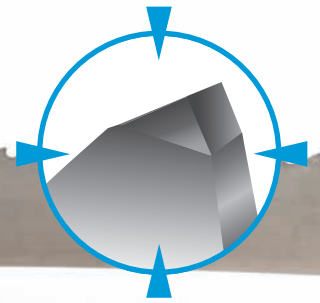
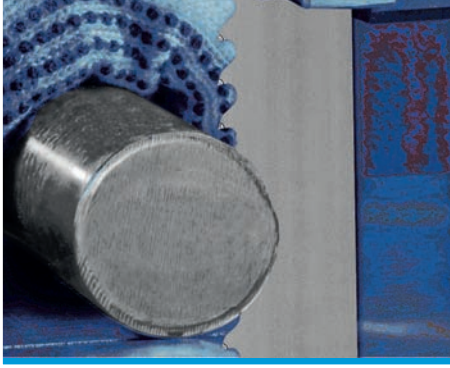
- Withstands rapid tool wear caused by fast cutting of highly abrasive materials

### APPLICATIONS

- Abrasive materials that dull Bi-Metal blades rapidly, such as: aluminium castings, graphite, fiberglass, etc.

Inch (mm)		STC
Width	Gauge	3
3/8" (10)	0.025" (0.6)	305-015S
1/2" (13)	0.025" (0.6)	305-020S
3/4" (20)	0.035" (0.9)	305-025S
1" (27)	0.035" (0.9)	305-045S
		305-029R
1 1/4" (34)	0.042" (1.1)	305-326R

S = Straight Set  
R = Raker Set



1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

T3N - Carbide

### FEATURES

### BENEFITS

### APPLICATIONS

<ul style="list-style-type: none"> <li>• Tungsten Carbide tooth</li> <li>• Negative rake angle</li> </ul>	<ul style="list-style-type: none"> <li>• Most heat resistant</li> <li>• Sawing with a smooth finish</li> </ul>	<ul style="list-style-type: none"> <li>• For case hardened materials</li> </ul>
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Inch (mm)		T3N
Width	Gauge	3-4
1" (27)	0.035" (0.9)	331-234
1 1/4" (34)	0.042" (1.1)	331-334
1 1/2" (41)	0.050" (1.3)	331-434





## STW - Carbide

### FEATURES

- Tungsten Carbide tooth
- Positive rake angle

### BENEFITS

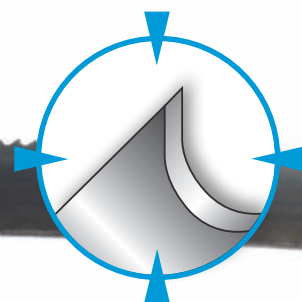
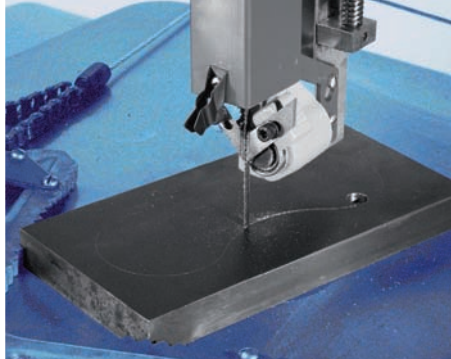
- Precisely cutting
- Clean cut and straight surface

### APPLICATIONS

- Hard woods like parquet

Inch (mm)		STW	
Width	Gauge	2	3
1" (27)	0.035" (0.9)	375-202	375-203
1 1/4" (34)	0.042" (1.1)	375-302	375-303





1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

## Dart - Carbon

### FEATURES

- Carbon steel teeth
- Flexible hardened back
- Hardened tooth tip

### BENEFITS

- Accepts high tension
- Resists scoring
- Extended cutting life

### APPLICATIONS

- Mild steels and other non-ferrous metals, plastics and wood
- Perfect for vertical band saw machines

