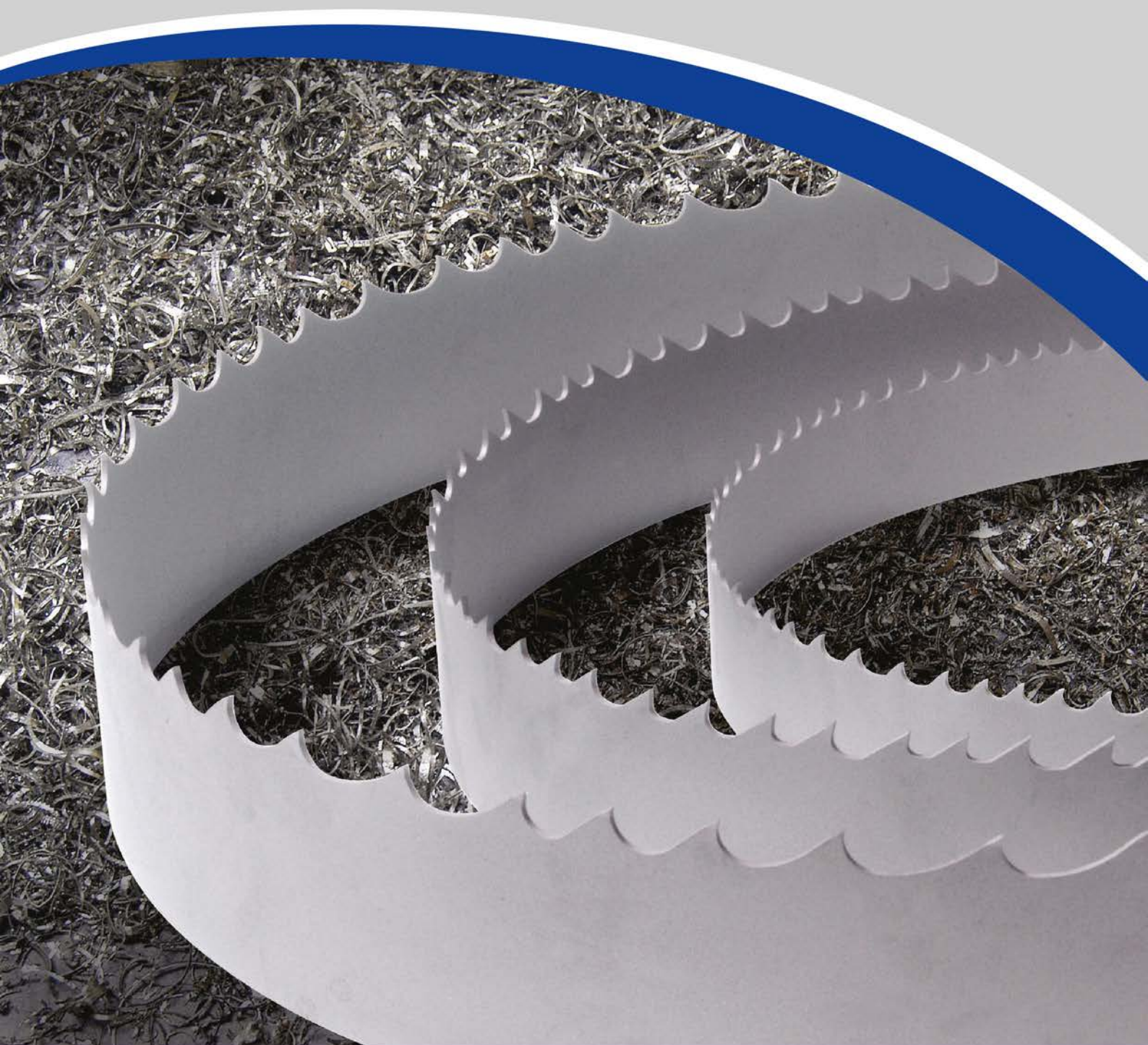




Cutting... Leave it to us



www.bipico.com

CATALOGUE 2017

CONTENTS

Chairman's Message	1
Factory Photograph	2 to 3
Manufacturing Facility of Bimetal Bandsaw Blades	4
Bimetal Bandsaw Blades	5 to 8
Bimetal Bandsaw Blades & Carbide Bandsaw Blades	9
Bimetal Bandsaw Blades Speed & Feed Chart	10 to 11
Bimetal Bandsaw Tooth Selection Chart	12
Carbon Bandsaw Blades	13
Hacksaw Blades	14 to 15
Tool Bits	16
Hole Saws	17 to 19
Saws	20
Abrasives	21 to 22
Products Range	23 to 24



Cutting... Leave it to us

From The Chairman's Desk

Bipico is a leading manufacturer & exporter of variety of cutting tools in India. Our Company started in November 1974. It has consistently achieved success in India & International market continuously for the last 4 decades.

It is a matter of great pride and privilege to build an empire on the foundations laid by my late father – Our beloved Shri Kanubhai Patel. I pledge to continue to walk on his foot steps and reach horizons much beyond his expectations.

The success and eminence of Bipico began as the dream of one man and extended to be transformed into the dream of many. We today strive to accomplish our dreams and goals to bring greater affluence in future.

To embark on a journey of success one needs the tools of preparedness, foresight and strategy. We at Bipico believe that we have all the three tools. We have been active for the past 40 years in manufacturing highly technical and cost competitive industrial cutting tools for domestic and export markets. We have continuously invested to create a most modern manufacturing facility.

Bipico entered the industrial arena with a humble beginning by manufacturing Hacksaw Blades. Today, Bipico is synonymous with respect to quality Hacksaw Blades & Bimetal Bandsaw, which finds application in a variety of fields. It's diverse range of products also includes Tool Bits, Carbon Steel Bandsaw Blades and Saws. Thanks to the international technological alliances, the quality products of Bipico have incited demands not only in the national markets but also in the export markets, world over.

The key to growing our business further is to focus on customer's profitability. Our single-minded focus would be on enhancing customer's advantage and thereby their profitability. Whether it is Hacksaw blades or Bimetal Bandsaws, we will work as partners with our customers, understanding their unique needs and developing world class cutting solutions that will exceed their expectations.

The 2nd key to growth is R&D and New Innovations. Gearing up for the same, we have ensured that we have all the key factors necessary to achieve success. A highly skilled and creative R & D team is reinforced by the state-of-the-art manufacturing infrastructure and qualified staff.

At Bipico, each and every individual is a member of our BIPICO FAMILY. Collectively, we ensure Growth and we move forward in time. We believe that apart from Technology, it is the Attitude that plays a major role in progress of a Company.

A well monitored and distribution network, which is aimed at attaining brand equity among our wide reaching customer base, is yet another asset of our Company. We have Achieve Customer Loyalty through Product Excellence and Good Customer Relations.

With warm regards

Pramit Patel
CMD





BIPICO INDUSTRIES (TOOLS) PVT. LTD., BILIMORA, GUJARAT, INDIA.

THE MODERN MANUFACTURING FACILITY OF BIMETAL BANDSAW



Productivity

Cost

Delivery

Safety

Moral

Attitude

Environment

WORLD CLASS
MANUFACTURING SYSTEM

SILVER MATRIX II

The Silver Matrix II Bimetal Bandsaw is manufactured from 8% cobalt HSS edge material Laser beam welded to high quality spring steel backing material. The superior properties of tooth cutting edge with controlled tungsten and carbon content will give good result for cutting high vibration sawing.

SILVER MATRIX II- PLUS

Specially designed tooth geometry having large gullet and standard rake angle.



SR. NO.	SIZE IN MM	CONSTANT TPI	VARIABLE TPI
1	13 X 0.60	10,14,18,24	8/12, 10/14
2	20 X 0.90	6,10,14,18,	8/12, 10/14
3	27 X 0.90	6,10,14,	8/12, 10/14



Cutting Application : M. S., Low carbon steel, Medium alloy steel, Non-ferrous metal and Structural steel having thinner and hollow section.

GOLD M42

The Gold M42 Bandsaw is manufactured with HSS M42 edge material having excellent wear resistance characteristic Laser beam welded to special BIPICO spring steel backing material having excellent fatigue life. The perfect distribution of Carbide with martensitic structure provides excellent cutting edge.

GOLD M42 - PLUS

Specially designed tooth geometry having large gullet and standard rake angle.



SR. NO.	SIZE IN MM	CONSTANT TPI	VARIABLE TPI
1	13 X 0.60	10,14,18, 24	8/12, 10/14
2	13 X 0.90	10,14,18, 24	6/10,8/12,10/14
3	20 X 0.90	6,10,14	4/6,5/8,6/10,8/12,10/14
4	27 X 0.90	6,10,14	4/6,5/8,6/10,8/12,10/14
5	34 x 1.1	4, 6, 8	3/4, 4/6, 6/10, 8/12, 5/8
6	41 x 1.3	4, 6	3/4, 4/6, 8/12, 5/8



Cutting Application : M. S., EN series, Alloy steels, High carbon steels, Structural steels, Tool steel having cutting large profiles and solids (Upto 35 HRC)

GOLD M42 - EXTREME

Specially designed tooth geometry with positive rake angle.



