

# BAND SAW BLADES

Eberle CT-flex nano

*Performance*  
*Precision*  
*Quality*

INTELLIGENT SOLUTIONS  
MADE BY

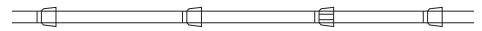
**Eberle**

# CT-flex® nano

Coated carbide-tipped blade

Features: TiAlN-coating, MultiChip® geometry, heat and wear resistant cutting edge, pre-honed tooth edges  
 Applications: stainless, acid-resistant, hardening martensitic steel, nickel-based alloys  
 ≤ 65 HRC

Work pieces:  round bar  square bar  flat bar



mm	teeth per inch (tpi)							in
	0,75/1,25	1/1,3	1,4/2	2	2/3	3	3/4	
41 x 1,30			TR ●	TR ○	TR ●	TR ○	TR ○	1 1/2 x .050
54 x 1,60		TR ○	TR ●	TR ○	TR ○			2 x .063
67 x 1,60	TR ○	TR ●	TR ●					2 5/8 x .063
80 x 1,60	TR ●		TR ●					3 1/8 x .063

# CT-flex® 3000

Carbide-tipped blade

Features: CT3 geometry, excellent performance, short cycle times, high stability  
 Applications: extremely hard-to-cut materials  
 ≤ 65 HRC

Work pieces:  round bar  square bar  flat bar



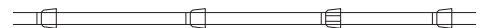
mm	teeth per inch (tpi)							in
	0,75/1,25	1/1,3	1,4/2	2	2/3	3	3/4	
27 x 0,90					TR			1 x .035
34 x 1,10				TR	TR	TR		1 1/4 x .042
41 x 1,30			TR	TR	TR	TR		1 1/2 x .050
54 x 1,60	TR	TR	TR	TR				2 x .063
67 x 1,60	TR	TR	TR					2 5/8 x .063
80 x 1,60	TR		TR					3 1/8 x .063

# CT-flex® 4000

Carbide-tipped blade

Features: CT4 geometry, excellent performance, short cycle times, very smooth running blade  
 Applications: hard-to-cut materials, Aluminum  
 ≤ 65 HRC

Work pieces:  round bar  square bar  flat bar



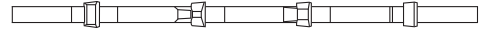
mm	teeth per inch (tpi)							in
	0,75/1,25	1/1,3	1,4/2	2	2/3	3	3/4	
20 x 0,90						TR		3/4 x .035
27 x 0,90					TR	TR	TR	1 x .035
34 x 1,10				TR	TR	TR	TR	1 1/4 x .042
41 x 1,30			TR	TR	TR	TR	TR	1 1/2 x .050
54 x 1,60	TR	TR	TR	TR	TR			2 x .063
67 x 1,60	TR	TR	TR					2 5/8 x .063
80 x 1,60	TR		TR					3 1/8 x .063

# CT-flex® CHM

Carbide-tipped blade

Features: Multichip® geometry, superior performance, negative rake angle, extreme wear resistance  
 Applications: case hardened and chrome plated materials ≤ 65 HRC

Work pieces: ● round bar ○ tubing ●● bundle single-layer



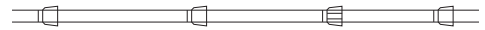
mm	teeth per inch (tpi)						in
			3	3/4			
27 x 0,90			TRN	TRN			1 x .035
34 x 1,10			TRN	TRN			1 1/4 x .042
41 x 1,30			TRN	TRN			1 1/2 x .050

# CT-flex® ALU XL

Carbide-tipped blade

Features: Multichip® geometry, improved chip formation, minor material loss, less forces  
 Applications: large plates and large blocks of Aluminum

Work pieces: ● round bar ■ square bar ■ flat bar



mm	teeth per inch (tpi)						in
		0,75/1,25	1/1,3	1,4/2	2	2/3	
41 x 1,30				TR	TR	TR	1 1/2 x .050
54 x 1,60		TR	TR	TR			2 x .063
67 x 1,60		TR	TR	TR			2 5/8 x .063
80 x 1,60		TR					3 1/8 x .063