Inch (mm)		Dart										
Width	Gauge	1.3	2	3	4	6	8	10	14	18	24	32
3/16" (5)	0.025" (0.6)				308-825			308-023	308-049			
1/4" (6)	0.025" (0.6)				309-021*	309-047*		308-080	308-106	308-122	308-148*	308-601
					308-841*							
3/8" (10)	0.025" (0.6)			309-062	309-088	309-104	308-163	308-189	308-205*	308-221*		
					308-908							
1/2" (13)	0.025" (0.6)					308-247		308-262*	308-288*	308-304		
				309-120*	309-146*	309-161*		308-627			308-668	
5/8" (16)	0.032" (0.8)							308-346				
3/4" (20)	0.032" (0.8)					308-403*	308-429*	308-445*	308-486*			
				309-187*		309-203		308-700	308-742	308-767		
1" (25)	0.035" (0.9)			309-229*	308-500S	308-502*	308-528*	308-544*	308-585*			
			308-973									
1 1/4" (32)	0.035" (0.9)	309-948**		309-260								

Precision Tooth

Claw Tooth

Wave Set

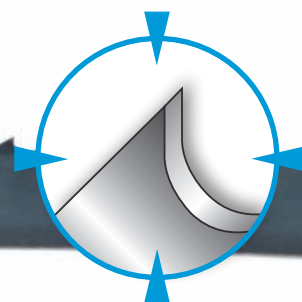
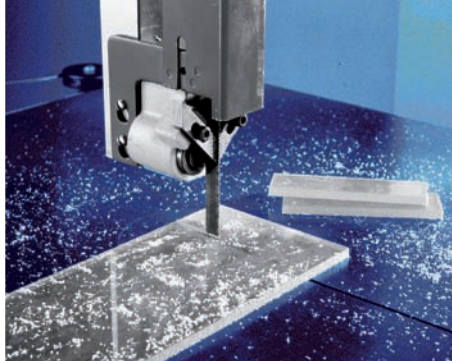
Buttress

S = Straight Set

\* = Available in 30.5 m or 152.4 m coils

\*\* = Available in 91.4 m coils

Final coil lengths may vary



1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

## Metal Master - Carbon

### FEATURES

- Carbon steel teeth
- Flexible back
- Hardened tooth tip

### BENEFITS

- Low cost band saw blade

### APPLICATIONS

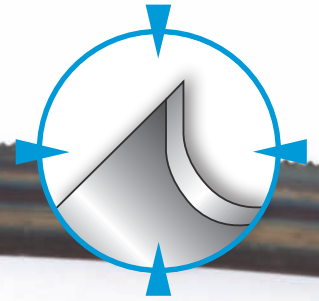
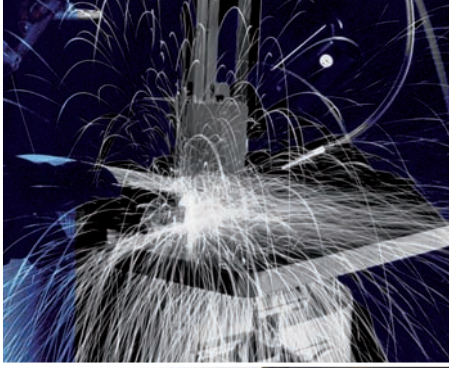
- Contour sawing
- Easy non-ferrous metals, plastics and wood
- First choice for small vertical band saw machines

Inch (mm)		Metal Master					
Width	Gauge	3	4	6	10	14	18
1/8" (3)	0.025" (0.6)					334-100	
1/4" (6)	0.025" (0.6)		335-348		334-227*	334-243*	334-268
3/8" (10)	0.025" (0.6)			335-422	334-326*	334-342	
1/2" (13)	0.025" (0.6)	335-488	335-462	335-505*	334-409		334-449
3/4" (20)	0.032" (0.8)	335-547			334-581*		
1" (25)	0.035" (0.9)	335-620			334-748		