1	20 X 0.90	-	4/6
2	27 x 0.90	4,6	3/4, 4/6
3	34 x 1.10	4,6	3/4, 4/6
4	41 x 1.30	2,4,6	3/4, 4/6

Cutting Application : Low alloy steel and Unalloyed tool steel.



GOLD M42 - FLEX

Specially designed tooth geometry having strong tooth for absorbing shocks due to interrupted cut.



1	20 X 0.90	-	4/6, 5/8, 5/7
2	27 x 0.90	-	2/3, 3/4, 4/6, 5/8, 5/7
3	34 x 1.10	-	2/3, 3/4, 4/6, 5/8, 5/7
4	41 x 1.30	-	2/3, 3/4, 4/6, 5/8
5	54 x 1.60	-	4/6, 3/4, 2/3
6	67 x 1.60	-	2/3, 3/4

Cutting Application : Bundle cutting for pipes, Tubing and Structural steel.



GOLD M42 - PREMIUM

Specially designed tooth geometry with positive rake angle having additional relief angle and deep gullet.



1	20 X 0.90	-	3/4, 4/6
2	27 x 0.90	-	2/3, 3/4, 4/6
3	34 x 1.10	-	2/3, 3/4, 4/6
4	41 x 1.30	-	2/3, 3/4, 4/6, 1.4/2
5	54 x 1.60	1.25	2/3, 3/4, 4/6, 1.4/2, 0.75/1.25
6	67 x 1.60	0.75, 1.25	2/3, 3/4, 0.75/1.25, 1.4/2, 0.75/1.10
7	80 x 1.60	1.25, 0.75	2/3, 3/4, 0.75/1.25, 1.4/2, 0.75/1.10

Cutting Application : Structural steels, Deep drawing steel, Machine steel, Spring steel, Medium alloy steel, Nitriding steel, Stainless steel.



GOLD M42 - ULTIMA

Specially designed tooth geometry with extreme positive rake angle having additional relief angle and deep gullet for aggressive cutting.



1	27 x 0.90	-	2/3, 3/4
2	34 x 1.10	-	2/3, 3/4
3	41 x 1.30	-	2/3, 3/4
4	54 x 1.60	-	2/3, 3/4
5	67 x 1.60	-	2/3, 3/4

Cutting Application : Deep drawing steel, Spring steel, Case hardened steel, Nitriding steel, Tool steel, Quenched & Tempered steel and Hot work steel.



GOLD M42 - ALUMINA

Specially designed skip tooth with shallow gullet and positive rake angle.



1	20 X 0.90	3.6	-
2	27 x 0.90	3.6	-

Cutting Application : Aluminum die casting extrusion and other Non Ferrous Metals / Alloys.



PLATINUM M51

The Platinum M51 Bandsaw is manufactured from HSS M51 (10% cobalt) edge material Laser beam welded to specially designed BIPICO spring steel backing material. Platinum M51 blade has excellent wear and red hot resistance due to higher percentage of tungsten and cobalt. It has proper distribution of dense hard carbide elements to give superior cutting performance.

PLATINUM M51 - PREMIUM / PLUS / FLEX

Specially designed tooth geometry with positive rake angle having additional relief angle and deep gullet.



1	27 x 0.90	-	2/3, 3/4, 4/6
2	34 x 1.10	-	2/3, 3/4, 4/6
3	41 x 1.30	-	2/3, 3/4
4	54 x 1.60	-	2/3
5	67 x 1.60	-	1.4/2, 3/4, 2/3, 0.75/1.25, 0.75/1.10
6	80 x 1.60	-	2/3, 1.4/2, 3/4, 0.75/1.25, 0.75/1.10

Cutting Application : Stainless Steel, Deep drawing steel, Machining steel, Quenched and Tempered steel, Case hardened steel, Spring steel, Alloy steel, Hot work steel, Nitriding steel, Cold work steel, High speed steel, Cast iron steel, Rust and heat resistant steel. It can be used for Hardened material upto 45 HRC.



PLATINUM M51 - ULTIMA

Specially designed tooth geometry with extreme positive rake angle having additional relief angle and deep gullet for aggressive cutting.



1	27 x 0.9	-	2/3
2	34 x 1.10	-	2/3
3	41 x 1.30	-	2/3
4	54 x 1.60	-	2/3
5	67 x 1.60	-	2/3

Cutting Application : Quenched and Tempered steel, Case hardened steel, High alloy steel, Hot work steel, Nitriding steel, Stainless steel, High speed steel, Cast iron steel, Rust and heat resistant steel. It can be used for Hardened material upto 45 HRC.



CARBIDE TIPPED BANDSAW

Carbide Tipped Bandsaw is recommended for cutting harder and difficult - to - machine Alloys with better surface finish. It gives higher productivity at economical cost.

Available Grade :

- 1) **BIPICO TRI CHIP** : Non set carbide tipped bandsaw available in standard Hi-Lo geometry with positive main angle.

Cutting Application : Aluminium, Steel and Tool Steel

- 2) **BIPICO MULTI CHIP X-TRA** : Non set carbide tipped bandsaw available with positive main angle with 5 tooth geometry for aggressive cutting.

Cutting Application : Aluminium alloys, difficult - to - cut Aluminium, in general aluminium application on automatic high speed machine.

- 3) **BIPICO MULTI CHIP SINUS** : Non set carbide tipped bandsaw with positive main angle with 4 tooth geometry.

Cutting Application : Cutting of stainless steel, difficult Tool steel, Titanium, Inconel alloys, Graphite and in general difficult to cut material.



BIPICO MULTI CHIP SINUS / MULTI CHIP X-TRA / TRI CHIP

3/4"	20 x 0.9							✓
1"	27 x 0.9				✓	✓	✓	
1 1/4"	34 x 1.1				✓	✓	✓	✓
1 1/2"	41 x 1.3			✓	✓	✓	✓	✓
2"	54 x 1.3				✓			
2"	54 x 1.6	✓	✓	✓	✓	✓		
2 5/8"	67 x 1.6	✓	✓	✓				
3"	80 x 1.6	✓	✓					