# CT-flex® Pro

Carbide-tipped blade

Features: set tooth, unique tooth geometry, minor vibration development  
 Applications: corrosion and acid-resistant steels, nickel-based alloys ≤ 65 HRC

Work pieces: ● round bar ○ tubing ■ square bar ■ flat bar



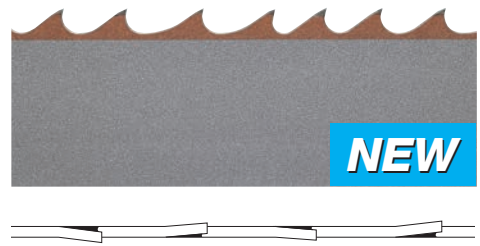
mm	teeth per inch (tpi)						in
		1,4/2	2	2/3	3	3/4	
20 x 0,90					ST		3/4 x .035
27 x 0,90					ST	ST	1 x .035
34 x 1,10				ST		ST	1 1/4 x .042
41 x 1,30		ST	ST	ST			1 1/2 x .050
54 x 1,60		ST					2 x .063

ST = set tooth

# nanoflex® VTX

Coated  
bimetal blade

Features: TiAlN-coating, micro-resistant cutting edge, increased tooth hardness, variable tooth height with strongly positive rake angle  
Applications: corrosion and acid-resistant steel, nickel-based alloys, tempered steel  
≤ 50 HRC



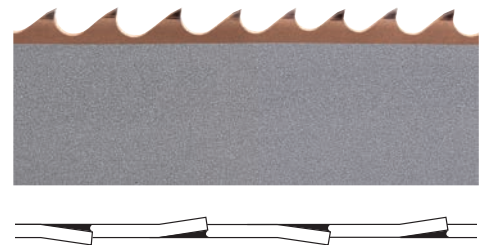
Work pieces: round bar tubing square bar flat bar

mm	teeth per inch (tpi)					in
	0,65/0,95	0,75/1,25	1,4/2	2/3		
34 x 1,10				CHT		1 1/4 x .042
41 x 1,30				CHT	CHT	1 1/2 x .050
54 x 1,30				CHT	CHT	2 x .050
54 x 1,60				CHT	CHT	2 x .063
67 x 1,60		CHT	CHT	CHT		2 5/8 x .063
80 x 1,60		CHT	CHT	CHT		3 1/8 x .063

# nanoflex® Black

Coated  
bimetal blade

Features: TiAlN-coating, prehoned edges, short cycle times, excellent wear resistance  
Applications: universally applicable  
≤ 50 HRC



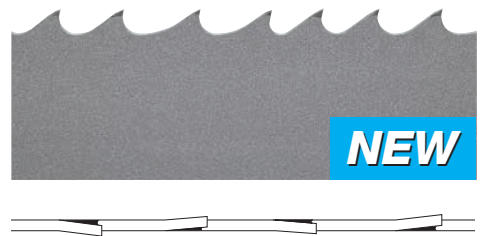
Work pieces: round bar tubing bundle single-layer  
 square bar flat bar beams special profiles

mm	teeth per inch (tpi)					in
	0,75/1,25	1/1,3	1,4/2	2/3	3/4	
41 x 1,30			DCS	DCS	DCS	1 1/2 x .050
54 x 1,60		DCS	DCS	DCS	DCS	2 x .063
67 x 1,60	DCS	DCS	DCS			2 5/8 x .063
80 x 1,60	DCS	DCS	DCS			3 1/8 x .063

# duoflex® VTX

Bimetal blade

Features: micro-resistant cutting edge, increased tooth hardness, variable tooth height with strongly positive rake angle  
Applications: corrosion and acid-resistant steel, nickel-based alloys, tempered steel  
≤ 50 HRC