#### Claw Tooth

\* = Available in 100ft (30.5m) or 500ft (152.4m) coils  
Final coil lengths may vary





## Friction - Carbon

### FEATURES

- Silicon-enhanced carbon steel
- Special wide set
- Hardened tooth tips

### BENEFITS

- Slower set wear and longer fatigue life

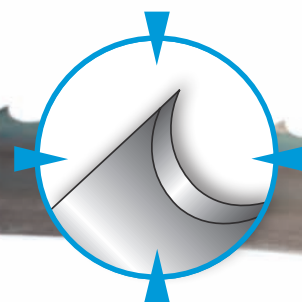
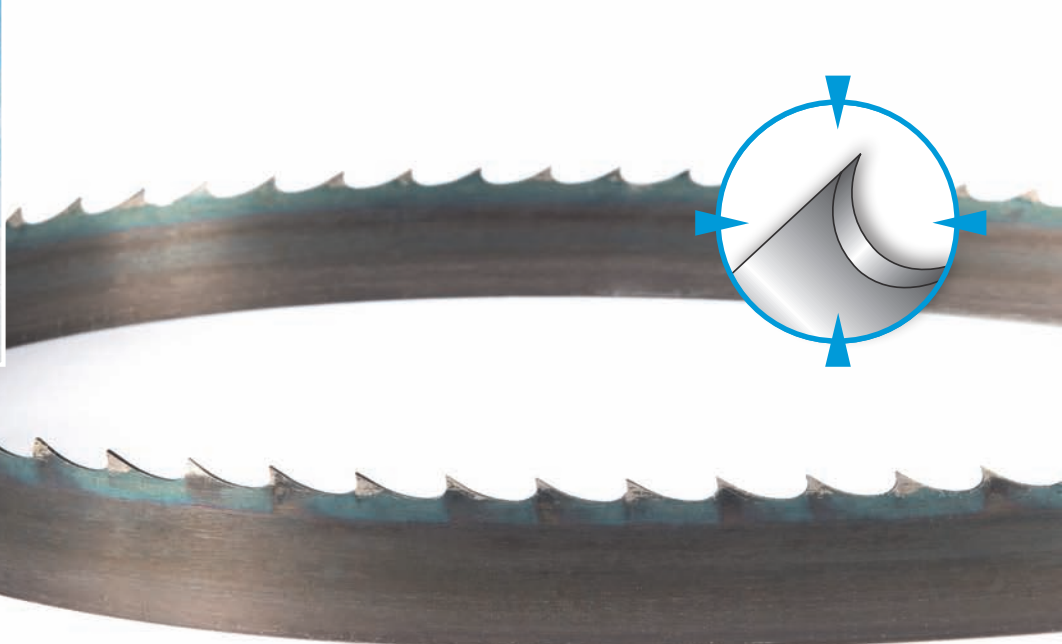
### APPLICATIONS

- Ferrous metals of any hardness up to 25 mm thick at speeds exceeding 1.500 m/min.

Inch (mm)		Friction	
Width	Gauge	8	10
1/2" (13)	0.032" (0.8)		310-037
3/4" (20)	0.035" (0.9)		310-094
1" (25)	0.035" (0.9)	310-134	310-136
1 1/4" (32)	0.035" (0.9)		310-359*

\* = Also available in 300ft (91.4m) or 500ft (152.4m) coils  
Final coil lengths may vary





## Olympia - Carbon

### FEATURES

- Precision milled tooth form
- Flame hardened tooth tips
- Spring hardened back

### BENEFITS

- Long blade life
- Strong blade for accurate contour sawing

### APPLICATIONS

- Typical woodworking and plastic operations

Inch (mm)		Olympia			
Width	Gauge	1.3	2	3	4
1/4" (6)	0.025" (0.6)				358-054
3/8" (10)	0.025" (0.6)			358-108	358-118
	0.032" (0.8)		358-104	358-114	
1/2" (13)	0.025" (0.6)			358-152	
	0.032" (0.8)			358-156	
5/8" (16)	0.032" (0.8)		358-211S	358-215	
3/4" (20)	0.032" (0.8)		358-252	358-256	
			358-254W		
1" (25)	0.035" (0.9)		358-304	358-328	
1 1/4" (32)	0.035" (0.9)	358-356	358-362		
2" (50)	0.035" (0.9)	358-513			