✓ = Available TPI in all above 3 Grades of Carbide Tipped Bandsaw

BIMETAL BANDSAW SPEED AND FEED CHART

Material (Annealed)	Stock Dimensions	Up to 25 mm		From 25 - 75 mm		From 75 - 150mm		Over 150mm	
	Tooth Pitch	10/14, 8/12, 6/10, 5/8 24, 18, 14, 10, 6		5/8, 6, 4/6, 3/4, 4		3/4, 2/3, 3		2/3, 1.4/2, 0.75/1.25 1.25, 0.75"	
	Grade	Band Speed Mtr/Min	Cutting Rate Sq.Cm/Min.	Band Speed Mtr/Min	Cutting Rate Sq.Cm/Min.	Band Speed Mtr/Min	Cutting Rate Sq.Cm/Min.	Band Speed Mtr/Min	Cutting Rate Sq.Cm/Min.
Carbon Steels	1008-1013	75	52 ~ 65	66	64 ~ 96	62	84 ~ 110	58	70 ~ 103
	1015-1018	75	58 ~ 84	66	84 ~ 110	62	96 ~ 130	58	70 ~ 110
	1048-1065	65	32 ~ 45	58	38 ~ 52	55	52 ~ 70	50	45 ~ 64
	1065-1095	60	20 ~ 38	53	32 ~ 45	49.8	38 ~ 52	45	32 ~ 52
Free Machining Steels	1108-1111	90	58 ~ 71	79	70 ~ 90	75	84 ~ 97	68	71 ~ 90
	1112-1113	90	58 ~ 77	79	70 ~ 96	75	96 ~ 116	68	77 ~ 96
	1115-1132	85	58 ~ 84	74	70 ~ 103	70	90 ~ 122	65	77 ~ 110
	1137-1151	80	32 ~ 52	70	45 ~ 64	65	64 ~ 84	62	52 ~ 77
Manganese Steels	1320-1330	75	26 ~ 45	66	32 ~ 52	62	52 ~ 70	58	38 ~ 58
	1335-1345	70	26 ~ 45	62	38 ~ 52	58	52 ~ 70	54	38 ~ 58
Nickel Chrome Steels	3115-3130	78	26 ~ 39	70	32 ~ 45	65	32 ~ 45	60	32 ~ 45
	3135-3150	65	26 ~ 39	58	26 ~ 45	54	39 ~ 52	50	32 ~ 52
	3310-3315	60	19 ~ 26	52	26 ~ 32	50	32 ~ 45	46	26 ~ 39
Molybdenum Steels	4017-4024	90	32 ~ 58	80	45 ~ 70	75	58 ~ 84	70	52 ~ 77
	4032-4042	85	26 ~ 45	75	32 ~ 58	70	58 ~ 84	65	52 ~ 77
	4047-4068	75	12 ~ 38	66	32 ~ 52	62	38 ~ 64	58	32 ~ 52
Chrome Moly Steels	4130-4140	85	26 ~ 45	75	38 ~ 58	70	58 ~ 84	65	52 ~ 77
	4142-4150	70	12 ~ 38	62	32 ~ 52	58	38 ~ 64	54	32 ~ 52
Nickel Chrome Moly Steels	4317-4320	75	26 ~ 38	66	32 ~ 52	62	38 ~ 58	58	32 ~ 52
	4337-4340	70	26 ~ 38	62	26 ~ 45	58	32 ~ 52	54	26 ~ 45
	8615-8627	75	26 ~ 38	66	32 ~ 45	62	38 ~ 52	58	26 ~ 45
	8630-8645	75	20 ~ 32	66	26 ~ 38	62	32 ~ 45	58	26 ~ 45
	8647-8660	65	12 ~ 26	58	20 ~ 32	54	26 ~ 38	50	20 ~ 32
	8715-8750	75	19 ~ 32	66	26 ~ 39	62	32 ~ 45	58	26 ~ 39
	9310-9317	60	6.5 ~ 19	54	13 ~ 19	50	13 ~ 26	46	13 ~ 19
	9437-9445	75	26 ~ 32	66	26 ~ 32	62	32 ~ 39	58	26 ~ 32
	9747-9763	75	20 ~ 32	66	26 ~ 38	62	26 ~ 45	58	20 ~ 38
	9840-9850	72	26 ~ 32	64	26 ~ 39	60	32 ~ 45	56	26 ~ 39
Nickel Moly Steels	4608-4621	75	19 ~ 32	66	32 ~ 39	62	39 ~ 45	58	32 ~ 39
	4640	65	19 ~ 32	58	26 ~ 39	54	32 ~ 45	50	26 ~ 39
	4812-4820	60	19 ~ 32	54	19 ~ 32	50	26 ~ 39	46	26 ~ 32
Chrome Steels	5045-5046	85	26 ~ 39	75	32 ~ 45	70	52 ~ 65	65	45 ~ 52
	5120-5135	85	26 ~ 39	75	39 ~ 45	70	45 ~ 52	65	32 ~ 52
	5140-5160	75	19 ~ 32	66	26 ~ 39	62	32 ~ 45	58	26 ~ 39
	50100-52100	55	13 ~ 26	48	19 ~ 32	46	26 ~ 39	42	19 ~ 32
Chrome Vanadium Steels	6117-6210	68	26 ~ 32	60	32 ~ 45	56	39 ~ 52	52	32 ~ 45
	6145-6152	65	19 ~ 26	58	26 ~ 32	54	32 ~ 39	50	26 ~ 32
Silicon Steels	9255-9260	60	13 ~ 26	54	19 ~ 32	50	19 ~ 32	46	19 ~ 32
	9261-9262	55	6 ~ 19	48	13 ~ 19	46	13 ~ 26	42	13 ~ 19
High Speed Steel	T-1, T-2	40	6 ~ 13	36	13 ~ 19	33	13 ~ 26	30	13 ~ 19
	T-4, T-5	33	6 ~ 13	30	6 ~ 13	28	13 ~ 19	24	4 ~ 11
	T-6, T-8	33	6 ~ 13	30	6 ~ 13	28	6 ~ 13	24	4 ~ 11
	T-15	25	6 ~ 13	22	6 ~ 13	20	6 ~ 13	18	4 ~ 11
	M-1	45	6 ~ 19	40	13 ~ 26	36	19 ~ 32	34	13 ~ 26
	M-2, M-3	35	6 ~ 13	30	13 ~ 19	28	19 ~ 26	25	13 ~ 19
	M-4, M-10	30	6 ~ 13	26	6 ~ 13	24	6 ~ 19	22	6 ~ 13
	A-2	63	13 ~ 19	55	19 ~ 26	52	19 ~ 26	48	13 ~ 19
	D-2, D-3	33	6 ~ 13	30	6 ~ 13	26	6 ~ 13	24	6 ~ 13
	D-7	27	6 ~ 11	24	6 ~ 11	22	6 ~ 11	20	4 ~ 10
Die Steels	O-1, O-2	70	19 ~ 26	62	26 ~ 32	58	32 ~ 39	54	26 ~ 32
	O-6	68	19 ~ 26	60	26 ~ 39	56	32 ~ 45	52	26 ~ 39
Hot Work Steels	H-12, H-13, H-21	45	13 ~ 26	40	19 ~ 32	37	13 ~ 26	35	13 ~ 26
	H-22, H-24, H-25	45	6 ~ 19	40	6 ~ 19	37	6 ~ 19	35	6 ~ 19
Shock Resisting Tool Steels	S-1	65	13 ~ 26	56	19 ~ 32	54	19 ~ 32	50	13 ~ 26
	S-2, S-5	50	6 ~ 19	44	13 ~ 26	42	13 ~ 26	38	6 ~ 19

Material (Annealed)	Stock Dimensions	Up to 25 mm		From 25 - 75 mm		From 75 - 150mm		Over 150mm	
	Tooth Pitch	10/14, 8/12, 6/10, 5/8 24, 18, 14, 10, 6		5/8, 6, 4/6, 3/4, 4		3/4, 2/3, 3		2/3, 1.4/2, 0.75/1.25 1.25, 0.75"	
	Grade	Band Speed Mtr/Min	Cutting Rate Sq.Cm/Min.	Band Speed Mtr/Min	Cutting Rate Sq.Cm/Min.	Band Speed Mtr/Min	Cutting Rate Sq.Cm/Min.	Band Speed Mtr/Min	Cutting Rate Sq.Cm/Min.
Special Purpose Tool Steels	L-6	60	13 ~ 26	54	19 ~ 32	50	19 ~ 32	46	13 ~ 26
	L-7	60	13 ~ 26	54	19 ~ 32	50	19 ~ 32	46	13 ~ 26
Stainless Steels	2.01202E + 11	35	13 ~ 26	30	13 ~ 26	28	13 ~ 26	26	6 ~ 19
	303, 303F	42	13 ~ 26	38	13 ~ 26	36	19 ~ 32	32	13 ~ 26
	3.08309E + 11	27	6 ~ 13	24	6 ~ 13	22	6 ~ 13	20	6 ~ 11
	314316317	27	6 ~ 11	24	6 ~ 13	22	6 ~ 11	20	6 ~ 11
	321347	40	6 ~ 19	35	6 ~ 19	33	13 ~ 26	30	6 ~ 19
	410, 420, 420F	45	6 ~ 19	40	6 ~ 19	37	13 ~ 26	35	6 ~ 19
	416, 430F	60	19 ~ 32	53	26 ~ 39	50	32 ~ 45	46	26 ~ 39
	430446	30	6 ~ 19	26	13 ~ 26	25	13 ~ 26	23	6 ~ 19
	440 A,B,C	35	6 ~ 19	30	6 ~ 19	28	13 ~ 26	26	6 ~ 19
	440F, 443	45	6 ~ 19	40	6 ~ 19	37	13 ~ 26	35	6 ~ 19
	17-4PH, 17-7PH	30	13 ~ 19	26	13 ~ 26	25	19 ~ 26	22	13 ~ 19
	A-7	30	6 ~ 13	28	6 ~ 13	25	13 ~ 19	22	13 ~ 19
Beryllium Copper #25	BHN 100-120	105	28 ~ 39	92	32 ~ 45	87	39 ~ 52	80	32 ~ 45
	BHN 220-250	75	13 ~ 26	66	19 ~ 32	62	26 ~ 39	58	19 ~ 32
	BHN 310-340	60	6 ~ 13	53	8 ~ 13	50	13 ~ 19	48	6 ~ 13
Nickel Base Alloys	Monel	30	6 ~ 13	26	6 ~ 13	25	6 ~ 13	22	6 ~ 13
	R Monel	42	13 ~ 19	37	13 ~ 26	35	13 ~ 26	32	13 ~ 19
	K Monel	30	6 ~ 13	26	6 ~ 11	25	6 ~ 11	22	6 ~ 10
	KR Monel	30	6 ~ 19	26	6 ~ 19	25	6 ~ 19	22	6 ~ 13
	Inconel	33	6 ~ 13	28	6 ~ 19	26	6 ~ 19	25	6 ~ 13
	Inconel X	27	6 ~ 11	24	6 ~ 11	22	6 ~ 11	20	6 ~ 10
	Hastelloy A	36	6 ~ 13	32	6 ~ 13	30	13 ~ 19	27	6 ~ 13
	Hastelloy B	33	6 ~ 11	28	6 ~ 13	26	6 ~ 13	24	6 ~ 11
	Hastelloy C	30	6 ~ 11	26	6 ~ 11	25	6 ~ 11	22	6 ~ 11
	Rene 41	27	6 ~ 13	24	6 ~ 10	22	6 ~ 10	20	6 ~ 10
	Udimit	30	6 ~ 13	26	6 ~ 13	25	6 ~ 13	22	6 ~ 13
	Waspalloy	27	6 ~ 13	24	6 ~ 11	22	6 ~ 10	20	6 ~ 10
	Titanium	30	6 ~ 13	26	13 ~ 19	25	13 ~ 19	22	13 ~ 19
Titanium Alloys	TI-140A 2CR-2M0	30	6 ~ 11	26	6 ~ 11	25	6 ~ 10	22	6 ~ 10
	TI-150A	30	6 ~ 11	26	6 ~ 11	25	6 ~ 10	22	6 ~ 10
	MST-6AL-4V	30	6 ~ 11	26	6 ~ 11	25	6 ~ 10	22	6 ~ 10
	99% Pure Titanium	30	6 ~ 11	26	6 ~ 11	25	6 ~ 10	22	6 ~ 10
Aluminium Alloy	1100,2011,2017,2024	150	48 ~ 68	132	68 ~ 120	125	120 ~ 151	115	125 ~ 150
	3003,5052,5086,6061	150	48 ~ 68	132	68 ~ 120	125	120 ~ 151	115	125 ~ 150
	6063,6160,6262,7075	150	48 ~ 68	132	68 ~ 120	125	120 ~ 151	115	125 ~ 150
Bronze	Aluminium Bronze	45	13 ~ 26	42	19 ~ 26	37	19 ~ 32	35	19 ~ 26
	Most others	70	39 ~ 58	62	65 ~ 77	58	65 ~ 77	54	45 ~ 58
Copper Alloy	358, 360	105	43 61	92	91 124	87	124 136	80	136 ~ 165
	353	100	38 55	88	81 111	83	100 110	75	115 ~ 146
	1452, 187	100	36 51	88	51 90	83	100 110	75	110 ~ 137
	380, 544	95	34 48	84	50 92	78	85 103	72	105 ~ 128
	173, 932	90	30 43	80	45 80	75	70 90	70	90 ~ 115
	330, 365	85	27 39	75	39 70	70	70 80	65	80 ~ 104
	623, 624	80	25 36	70	36 68	66	63 75	62	75 ~ 97
	230, 260, 272	75	23 33	66	33 60	62	60 70	58	72 ~ 90
	280, 464, 632, 655	75	23 33	66	33 60	62	60 70	58	72 ~ 90
	101, 102, 110, 122, 172	70	23 32	62	32 56	58	56 68	54	70 ~ 86
	1751, 182, 220, 510	70	23 32	62	32 56	58	56 68	54	70 ~ 86
	625, 706, 715, 934	70	23 32	62	32 56	58	56 68	54	70 ~ 86
	630	65	22 31	57	31 54	54	54 66	50	68 ~ 84
	811	60	21 29	54	29 50	50	51 62	46	64 ~ 79