Work pieces: round bar tubing square bar flat bar

mm	teeth per inch (tpi)					in
	0,65/0,95	0,75/1,25	1,4/2	2/3		
34 x 1,10				CHT		1 1/4 x .042
41 x 1,30				CHT	CHT	1 1/2 x .050
54 x 1,30				CHT	CHT	2 x .050
54 x 1,60				CHT	CHT	2 x .063
67 x 1,60		CHT	CHT	CHT		2 5/8 x .063
80 x 1,60		CHT	CHT	CHT		3 1/8 x .063



# duoflex® GTX

Bimetal blade

Features: ground triple chip tooth geometry,  
micro-resistant cutting edge, excellent surface finish

Applications: large applications  
≤ 50 HRC



Work pieces: round bar square bar flat bar beams



mm	teeth per inch (tpi)							in
		0,75/1,25	1/1,3	1,4/2				
54 x 1,60		DCS	DCS	DCS				2 x .063
67 x 1,60		DCS	DCS	DCS				2 5/8 x .063
80 x 1,60		DCS	DCS	DCS				3 1/8 x .063

# duoflex® SPX

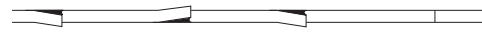
Bimetal blade

Features: special tooth geometry,  
micro-resistant cutting edge, reduced cutting force

Applications: austenitic steels, nickel-based alloys  
≤ 49 HRC



Work pieces: round bar thick-walled tubes square bar flat bar beams



mm	teeth per inch (tpi)							in
		0,75/1,25	1/1,3	1,4/2	2/3	3/4		
27 x 0,90						CSP		1 x .035
34 x 1,10					CSP	CSP		1 1/4 x .042
41 x 1,30				CSP	CSP	CSP		1 1/2 x .050
54 x 1,60			CSP	CSP	CSP			2 x .063
67 x 1,60		CSP	CSP	CSP	CSP			2 5/8 x .063
80 x 1,60		CSP	CSP					3 1/8 x .063

# duoflex® MX55

Bimetal blade

Features: micro-resistant cutting edge, resistant against interrupted cuts,

Applications: hard-to-cut materials, e.g. Duplex- and heat resistant steel,  
Titanium and Titanium alloys, Aluminum bronze, tempered steel  
≤ 49 HRC



Work pieces: round bar tubing bundle single-layer  
 bundle round bars bundle thick-walled tubes square bar flat bar beams













mm	teeth per inch (tpi)							in
		0,75/1,25	1,4/2	2/3	3/4	4/6		
27 x 0,90				DCS	DCS	CS		1 x .035
34 x 1,10				DCS	DCS	CS		1 1/4 x .042
41 x 1,30				DCS	DCS			1 1/2 x .050
54 x 1,60			DCS	DCS	DCS			2 x .063
67 x 1,60		DCS	DCS	DCS				2 5/8 x .063
80 x 1,60		DCS	DCS					3 1/8 x .063

# duoflex® M42

Bimetal blade

Features: efficient and powerful saw blade with vibration resistant tooth edge  
 Applications: universally applicable  
 ≤ 44 HRC



- Work pieces:
-  round bar
  -  thick-walled tubes
  -  bundle single-layer
  -  bundle multiple-layer
  -  bundle round bars
  -  square bar
  -  flat bar
  -  bundle thick-walled tubes
  -  beams
  -  special profiles










mm	teeth per inch (tpi)														in	
	3	4	6	8	10	14	0,75/ 1,25	1,4/2	2/3	3/4	4/6	5/8	6/10	8/12		10/14
6 x 0,90		CW	CW			N	N								N	1/4 x .035
10 x 0,90		CW	CW			N	N								N	3/8 x .035
13 x 0,65		CW	CW			N	N						N	N	N	1/2 x .025
13 x 0,90	CW	CW	CW	N	N	N							N	N	N	1/2 x .035
20 x 0,90					N	N					N/CS	N	N	N	N	3/4 x .035
27 x 0,90	DCS	CS	N						DCS	N/DCS	N/CS DCS	N/CS	N	N	N	1 x .035
34 x 1,10			CS						DCS	N/DCS	N/CS	N	N	N		1 1/4 x .042
41 x 1,30			CS						DCS	DCS	DCS	N/CS	N			1 1/2 x .050
54 x 1,30									DCS	DCS	CS					2 x .050
54 x 1,60								DCS	DCS	DCS	DCS	CS				2 x .063
67 x 1,60								DCS	DCS	DCS	DCS					2 5/8 x .063
80 x 1,60								DCS	DCS							3 1/8 x .063