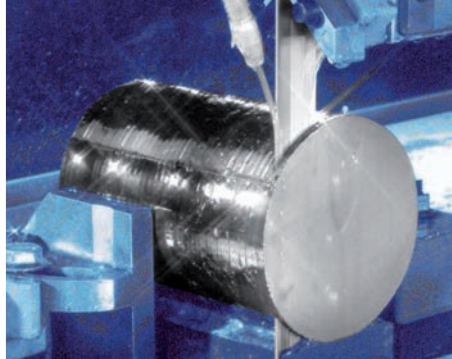
#### Claw Tooth

S = Straight Set

W = Wide Set

Coil length up to 500ft (152.4m) in sizes up to 3/4" (20mm) and 300ft (91.4m) in sizes over 3/4" (20mm).

Final coil lengths may vary



1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20

## Diamond

### FEATURES

- Diamond grit edge
- Continuous for materials up to 25 mm, segmented for large materials

### BENEFITS

- Grinds hardest, most brittle, abrasive materials known.

### APPLICATIONS

- Silicon, glass, quartz, abrasive composites, hard graphites, carbide, marble, limestone, brake linings etc.
- Not for steel!

Inch (mm)		Type	Diamond Grit size				
Width	Gauge		30/40	40/50	60/80	100/120	200
1/2" (13)	0.020" (0.5)	Continuous		406-942	406-918		
3/4" (19)	0.020" (0.5)	Continuous		406-959	406-926	406-750	406-769
		Segmented		406-741			
1" (25)	0.020" (0.5)	Continuous		406-967	406-934	406-971	
		Segmented		406-827	406-843	406-846	
	0.040" (1.0)	Continuous	406-421	406-552	406-462		
		Segmented	406-442		406-433		
1 1/4" (32)	0.020" (0.5)	Continuous		406-807	406-804	406-802	
		Segmented		406-813			
	0.040" (1.0)	Continuous	406-428		406-476		
		Segmented	406-447		406-483		
1 1/2" (38)	0.020" (0.5)	Continuous		406-817			
	0.040" (1.0)	Continuous	406-480				
		Segmented	406-456				
2" (50)	0.040" (1.0)	Continuous	406-496		406-830		
		Segmented	406-837		406-833		
<b>Kerf</b>	<b>Factor</b>	<b>Inch (mm)</b>	<b>0.06" (1.6)</b>	<b>0.04" (0.9)</b>	<b>0.02" (0.6)</b>	<b>0.02" (0.4)</b>	<b>0.01" (0.2)</b>

Note 1: Shaded areas show available bands (minimum order required)

Note 2: To determine approximate kerf add kerf factor to gauge of the band

## Circular saw blades

DoALL circular saw blades are designed for use in high performance circular sawing machines, with high demands on productivity, accuracy and surface finish. These saw blades have a special tooth geometry for single use, resulting in a smaller kerf and therefore lower energy consumption and less material loss. The program consists of cermet tooth tip material for general purpose cutting of a wide range of materials. The tungsten carbide tooth tip with coating is a typical tip material dedicated for cutting stainless steel.