Formula for calculating time for cutting the job :

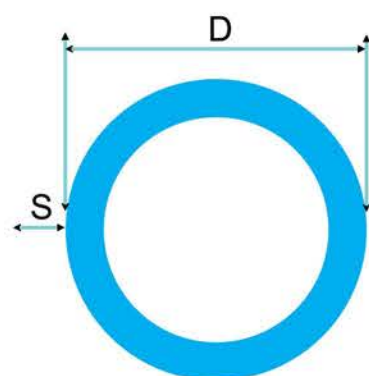
TOOTH SELECTION CHART

FOR ROUND SOLID BAR																					
Diameter in mm	5	10	15	20	25	30	50	75	100	150	250	300	500	700	800	900	1000	1100	1200		
TEETH PER INCH/25 MM	10/14		8/12	6/10	5/8		4/6		3/4		2/3		1.4/2		1.25			0.75/1.25			

FOR SQUARE / RECTANGLE SOLID																					
Width in mm	5	10	15	20	25	30	50	75	100	150	200	250	300	400	500	700	800	900	1000	1100	1200
TEETH PER INCH/25 MM	10/14	8/12	6/10	5/8		4/6		3/4		2/3		1.4/2		1.25				0.75/1.25			

FOR STRUCTURALS																					
Wall Thickness in mm	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	20	25	30	40	50	
TEETH PER INCH/25 MM	10/14		8/12	6/10	5/8		4/6							3/4				2/3			

TOOTH SELECTION CHART FOR CUTTING OF PIPES / TUBES



D = Diameter
S = Wall Thickness

D (mm)	20	40	60	80	100	120	150	200	300	400	500	600	700
S (mm)	Tooth pitch (TPI)												
2	14	14	14	14	14	14	10-14	10-14	8-12	8-12	6-10	6-10	5-8
3	14	14	10-14	10-14	10-14	10-14	8-12	8-12	6-10	6-10	5-8	5-8	5-8
4	14	14	10-14	10-14	8-12	8-12	8-12	8-12	5-8	5-8	4-6	4-6	4-6
5	14	10-14	10-14	10-14	8-12	8-12	8-12	6-10	5-8	5-8	4-6	4-6	3-4
6	14	10-14	10-14	8-12	8-12	8-12	5-8	5-8	4-6	4-6	4-6	4-6	3-4
8	14	10-14	10-14	8-12	8-12	6-10	6-10	5-8	4-6	4-6	4-6	3-4	3-4
10		8-12	6-10	6-10	6-10	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4
12		8-12	6-10	6-10	5-8	5-8	4-6	4-6	3-4	3-4	3-4	3-4	3-4
15		8-12	6-10	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3
20			6-10	5-8	4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3	2-3
30				4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3	2-3	2-3
50						3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3
75								2-3	2-3	2-3	2-3	2-3	1.4-2
100									2-3	2-3	1.4-2	1.4-2	1.4-2
150									2-3	1.4-2	1.4-2	1.4-2	
200										1.4-2	1.4-2	1.4-2	

BLADE BREAK-IN EXTREMELY IMPORTANT

The extremely sharp tooth tip and edges of new blades must be broken-in before applying full feed pressure to the blade. A good analogy is that of writing with a freshly sharpened wooden pencil.

RECOMENDED PROCEDURE

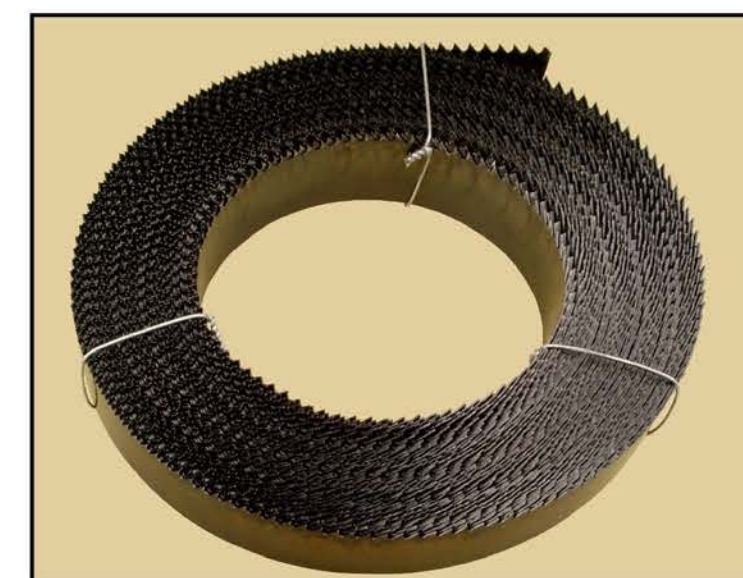
- Maintain proper blade speed for the material to be cut.
- Reduce blade feed pressure or feed rate by 50% for the first 300 to 500 square cm of material cut
- Gradually increase feed pressure or feed rate after break-in to full pressure or rate.

CARBON BANDSAW BLADES

BIPICO CARBON FLEXIBLE BACK BANDSAW BLADES

An economical, high quality carbon steel bandsaw for general purpose cutting. Hard teeth and a flexible back ensures long cutting life on mild and low alloy steels, plastics and wood.

WIDTH AND THICKNESS		TEETH PER INCH (25 mm)	
mm	inch	Standard Tooth	Hook Tooth
6.0 x 0.63	1/4 x .025	10,14,18,24	4,6
10.0 x 0.63	3/8 x .025	4,6,8,10,14,18,24	3,4,6
12.5 x 0.63	1/2 x .025	6,8,10,14,18,24	3,4,6
16.0 x 0.80	5/8 x .032	6,8,10,14,18	3,4,6
20.0 x 0.80	3/4 x .032	6,8,10,14,18	3,4,6
25.0 x 0.90	1 x .035	4,6,8,10,14	2,3,4,6



BIPICO HARD BACK CARBON BANDSAW BLADES

A heavy duty carbon blade designed to deliver maximum performance from standard bandsaw machines. The high hardness backing material allows increased feed pressure and cutting rates without compromising to the straightness and accuracy of cut, while greater fatigue resistance extends the blade life than of standard carbon steel blades.

WIDTH AND THICKNESS		TEETH PER INCH (25 mm)	
mm	inch	Standard Tooth	Hook Tooth
6.0 x 0.63	1/4 x .025	8,10,14,18,24	4,6
10.0 x 0.63	3/8 x .025	8,10,14,18	3,4,6
12.5 x 0.63	1/2 x .025	6,8,10,14,18,24	3,4,6
16.0 x 0.80	5/8 x .032	10,14,18	4
20.0 x 0.80	3/4 x .032	6,8,10,14,18	3,6
25.0 x 0.90	1 x .035	6,8,10,14	2,3,4

* Bipico Carbon Bandsaw Blades can be supplied both in coils & welded loops

HAND HACKSAW BLADES



High Speed Steel All Hard Hand Hacksaw Blades

High Speed Steel All Hard Hand Hacksaw Blade is manufactured from top quality high speed steel. The blade is precisely hardened and tempered throughout its entire width to give strong & rigid back ensuring a perfectly straight cut and long life.

The work piece should be securely held in a clamp or vice to prevent shattering of the blade.

It cuts through all types of materials including alloy and stainless steels.



High Speed Steel Flexible Bimetal Hand Hacksaw Blades

A virtually shatter proof bimetal blade for superb cutting performance, wear resistance and safety.

The combination of M2 high speed cutting edge, electrobeam welded to a flexible alloy back gives a level of cutting power and flexibility that is far superior to edge hardened or conventional flexible blades.

