

Bahco Sandflex[®] holesaws

Bahco holesaws Ø 14 to 210 mm



Holesaws for professionals!

Bahco Sandflex®

Razor sharp high-speed steel teeth that cut through anything from timber with nails to tough, stainless steel.

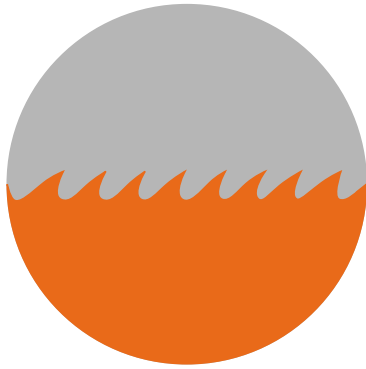
Bahco's Sandflex® Bi-metal holesaws are put together in the same way as the famous Sandflex® hacksaw blades. They have a body of tough, strong carbon steel, which is fitted with a row of hard, sharp high-speed steel teeth. The teeth have 4/6 TPI variable tooth pitch which reduces vibration. They feature a 6° positive cutting angle that cuts extremely easily, requiring less effort, and a set that gives greater clearance for cutting both outwards and inwards towards the core.

Bahco Sandflex® Bi-metal holesaws are on average 20 % faster compared with conventional holesaws. We use the best high-speed steel in the tooth tips that retain their sharpness at least twice as long.

Reduced effort, fast cuts and long life makes our holesaws easy to use. It also means that you can cut significantly more holes for the same tool cost.

Run at correct cutting data Bahco's Sandflex® Bi-metal holesaws are long lasting and effective production tools.





Bahco Carbide



Carbide tipped teeth for cutting firebricks, ceramic tiles, fibreglass and other abrasive materials.

Bahco Carbide holesaws have carbide tipped teeth. They are designed to produce clear, neat holes in hard and abrasive materials, such as light concrete, brick, ceramic tiles, laminated board, plywood, etc.

Bahco Carbide holesaws have 4 TPI regular tooth pitch and a specially developed tooth profile with a 5° positive cutting angle, resulting in excellent cutting performance in all recommended materials. (Please note, they are not suitable for cutting iron and steel or stone and granolithic concrete).

Bahco Carbide holesaws fit the same arbors as Bahco Sandflex® Bi-metal holesaws. However, remember to change the pilot drill to one with a carbide tip when sawing in abrasive materials, so that it doesn't wear out prematurely.



The Bahco Carbide holesaws performs well in light concrete, bricks, plasterboard or wood. Also tile, glassfibre reinforced plastics and other abrasive materials are easily penetrated.



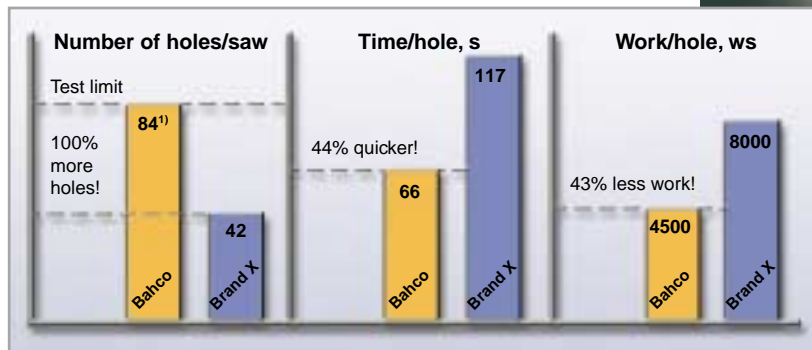
More holes for your money!

Long life, fast cuts and reduced effort

The quality of a holesaw will not be found in its colour or the packaging. It's in the choice of material, the design, the tooth profile and last but not least the construction of the arbor. On the surface many holesaws may look identical. But put them to the test and you will quickly realise that the differences are considerable.

In Bahco's saw laboratory we test many different holesaws. We know where the differences lie – and the similarities. There is a clear performance limit between professional quality tools and the lower priced alternatives that are more suitable for hobby work.