### FEATURES

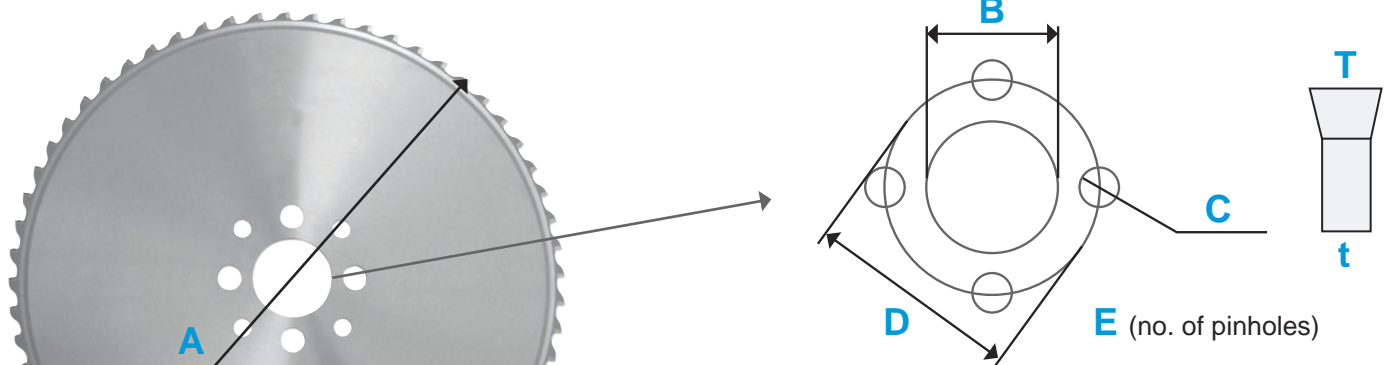
- Cermet tooth tips and tungsten carbide tooth tips with coating available
- Small kerf tooth tips
- Tight tolerances on body flatness

### BENEFITS

- Wide range of sawing applications
- High cutting rates, low energy consumption, low material losses
- Less vibration, low noise level, extended blade life, superb surface finish

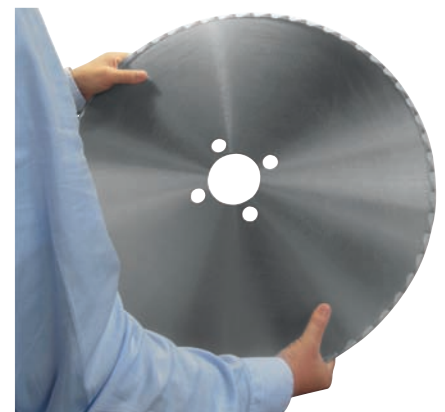
### APPLICATIONS

- Carbon steel
- Alloy steel
- Stainless steel
- Bearing steel
- Tool steel



#### Required information choosing the right blade:

- Machine model
- Blade diameter (A)
- Bore (B) and pinholes specifications (C / D / E)
- T= Kerf / t= thickness
- Material type; size and shape







## Welcome to DoALL

It started with the metal cutting band saw, invented by our founder Mr. Leighton A. Wilkie in 1933. He was the first to produce all three vital elements for band sawing: sawing machines, band saw blades and cutting fluids.

DoALL invented the Bi-Metal band saw blade and released many improvements over the years. Today we are still the trendsetter in band saw blade technology. We have production facilities in the USA, Canada, Mexico as well as in Europe.

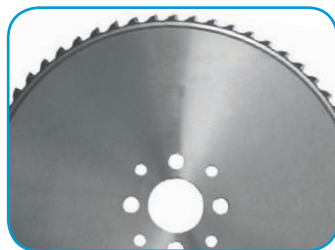


## At your service!

We are strategically located in the suburbs of Chicago, IL. near O'Hare airport. Besides having our own team of dedicated support engineers, we have factory authorized distributors around the world who are saw blade focused with many of them managing their own weld centers. They are able to provide technical support and fast response to any issue. We are committed to your satisfaction and look forward to serving you.



## Your distributor:



**Contour Saws, Inc. a DoALL Company**  
**900 Graceland Ave. Des Plaines, IL. 60016**

**Phone:** 800-259-6834 **Fax:** 847-803-9467