It cuts through all types of materials including alloy and stainless steels.



High Speed Steel All Hard Variable Pitch Hand Hacksaw Blades

The New 20/24 VARI TOOTH HSS Blade is all hard blade for highly accurate cutting and long life.

Has two blades in one. It cuts through all types of materials including alloy and stainless steels.



High Speed Steel Flexible Bimetal Variable Pitch Hand Hacksaw Blades

The New 20/24 VARI TOOTH Bimetal HSS Blade is virtually unbreakable, has superb cutting performance with wear resistance and safety.

Has two blades in one. It cuts through all types of materials including alloy and stainless steels.



Low Alloy Steel Hand Hacksaw Blades

A low alloy steel blade is manufactured from high carbon steel and this blade is ideal for general purpose sawing of mild steel, brass, aluminium, copper and other soft metals and plastics.

ALL HARD HIGH SPEED STEEL

⇒ Accurate Cutting

⇒ Long Life

BLADE SIZE (in mm)	BLADE SIZE IN (inches)	TEETH PER 25 mm	PIN DIA. (mm)	PACK SIZE	WEIGHT PER PACK (K.G.)
250 x 12.5 x 0.63	10 x 1/2 x 0.025	18	4	100	1.50
250 x 12.5 x 0.63	10 x 1/2 x 0.025	24	4	100	1.50
300 x 12.5 x 0.63	12 x 1/2 x 0.025	18	4	100	1.80
300 x 12.5 x 0.63	12 x 1/2 x 0.025	24	4	100	1.80
300 x 12.5 x 0.63	12 x 1/2 x 0.025	32	4	100	1.80

BIMETAL HIGH SPEED STEEL

⇒ High Performance

⇒ Shatterproof Blade

250 x 12.5 x 0.63	10 x 1/2 x 0.025	18	4	100	1.50
250 x 12.5 x 0.63	10 x 1/2 x 0.025	24	4	100	1.50
300 x 12.5 x 0.63	12 x 1/2 x 0.025	18	4	100	1.80
300 x 12.5 x 0.63	12 x 1/2 x 0.025	24	4	100	1.80
300 x 12.5 x 0.63	12 x 1/2 x 0.025	32	4	100	1.80

ALL HARD HSS VARIABLE TOOTH

⇒ 20% Longer Life

⇒ High Performance

300 x 12.5 x 0.63	12 x 1/2 x 0.025	20/24	4	100	1.80
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BIMETAL HSS VARIABLE TOOTH

⇒ 20% Longer Life

⇒ High Performance

300 x 12.5 x 0.63	12 x 1/2 x 0.025	20/24	4	100	1.80
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LOW ALLOY STEEL FULLY HARD

⇒ General Purpose

⇒ Economical

250 x 12.5 x 0.63	10 x 1/2 x 0.025	18	4	100	1.50
250 x 12.5 x 0.63	10 x 1/2 x 0.025	24	4	100	1.50
300 x 12.5 x 0.63	12 x 1/2 x 0.025	18	4	100	1.80
300 x 12.5 x 0.63	12 x 1/2 x 0.025	24	4	100	1.80
300 x 12.5 x 0.63	12 x 1/2 x 0.025	32	4	100	1.80

POWER HACKSAW BLADES

The comprehensive range of BIPICO Power Blades Hacksaw Blades will suit virtually all popular sawing machines. The continuous development of our range has improved the long-term sharpness of the blades. There is a choice of ALL Hard HSS or Bimetal HSS blades with a wide range of sizes and tooth pitch to cater for all varieties of materials and thickness.

ALL HARD HIGH SPEED STEEL

High Speed Hacksaw Blades satisfy the highest requirements for power sawing bars, tubes, section etc.

High Speed blades are specially hardened and precision set.

Blades suitable for Kasto Machine can also be produced.



BIMETAL HIGH SPEED STEEL

Manufactured from High Speed Steel, electron beam welded to a spring steel back, these bimetal blades are able to withstand heavy feed pressures, giving economical, high cutting rates. Because these blades are virtually unbreakable in normal use, they are particularly safe and therefore suitable for use by unskilled operators or on older machines. They will cut through most type of material including alloy and stainless steel.



BLADE SIZE (MM)	BLADE SIZE (INCHES)	TEETH PER 25 MM	PIN HOLE DIA. (MM)	PACK SIZE	WEIGHT PER PACK (K.G.)	BLADE SIZE (MM)	BLADE SIZE (INCHES)	TEETH PER 25 MM	PIN HOLE DIA. (MM)	PACK SIZE	WEIGHT PER PACK (K.G.)
300x25x1.25	12x1x0.050	10,14	8.20	20	1.45	300x25x1.25	12x1x0.050	10,14	8.20	20	1.45
350x25x1.25	14x1x0.050	10,14	8.20	20	1.68	350x25x1.25	14x1x0.050	6, 10, 14	8.20	20	1.68
400x25x1.25	16x1x0.050	10,14	8.20	20	1.95	300x32x1.60	12x1-1/4x0.062	6,10	8.20	20	2.46
425x25x1.25	17x1x0.050	10,14	8.20	20	2.03	350x32x1.60	14x1-1/4x0.062	4, 6, 10	8.20	20	2.87
450x25x1.25	18x1x0.050	10,14	8.20	20	2.19	400x32x1.60	16x1-1/4x0.062	4, 6, 10, 14	8.20	20	3.34
350x32x1.60	14x1-1/4x0.062	6,10	8.20	20	2.87	425x32x1.60	17x1-1/4x0.062	10	8.20	20	3.58
400x32x1.60	16x1-1/4x0.062	6,10	8.20	20	3.34	450x32x1.60	18x1-1/4x0.062	4, 6, 10, 14	10.20	20	3.70
425x32x1.60	17x1-1/4x0.062	6,10	8.20	20	3.58	350x32x2.00	14x1-1/4x0.075	4, 6, 10	8.20	20	2.87
450x32x1.60	18x1-1/4x0.062	6,10	10.20	20	3.70	350x38x2.00	14x1-1/2x0.075	4, 6, 10	8.20	10	2.06
450x38x1.60	18x1-1/2x0.062	6,10	10.20	10	2.28	400x38x2.00	16x1-1/2x0.075	4, 6, 10	8.20	10	2.37
450x38x2.00	18x1-1/2x0.075	4, 6, 10	10.20	10	2.65	450x32x2.25	18x1-1/4x0.088	4, 6, 10	10.20	20	2.47
450x45x2.00	18x1-3/4x0.075	4, 6, 10	10.20	10	3.69	450x38x2.25	18x1-1/2x0.088	4, 6, 10	10.20	10	2.67
500x32x2.00	20x1-1/4x0.075	4, 6	10.20	10	2.08	500x38x2.25	20x1-1/2x0.088	4, 6, 10	10.20	10	2.93
500x38x2.00	20x1-1/2x0.075	4, 6, 10	10.20	10	2.93	450x45x2.25	18x1-3/4x0.088	4, 6	10.20	10	3.77
525x38x2.00	21x1-1/2x0.075	4, 6, 10	10.20	10	3.02	475x45x2.25	19x1-3/4x0.088	6	10.20	10	3.97
525x45x2.25	21x1-3/4x0.088	4, 6	10.20	10	4.45	500x45x2.25	20x1-3/4x0.088	4, 6	10.20	10	4.18
550x38x2.25	22x1-1/2x0.088	4, 6, 10	10.20	10	3.20	525x38x2.25	21x1-1/2x0.088	6	10.20	10	3.03
600x40x2.25	24x1-1/2x0.088	4, 6, 10	10.20	10	3.48	525x45x2.25	21x1-3/4x0.088	4, 6	10.20	10	7.45
600x45x2.25	24x1-3/4x0.088	4, 6, 10	10.20	10	4.71	550x45x2.25	22x1-3/4x0.088	6	10.20	10	4.66
600x45x2.25	24x1-3/4x0.088	4, 6	10.20	10	4.71	575x45x2.25	23x1-3/4x0.088	4	10.20	10	4.87
600x50x2.25	24x2x0.088	4, 6, 10	10.20	10	4.85	600x45x2.25	24x1-3/4x0.088	6	10.20	10	4.71
600x38x2.50	24x1-1/2x0.100	4, 6	10.20	10	4.57	500x50x2.50	20x2x0.100	4, 6	10.20	10	4.87
600x50x2.50	24x2x0.100	4, 6	10.20	10	6.11	525x50x2.50	21x2x0.100	4, 6	10.20	10	5.11
700x38x2.50	28x1-1/2x0.100	4, 6	10.20	10	5.20	550x50x2.50	22x2x0.100	4, 6	10.20	10	5.35
700x50x2.50	28x2x0.100	4, 6	10.20	10	6.98	575x50x2.50	23x2x0.100	4	10.20	10	5.61
750x38x2.50	30x1-1/2x0.100	4, 6	10.20	10	5.44	600x50x2.50	24x2x0.100	4, 6	10.20	10	5.85
750x50x2.50	30x2x0.100	4, 6	10.20	10	7.47	650x50x2.50	26x2x0.100	4, 6	10.20	10	6.32
800x50x2.50	32x2x0.100	4, 6	10.20	10	7.75	700x50x2.50	28x2x0.100	4, 6	10.20	10	6.80
900x50x2.50	36x2x0.100	4, 6	10.20	10	8.99	750x50x2.50	30x2x0.100	4, 6	10.20	10	7.47
						800x50x2.50	32x2x0.100	4, 6	10.20	10	7.75
						900x50x2.50	36x2x0.100	4, 6	10.20	10	8.99