# duoflex® PT

Bimetal blade

Features: highest cutting performance in interrupted cuts,  
 reduced vibration, resistant to tooth breakage  
 Applications: pipes and tubes  
 ≤ 44 HRC

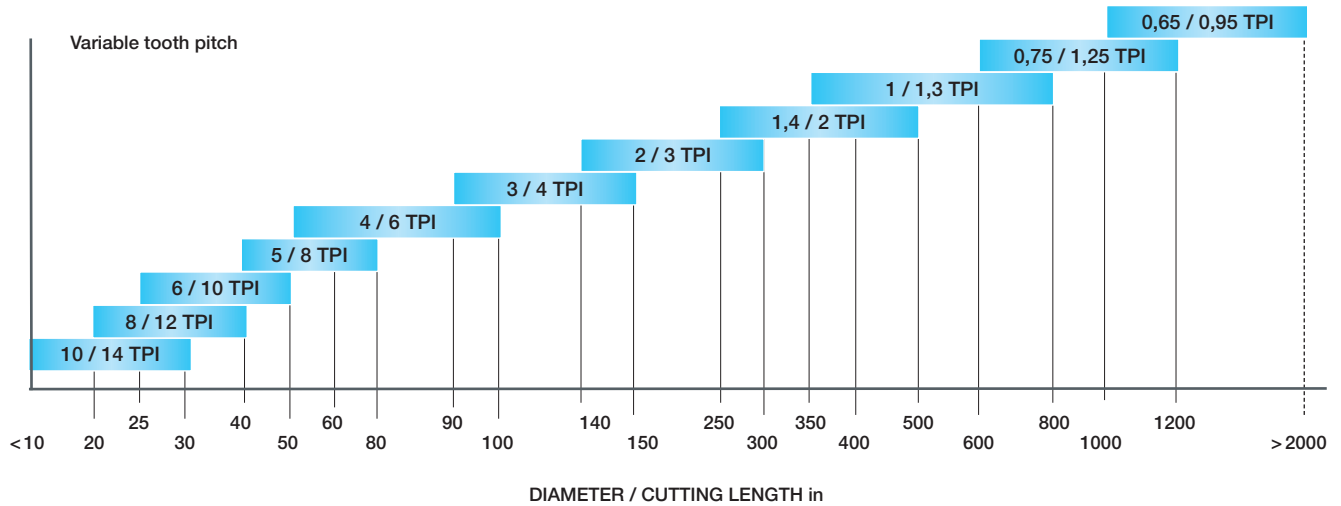


- Work pieces:
-  Tubes
  -  bundle single-layer
  -  bundle multiple-layer
  -  bundle round bars
  -  bundle thick-walled tubes
  -  beams
  -  special profiles

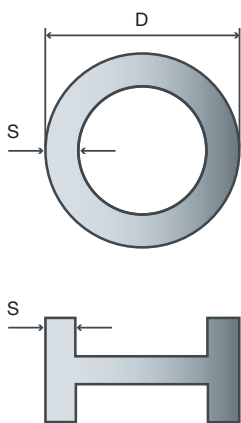


mm	teeth per inch (tpi)							in
	2/3	3/4	4/6	5/8	8/12			
20 x 0,90					CST		3/4 x .035	
27 x 0,90	CST	CST	CST	CST	CST		1 x .035	
34 x 1,10	CST	CST	CST	CST			1 1/4 x .042	
41 x 1,30	CST	CST	CST	CST			1 1/2 x .050	
54 x 1,60	CST	CST	CST				2 x .063	
67 x 1,60	CST	CST					2 5/8 x .063	