Certainly, if you only intend to make one hole in 10 nesting boxes then a hobby holesaw will more than likely do the job. But, if you need to make 100 holes in 6 mm thick stainless steel for example, or you wish to own a carbide tipped tool that can cut through both tile and brick, day in and day out, then you must choose a professional quality holesaw. And then naturally a holesaw from Bahco.



Long life, fast cuts and reduced effort ensures an easy-to-use holesaw.

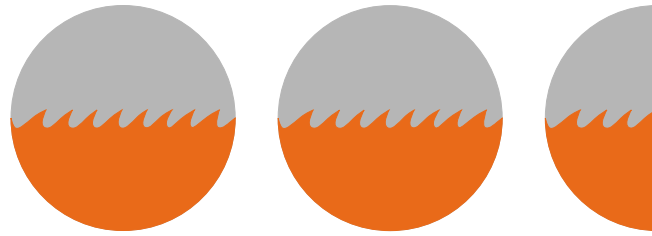
The figures in the diagram are from a bi-metal holesaw test with the following conditions:

- Holesaw diameter 25 mm
- Stainless steel
- Feeding force 334 N
- Cutting depth 6 mm
- Milling oil coolant
- Speed 225 rpm

¹⁾No of holes limited to 84. The Bahco saw was still going strong even after the 84th test hole was made!

All new cutter features are tested in Bahco's saw laboratory before they are introduced into production. Random samples from production must undergo continuous quality testing.





Easy to use

When using holesaws it is important to use the correct speed and sufficient feed force so that the saw cuts correctly into the material. The frictional heat produced will generally disappear with the chips.

Use the approximate speeds recommended in the working instructions supplied with the holesaw. As a general rule for the feed pressure 20 to 30 N per tooth can be used. That is to say, a Ø 25 mm holesaw with 14 teeth requires a feeding force between 280 to 420 N (28 to 42 kp) in order to gain optimal cutting performance.

Use a column drilling machine if possible, as this makes it easier to apply sufficient force when cutting large hole diameters. You should also lift the holesaw occasionally to release the chips. By doing so the holesaw becomes a more efficient and longer lasting tool.

Use cutting oil in order to cool the holesaws and lead off chips when cutting difficult materials, such as stainless steel.

Information is supplied with the holesaws as leaflets, or as shown below, printed on the tooth-guard.

Example

Question: Which speed should be used for a 32 mm hole in an 18/8 stainless sheet?

Answer: 150-100 rpm, together with cooling and lubrication.

SANDFLEX BIM
32.43 mm
1.118 x 1.178

Material	Recommended Speed (rpm)
Steel	150-200
Stainless steel	100-150
Cast iron	100-150
Brass/Copper	200-300
Aluminium	300-350
Wood	400-500

Fastening of workpiece

Use protective goggles

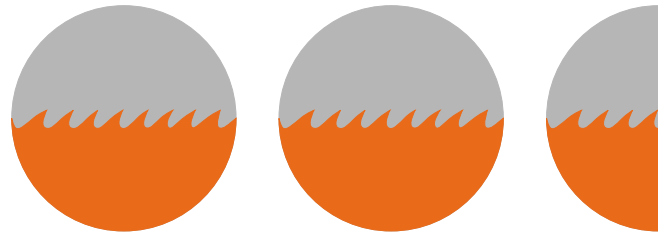
Should be cooled and lubricated

Recommended speeds for cutting in various materials

Suitable arbor

*Saw type and dimension
BIM = Bi-metal*

Extensive range!



New design and clearer markings

Today there are many holesaws available on the market and several of the cheaper models look deceptively like the quality brands. Therefore, it is easy to buy a tool that is not suitable for the job.

In order to make it easier to tell the copies from the original, we have now introduced a clearer Bahco design on our professional tools. It is now easy to identify the Bahco holesaws that offer the quality and performance that you require.

The clear dimension markings on both the packaging and the holesaw make it easier and safer to quickly find the right holesaw dimensions - in the merchants and retailers as well as in your toolbox.



Open display packaging makes it possible to feel the Bahco quality and easily choose the correct holesaw.

Distinct label makes it easy to find correct size, even from a distance.



Size is clearly stated on the saw.

Easy-to-use tooth guard with operating instructions.