SQUARE GROUND TOOL BITS HIGH SPEED STEEL



SIZE (INCH)		
WIDTH	HEIGHT	LENGTH
1/8	1/8	2 1/2
3/16	3/16	2 1/2
1/4	1/4	2 1/2
5/16	5/16	2 1/2
3/8	3/8	3
7/16	7/16	3 1/2
1/2	1/2	4
5/8	5/8	4 1/2
3/4	3/4	5
7/8	7/8	6
1	1	7
1 1/8	1 1/8	7
1 1/4	1 1/4	7

EXTRA LONG		
WIDTH	HEIGHT	LENGTH
1/4	1/4	4
1/4	1/4	6
1/4	1/4	8
5/16	5/16	4
5/16	5/16	6
5/16	5/16	8
3/8	3/8	4
3/8	3/8	6
3/8	3/8	8
7/16	7/16	6
1/2	1/2	6
1/2	1/2	8
5/8	5/8	6
5/8	5/8	8
3/4	3/4	6
3/4	3/4	8
1	1	8

AVAILABLE
BP 101 GRADE M2 WITHOUT COBALT
BP 202 GRADE M35 WITH 5% COBALT
BP 303 GRADE M42 WITH 8% COBALT
BP 404 GRADE T42 WITH 10% COBALT
BP 505 GRADE T42 WITH 10% COBALT
(WITH CRYOGENIC TREATMENT)

CUT - OFF BLADES HIGH SPEED STEEL



SIZE (INCH)		
WIDTH	HEIGHT	LENGTH
1/6	1/2	4 1/2
1/16	11/16	5
3/32	1/2	4 1/2
3/32	5/8	5
1/8	1/2	4 1/2
1/8	3/4	5
1/8	3/4	6
1/8	7/8	6
1/8	7/8	7
3/16	3/4	6
3/16	13/16	6
3/16	1	6 1/2
3/16	1	8
3/16	1 1/8	7
1/4	1 1/8	7
1/4	1 1/4	7
1/4	1 1/4	9

AVAILABLE
BP 101 GRADE M2 WITHOUT COBALT
BP 202 GRADE M35 WITH 5% COBALT

TOOL BITS



HIGH SPEED TOOL BITS

are manufactured from the finest quality Molybdenum & Tungsten bearing grades of High Speed Steel. Widely used for machining and variety of ferrous and nonferrous metals. Sophisticated heat treatment provides more life between two regrinds.

RECTANGULAR GROUND TOOL BITS HIGH SPEED STEEL



SIZE (INCH)			SIZE (INCH)		
WIDTH	HEIGHT	LENGTH	WIDTH	HEIGHT	LENGTH
1/8	1/2	4	3/8	3/4	5
3/16	5/16	4	3/8	3/4	6
1/4	3/8	2 1/2	3/8	1	6
1/4	3/8	3	1/2	3/4	4
1/4	3/8	4	1/2	3/4	5
1/4	3/8	6	1/2	3/4	6
1/4	1/2	3	1/2	1	6
1/4	1/2	4	1/2	1	7
1/4	1/2	6	1/2	1	8
1/4	3/4	4	1/2	1 1/4	7
1/4	3/4	5	1/2	1 1/2	7
1/4	3/4	6	5/8	3/4	5
1/4	1	6	5/8	7/8	6
5/16	3/8	4	5/8	1	6
5/16	7/16	3	5/8	1	7
5/16	7/16	4	5/8	1 1/4	6
5/16	1/2	4	5/8	1 1/4	7
5/16	1/2	6	5/8	1 1/2	7
5/16	3/4	4	3/4	1	6
5/16	3/4	5	3/4	1	7
5/16	1	6	3/4	1 1/4	6
3/8	1/2	3	3/4	1 1/4	7
3/8	1/2	4	3/4	1 1/2	7
3/8	5/8	4	3/4	1 1/8	7
3/8	5/8	5	11 1/4	6	
3/8	5/8	6	11 1/4	7	
3/8	3/4	4	11 1/2	7	

AVAILABLE
BP 101 GRADE M2 WITHOUT COBALT
BP 202 GRADE M35 WITH 5% COBALT
BP 303 GRADE M42 WITH 8% COBALT

ROUND TOOL BITS HIGH SPEED STEEL



SIZE (INCH)	
DIAMETER	LENGTH
1/8	2 3/4
3/16	3 1/2
1/4	2 1/2
5/16	2 1/2
5/16	3 1/2
3/8	3
7/16	3 1/2
7/16	4
1/2	4
5/8	3

EXTRA LONG	
DIAMETER	LENGTH
1/4	4
5/16	4 1/2
3/8	4
3/8	5
7/16	5 1/2
1/2	6
3/16	6
5/8	6
3/4	6
7/8	6
7/8	8
1	6
1	8

AVAILABLE
BP 101 GRADE M2 WITHOUT COBALT
BP 202 GRADE M35 WITH 5% COBALT

CUT - OFF BLADES P TYPE (T SHAPED) HIGH SPEED STEEL



SIZE (INCH)			
CODE	WIDTH	HEIGHT	LENGTH
P1N	0.040	1/2	3 1/2
P1	1/16	1/2	4 1/2
P2N	5/64	1/2	4 1/2
P2	3/32	1/2	4 1/2
P3S	1/8	1/2	4 1/2
P3N	3/32	11/16	5
P3	1/8	11/16	5
P4	5/32	11/16	5
P5S	3/16	11/16	5
P3W	1/8	3/4	5
P4W	5/32	3/4	5
P5W	3/16	3/4	5
P5X	1/8	7/8	6
P5N	5/32	7/8	6
P5	3/16	7/8	6
P6	1/4	7/8	6
P8X	1/8	1 1/8	6 1/2
P8N	5/32	1 1/8	6 1/2
P8	3/16	1 1/8	6 1/2
P9	1/4	1 1/8	6 1/2
P10	5/16	1 1/8	6 1/2

AVAILABLE
BP 101 GRADE M2 WITHOUT COBALT
BP 202 GRADE M35 WITH 5% COBALT

UNIVERSAL HOLE SAW



Sailent Features & Advantages :

- ▶ Cutting depth is 27 mm giving double life than conventional Hole Saw.
- ▶ Specially design & precision tooth geometry for cutting variety of materials.
- ▶ Cutting at higher speed with better and smooth finish.
- ▶ Useful in cutting of all different types of soft and hard material.
- ▶ Higher hardness & toughness of HSS teeth for excellent cutting & longer life.
- ▶ Better rigidity

BIPICO Universal Hole Saws are manufactured from HSS M42 (8% Cobalt) grade imported Bimetal Strips. The tooth geometry of Hole Saw is specially designed by our R & D centre for cutting variety of material. The Hole Saws are heat treated in fully automated CNC controlled imported furnaces in inert atmosphere resulting consistency in hardness & better toughness. Universal Hole Saw is single piece construction with inbuilt Arbor & Drill.

Diameter :					
MM	INCH	MM	INCH	MM	INCH
12	1/2	40	1-5/8	70	2-3/4
16	5/8	44	1-3/4	76	3
19	3/4	48	1-7/8	79	3-1/8
22	7/8	51	2	83	3-1/4
25	1	54	2-1/4	86	3-3/8
29	1-1/8	57	2-1/4	89	3-1/2
32	1-1/4	60	2-3/8	95	3-3/4
35	1-3/8	64	2-1/2	102	4
38	1-1/2	67	2-5/8		

PRECISION HOLE SAW



Sailent Features & Advantages :

- ▶ Variable teeth with positive rake angle reduce cutting vibrations.
- ▶ Special heat treatment resulting faster cutting than conventional Hole Saw.
- ▶ Provide extra swap clearance when cutting thicker metal section.
- ▶ The better Drill geometry giving easier penetration into the material.
- ▶ Smooth cut and have less tendency to snag on, contact with irregular service.
- ▶ Bipico Hole Saw is useful in cutting Cast Iron, Mild Steel, Cast Steel, Stainless Steel, Aluminium, Duralium, Inox, Non Ferrous Alloys, Bakelite, Bronze, Brass, Wood, Hardwood and Plaster of Paris.
- ▶ Hole Saw is useful for variety of applications like production, maintenance, electrical panel manufacturing, Plumbing and carpentry.

BIPICO Precision Hole Saws are manufactured from HSS M42 (8% Cobalt) imported Bimetal Strips. The tooth geometry of Hole Saw is specially design by our R&D centre. The tooth design is variable pitch with positive rake angle. The Hole Saws are heat treated in fully automated CNC controlled imported furnaces in inert atmosphere resulting consistency in hardness & better toughness.