## CUTTING RECOMMENDATIONS FOR SOLID MATERIAL

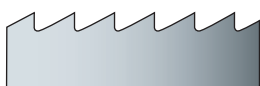


## CUTTING RECOMMENDATIONS FOR TUBES AND PROFILES



D mm	20	40	60	80	100	150	200	300	400	500	> 700
<b>S mm</b>	<b>teeth per inch (tpi)</b>										
<b>2</b>	14	14	14	14	10/14	10/14	10/14	10/14	8/12	8/12	6/10
<b>3</b>	14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	6/10	6/10	6/10
<b>4</b>	14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6
<b>5</b>	14	10/14	10/14	8/12	6/10	6/10	5/8	4/6	4/6	4/6	4/6
<b>6</b>	14	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6	4/6	4/6
<b>8</b>	14	8/12	6/10	6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6
<b>10</b>		6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4
<b>12</b>		6/10	5/8	4/6	4/6	4/6	4/6	3/4	3/4	3/4	3/4
<b>15</b>				4/6	4/6	3/4	3/4	3/4	3/4	2/3	2/3
<b>20</b>				4/6	4/6	3/4	3/4	3/4	3/4	2/3	2/3
<b>30</b>				3/4	3/4	3/4	2/3	2/3	2/3	2/3	1,4/2
<b>50</b>						2/3	2/3	2/3	2/3	1,4/2	1,4/2
<b>80</b>							2/3	1,4/2	1,4/2	1,4/2	1/1,3
<b>100</b>								1,4/2	1,4/2	1/1,3	0,75/1,25
<b>150</b>										0,75/1,25	0,75/1,25
<b>&gt; 250</b>										0,75/1,25	0,75/1,25

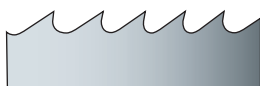
## TOOTH FORMS



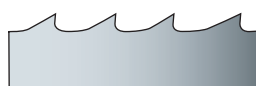
**N-TOOTH** | neutral rake angle  
 > short-chip materials  
 > small work pieces



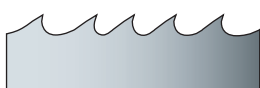
**CST-TOOTH** | positive rake angle  
 > short-chip materials  
 > profiles, tubes, bundles



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



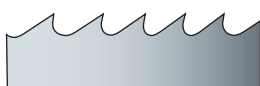
**CW-TOOTH** | positive rake angle  
 > low-alloy materials, Aluminum  
 > mold construction, contours



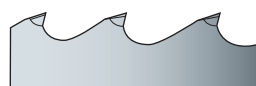
**DCS-TOOTH** | positive rake angle  
 > heavy duty, high alloyed work pieces  
 > large cross-sections



**CHT-ZAHN** | variable, extremely positive rake angle  
 > hard-to-cut materials, heat-treated steels  
 > large to very large work pieces



**CSP-TOOTH** | positive rake angle  
 > austenitic materials  
 > nickel-based alloys



**TR/TRN-TOOTH** | variable rake angle  
 > heavy duty work pieces  
 > high cutting performance

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**Upcoming Trade Shows**

For a detailed overview about our trade shows with direct access to the event website and to Google Maps, please refer to our homepage [www.eberle-augsburg.de](http://www.eberle-augsburg.de).

**Eberle Cutting Data App**

The Eberle Cutting Data App provides you immediately and precisely with the cutting parameters for individual bimetal and carbide tipped band saw cutting. It can be downloaded from our homepage or [www.eberleslidechart.com](http://www.eberleslidechart.com) or from:

**Training**

We offer band saw blade training to your company upon request. Just contact our distribution network or get in touch with our headquarter.

**Technical advice**

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

**Tel.:** +49 (821) 5212-220  
**Fax:** +49 (821) 5212-300  
**Email:** [support@eberle-augsburg.de](mailto:support@eberle-augsburg.de)

**We look forward to your call.**

# Eberle

J.N. Eberle & Cie. GmbH, Augsburg, Germany  
 Cold Rolling Mill and Saw Factory  
 Quality products since 1836