Diameter :							
MM	INCH	MM	INCH	MM	INCH	MM	INCH
14	9/16	44	1-3/4	79	3-1/8	114	4-1/2
16	5/8	48	1-7/8	83	3-1/4	121	4-3/4
19	3/4	51	2	86	3-3/8	127	5
22	7/8	54	2-1/8	89	3-1/2	133	5-1/4
25	1	57	2-1/4	92	3-5/8	140	5-1/2
29	1-1/8	60	2-3/8	95	3-3/4	152	6
32	1-1/4	64	2-1/2	102	4	160	6-5/16
35	1-3/8	67	2-5/8	105	4-1/8	183	7-5/16
38	1-1/2	70	2-3/4	108	4-1/4	210	8-1/4
40	1-9/16	76	3	111	4-3/8		

HOLE SAW CUTTING TIPS

- ▶ Always wear safety glasses.
- ▶ Keep hands, loose hair and clothing away from the rotating Saws.
- ▶ Use oil or coolant on most metals except cast iron.
- ▶ Hold the Impact Drill machine firmly and perpendicular to the work surface.
- ▶ Use enough pressure to ensure that the Hole Saw cuts and does not just "rub" the work. Make clear the chips frequently from Hole Saw.
- ▶ Follow the recommended cutting speed for dia of Hole Saw, Rpm & material to be cut. Use a variable speed machine, if possible.
- ▶ For harder material & tough cuts, we recommend self-locking Arbor eliminating chatter & vibrations during cutting.
- ▶ When sawing tough materials such as ceramics, it is sometimes a good idea to leave the Drill in only long enough to allow the Hole Saw to penetrate the material and establish its position. Then take the Drill out of the Hole Saw. This will lessen pressure, which will allow for a much faster cut.
- ▶ Coolant should be used, especially when cutting metals and fired ceramics.
- ▶ Always start with low (or recommended) speed (RPM). Speed can be increased as ease of cutting is noticed. Avoid extreme heat build-up on the cutting surface.

Recommended Cutting Speeds (RPM) for sawing various materials with Bipico High Speed Steel Bimetal Hole Saws:

Saw Diameter		Mild Steel	Stainless & Tool Steel	Cast Iron	Brass & Aluminium	
MM	INCH					
14-25	9/16-1	580-350	300-175	400-235	790-470	
27-51	1 1/16-2	325-170	160-85	215-115	435-230	
52-76	2 1/16-3	165-115	80-55	110-75	220-150	
79-102	3 1/8-4	110-85	55-40	70-55	140-110	
105-210	4 1/8-8 9/32	80-40	40-20	55-25	110-60	

ARBORS

BIPICO provides 3 type of Arbors to make suitable for PRECISION HOLE SAWS. Its having hex shank for better grip & interlocking provision.

Arbor Types :

BPA03 - Hex Shank 9mm (3/8") - Suitable for Dia 14mm to 32mm Hole Saws

BPA05 - Quick Release Hex Shank 9mm (3/8") - Suitable for Dia 35mm to 210mm Hole Saws

BPA06 - Quick Release Hex Shank 11 mm (7/16") - Suitable for Dia 35mm to 210mm Hole Saws



BPA03



BPA05

HOLE SAW KIT

Hole Saw Kits are available for cutting any material. Each kit consist of assorted Hole Saws and accessories that are specifically designed for use in the electrical, plumbing, interiors decoration etc. In addition to these special purpose kits, we offer a general purpose kit and universal kit that is suitable for a variety of applications.

The standard kits have in them Bimetal M42- 8% Cobalt Hole Saws of variable TPI.



JOB	HOLE SAW MM	ACCESSORIES
General Purpose Kit	22, 29, 35, 44, 51 & 64	BPA03 & BPA05 Arbors, HSP Ejector Spring
Electrician Kit	16, 20, 25, 29, 44 & 51	BPA03 & BPA05 Arbors, HSP Ejector Spring
Electrician Kit	16, 20, 22, 25, 29, 35, 44, 51, 64, 68 & 76	BPA03 & BPA06 Arbors, HSP Ejector Spring
Plumber Kit	19, 22, 29, 38, 44, 51 & 57	BPA03 & BPA05 Arbors, HSP Ejector Spring
Plumber Kit	16, 19, 22, 29, 35, 38, 44, 51, 57, 65 & 68	BPA03 & BPA06 Arbors, HSP Ejector Spring
Plumbers and Electrician Kit	16, 20, 22, 29, 35, 38, 40, 44, 51, 57, 65 & 68	BPA03 & BPA06 Arbors, HSP Ejector Spring
Automotive Kit	19, 22, 25, 29, 32 & 38	BPA03 & BPA05 Arbors
Locksmith Kit	24, 27, 32, 35, 38, 54 & 60	BPA03 & BPA05 Arbors, HSP Ejector Spring
Locksmith Kit	22, 24, 25, 27, 32, 35, 38, 44, 54 & 60	BPA03 & BPA06 Arbors, HSP Ejector Spring
Universal Kit	16, 57, 64, 20, 22, 25, 29, 32, 35, 38, 44, 51, 68 & 76	BPA03 & BPA06 Arbors, HSP Ejector Spring

SAWS



PROFESSIONAL : TUBULAR HACKSAW FRAME BHF - 20

Blade	250mm/300mm 10/12 inches
Section	13mm x 16 mm x 19 Gauge
Nt.Wt.	670gms

- ▶ Zinc Die Cast Handle. Powder coated
- ▶ Adjustable for 10" & 12" Blade.
- ▶ Tubular design to give rigidity.



PROFESSIONAL : RECTANGULAR FRAME BHF - 40

Blade	250mm/300mm 10/12 inches
Section	20mmx15mmx18 Gauge
Nt.Wt.	520gms

- ▶ Heavy Duty aluminium die-cast handle.
- ▶ Handle & pipe - epoxy powder coated.
- ▶ Rigid & balanced frame with carbon steel pipe
- ▶ 8mm square fitting with wing nut.
- ▶ In the process of blade fitting, rivets do not fall off.
- ▶ Also available with the same feature in chrome plated pipe.



PROFESSIONAL : TUBULAR FRAME BHF - 50

Blade	250mm/300mm 10/12 inches
Section	18mm x 13 mm x 16 Gauge
Nt.Wt.	370gms

- ▶ Unbreakable Nylon Handle.
- ▶ Pipe Epoxy Powder Coated.
- ▶ Adjustable for 10" & 12" Blade
- ▶ 8mm square fitting with wing nut.
- ▶ In the square of blade fitting rivets do not fall off.
- ▶ Also available with the same feature in chrome plated pipe.



PROFESSIONAL : FRAME ADJUSTABLE BHF - 44

Blade	250mm/300mm 10/12 inches
Section	18mm x 5.0mm
Nt.Wt.	685gms

- ▶ A.B.S. Plastic Heavy Handle.
- ▶ Adjustable for 10" & 12" Blade.
- ▶ 8mm square fitting with wing nut.
- ▶ In the process of blade fitting, rivets do not fall off.



PROFESSIONAL : FIX TYPE FRAME BHF - 46

Blade	300mm /12 inches
Section	19mm x 6.35mm
Nt.Wt.	610gms

- ▶ Rigid & heavy duty frame for 12" blades only.
- ▶ Environmental friendly wooden handle.
- ▶ 8mm square fitting with wing nut.
- ▶ In the process of blade fitting, rivets do not fall off.



HANDY JUNIOR SAW - PISTOL GRIP BPG - 110

Blade	150mm /6 inches
Section	9.5 mm x 4.78mm
Nt.Wt.	140gms

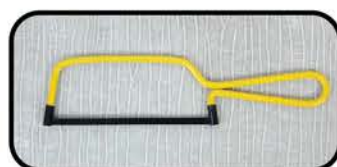
- ▶ Pistol Grip A.B.S. die moulded handle
- ▶ Fitted with 6" blade.
- ▶ Nickel Plated square screws for blade holding.
- ▶ Knurled nut for blade tensioning.



JUNIOR SAW FRAME BJS - 202

Blade	150mm/6 inches
Section	9.5mmx5mm
Nt.Wt.	170gms

- ▶ Useful for home/ factory / articiane etc.
- ▶ Hexagon nut fitted in wooden handle for blade tensioning.
- ▶ Nickel plated screw for blade holding.



HANDY WIRE SAW - SLEEK TYPE BWS - 6

Blade	150mm/6 inches
Section	6mm round
Nt.Wt.	100gms

- ▶ Low price sleek saw frame.
- ▶ Bow available in different assorted powder coated color.
- ▶ 6" blade fitted with the help of powder coated dowels.

ABRASIVES



Safety Recommendations



Wear Protective goggles



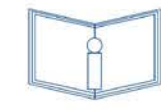
Wear ear protectors



Wear Protective gloves



Wear dust respirator



Observe safety recommendations

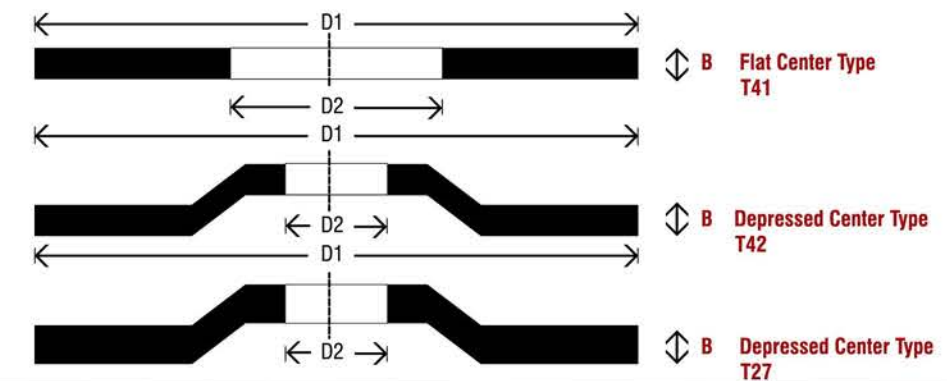


Not approved for side grinding

Abrasive Type Code	Grit Size	Hardness Grade	Bond BF
A = Aluminum Oxide C = Silicon Carbide Z = Zirconia Alumina Grain ZA = Zirconia Alumina Grain /Aluminum Oxide WA = White Corundum	16 - 24 = Coarse 30 - 60 = Medium 70-220 = Fine- Medium	(A-Z)The hardness is graded from soft to hard by means of letters in alphabetically ascending order (A TO Z) H-K = soft L-l = medium P-S = hard T-Z = very hard	BF = Resinoid bond Fibre = Reinforced, woven or non - woven

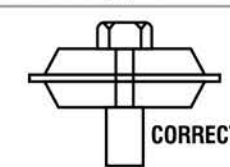
Dimensions and Shape

The diameter, thickness and center hole dimension are indicated in the drawings and tables by means of the following symbols :



Mounting System

- ▶ Never use two flanges that have different diameter for cutting and grinding.
- ▶ Ensure that the two flanges have the same diameter and support areas.



CORRECT



INCORRECT

Maximum Operating Speed

The maximum operating speed (m/s) is shown on the product lable in accordance with the specification of EN12413 the maximum permissible RPM specification applies to the nominal diameter of the tools.

Cutting Wheel Series



- High Performance Abrasive
- No burning mark on workpiece
- Good durability and good finish
- Developed for Metal, Stainless Steel and Precious metals
- More safety and efficiency
- Fast and smooth cutting



- 'A' class Aluminum Oxide Grains
- For metal cutting
- High security
- Fast and smooth cutting
- Good durability and good finish

Grinding Disc For All Metals



- 'A' class Aluminum Oxide Grains
- Specially for metal
- No burning mark on workpiece
- Good durability and good finish
- Fast and smooth cutting

Ultra Thin Cutting Wheel

D1 x B x D2		Shape		Specification	M/S	RPM
Size in Metric	Size in Inch	T41	T41			
76x1x9.52	3x1/25x3/8	076301		AWA600BF	80	20100
76x1.6x9.53	3x1/16x3/8	076201		AWA460BF	80	20100
100x1x16	4x1/25x5/8	100321	100302	AWA600BF	80	15300
100x1.6x16	4x1/16x5/8	100201	100202	AWA460BF	80	15300
115x1x22	4-1/2x1/25x7/8	115310	115302	AWA600BF	80	13300
115x1.6x22	4-1/2x1/16x7/8	115210	115202	AWA460BF	80	13300
125x1x22	5x1/25x7/8	125301	125302	AWA600BF	80	12200
125x1.6x22	5x1/16x7/8	125201	125202	AWA460BF	80	12200
180x1.6x22	7x1/16x7/8	180201	180202	AWA460BF	80	8500
230x1.6x22	9x1/16x7/8	230201		AWA460BF	80	6600

Cutting Wheel For All Metals

D1 x B x D2		Shape		Specification	M/S	RPM
Size in Metric	Size in Inch	T41	T41			
76x3x9.53	3x1/8x3/8	076401		A30RBF	80	20100
100x3x16	4x1/8x5/8	100401	100402	A30RBF	80	15300
115x3x22	4-1/2x1/8x7/8	115401	115402	A30RBF	80	13300
125x3x22	5x1/8x7/8	125401	125402	A30RBF	80	12200
150x3x22	6x1/8x7/8	150401	150402	A30RBF	80	10200
180x3x100	7x1/8x5/8	180401		A30RBF	80	8500
180x3x22	7x1/8x7/8	180403	180404	A30RBF	80	8500
230x3x22	9x1/8x7/8	230401	230402	A30RBF	80	6600
300x3x25.4	12x1/8x1	300401		A30RBF	80	5100
300x3.5x22.2	14x9/64x7/8	300431		A24RBF	80	5100
300x3.5x22.2	12x9/64x7/8	300421		A24RBF	80	5100
300x3.5x25.4	12x9/64x1	300411		A24RBF	80	5100
355x3x25.4	14x1/8x1	355401		A30RBF	80	4400
355x4x20	14x5/32x25/32	355431		A24RBF	80	4400
355x4x22.2	14x5/32x7/8	355421		A24RBF	80	4400
355x4x25.4	14x5/32x1	355411		A24RBF	80	4400
405x3x25.4	16x1/8x1	405401		A30RBF	80	3800
405x4x20	16x5/32x26/33	405431		A24RBF	80	3800
405x4x22.2	16x5/32x7/8	405421		A24RBF	80	3800
405x4x25.4	16x5/32x1	405411		A24RBF	80	3800

D1 x B x D2		Shape	Specification	M/S	RPM
Size in Metric	Size in Inch	T27			
100x6x100	4x1/4x5/8	100901	A24SBF	80	15300
115x6x22	4-1/2x1/4x7/8	115901	A24SBF	80	13300
115x6x16	4-1/2x1/4x5/8	115911	A24SBF	80	13300
125x6x22	5x1/4x7/8	125901	A24SBF	80	12200
150x6x22	6x1/4x7/8	150901	A24SBF	80	10200
180x6x16	7x1/4x5/8	180911	A24SBF	80	8500
180x6x22	7x1/4x7/8	180901	A24SBF	80	8500
200x6x16	8x1/4x5/8	200911	A24SBF	80	7400
200x6x22	4x1/4x7/8	200901	A24SBF	80	7400
230x6x22	9x1/4x7/8	230901	A24SBF	80	6600
230x6x16	4x1/4x5/8	230911	A24SBF	80	6600

PATA / PLANNER BLADES



A Unique product to cater vast industrial application

Salient Features

- Available in two grades i.e. LAS & HSS

Applications

- A Planner Blade is used in Hard Planners and in Machines for Wood-Working
- A Scraper in Chemical Plants, Engineering Industries, Construction Industries, etc.

MARBLE CUTTER



Segmented Blades :

These blades are designed for cutting of marbles.

Available Size: 4" (110mm x 9mm x 20mm)

Trubo :

These blades are designed for fast cutting of granites, marbles, concrete etc.

Available Size: 4" (110mm x 7mm x 20mm)

Continuous Rim :

These blades are designed for clean and free cutting of tiles, ceramics, porcelain & moulding work.

Available Size: 4" (110mm x 9mm x 20mm)

T C T CUTTER



These blades are designed for cutting normal and standard wood series.

Available Size :

4" (110mm x 20mm x 30TPI & 40 TPI) & 5" (125mm x 20mm x 30 TPI & 40 TPI)z

PRODUCTS RANGE

GP SAW - DO-IT-YOURSELF TOOL



Product of 21st Century from BIPICO

An invaluable DO-IT-YOURSELF tool for automobile workshops, carpenters, small factories, engineering industries, building contractors, households, farms & gardens. Nine different adjustable angles provided on special Zinc Die Cast Handle makes easier to cut at DIFFICULT-TO-REACH POSITIONS.

Available in : 4TPI, 6TPI, 10TPI & 14TPI with flexible blade.

Applications : 10 TPI - Can cut Non-Ferrous, Ferrous Bars, Sections, Angles, Channels, Cables, Asbestos Sheets etc.

14 TPI - Can cut galvanised pipes & sheets, PVC pipes, cement pipes, ceramic pipes etc.

6 TPI - Can cut hard wood & 4 TPI - Can cut soft wood.

Replacement of the blade is easy & quick.

MOP WHEEL (FLAP WHEEL ON SHAFT)



Used for removing rust from any place, For sharp Polishing and Cleaning of Metal and Tiles.

SUPERCUT - STEEL FILES



Used for removing rust from any place, For sharp Polishing and Cleaning of Metal and Tiles.

FLAP DISC

(ALUMINIUM OXIDE, ZIRCONIA OXIDE)



Material : Aluminium oxide, Zirconia oxide Abrasives.

Application : Removing materials, edges, chamfering, burrs rust, trimming of weld joints, surface cleaning and finishing.

Features : Powerful and quick sharpening, preventing workpieces from being burnt. High grinding efficiency, good safety in use and longservice life.

VELCRO DISC



Fast changing Disc without tools Widely use in Automotive, Hardware, Electronics, Plastic, Furniture, Hand-crafts and for polishing Low Alloy.

RESIN METAL CLOTH TAPE ROLL



Aluminium Oxide Abrasive Cloth Roll is used for making joint Belt and Disc application. Different Grit used for polishing, surface cleaning and removal of Metal, Automobile, Furniture, Aviation and Engineering Industries.

ALUMINIUM OXIDE FIBER DISC



Made of Hard Fiber Vulcanized Paper coated with Aluminium Oxide (Flexible).

Use for Rust Removing, Paint Stripping, De-burring, Grinding, Welding Seam polishing.

NON WOVEN PAD



Used for removing rust from any place, For sharp Polishing and Cleaning of Metal and Tiles.

RESIN METAL CLOTH BELT



Butt Joint & Lap Joint
Use for polishing with machine for Automobile, Ship Buildings, Aviation, Timber, Furniture, Tanning and Textile Industries.

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