Holesaws

Close dimension increments make it easy to find a suitable Bahco holesaw.

All Bahco holesaws have

- 38 mm (1 1/2") cutting depth
- Solid, flat cap design to withstand heavy workload



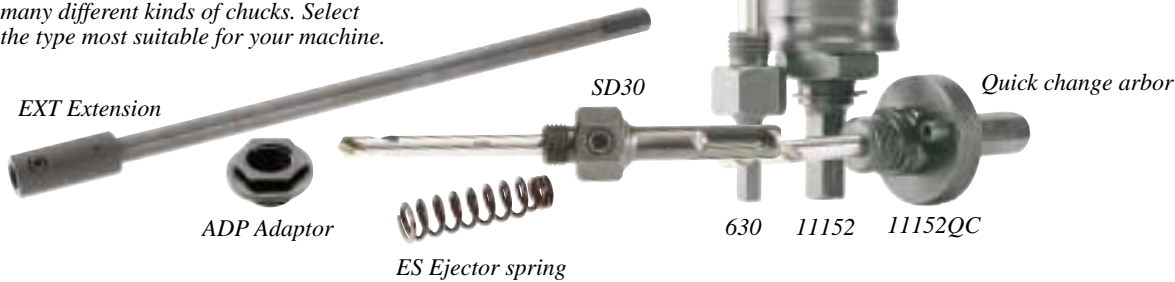
Extensive range with many dimensions

Ø mm inch		Bimetal				Ø mm inch		Carbide tipped	
		Cardboard boxed packaging		Display packaging				Cardboard boxed packaging	
		Product code	EAN-kod 731151+	Product code	EAN code 721151+			Product code	EAN code 731151+
14	9/16	3830-14-VIP	8041618	3830-14-C	8228347	14	9/16	3832-14	8557744
16	5/8	3830-16-VIP	8041625	3830-16-C	8225353	16	5/8	3832-16	8557768
17	11/16	3830-17-VIP	8041632	3830-17-C	8228354	17	11/16	3832-17	8557782
19	3/4	3830-19-VIP	8041649	3830-19-C	8225360	19	3/4	3832-19	8557805
20	25/32	3830-20-VIP	8041656	3830-20-C	8225377	20	25/32	3832-20	8557812
21	13/16	3830-21-VIP	8041663	3830-21-C	8228361	21	13/16	3832-21	8557829
22	7/8	3830-22-VIP	8041670	3830-22-C	8225384	22	7/8	3832-22	8557843
24	15/16	3830-24-VIP	8041687	3830-24-C	8228378	24	15/16	3832-24	8557867
25	1	3830-25-VIP	8041694	3830-25-C	8225391	25	1	3832-25	8557881
27	1 1/16	3830-27-VIP	8041700	3830-27-C	8225407	27	1 1/16	3832-27	8557904
29	1 1/8	3830-29-VIP	8041717	3830-29-C	8225414	29	1 1/8	3832-29	8557928
30	1 3/16	3830-30-VIP	8041724	3830-30-C	8225421	30	1 3/16	3832-30	8557942
32	1 1/4	3830-32-VIP	8041731	3830-32-C	8225438	32	1 1/4	3832-32	8557966
33	1 5/16	3830-33-VIP	8041748	3830-33-C	8228385	33	1 5/16	3832-33	8557980
35	1 3/8	3830-35-VIP	8041755	3830-35-C	8225445	35	1 3/8	3832-35	8558000
37	1 7/16	3830-37-VIP	8041762	3830-37-C	8228392	37	1 7/16	3832-37	8558024
38	1 1/2	3830-38-VIP	8041779	3830-38-C	8225452	38	1 1/2	3832-38	8558048
40	1 9/16	3830-40-VIP	8041786	3830-40-C	8228408	40	1 9/16	3832-40	8558062
41	1 5/8	3830-41-VIP	8041793	3830-41-C	8225469	41	1 5/8	3832-41	8558086
43	1 11/16	3830-43-VIP	8041809	3830-43-C	8228415	43	1 11/16	3832-43	8558109
44	1 3/4	3830-44-VIP	8041816	3830-44-C	8225476	44	1 3/4	3832-44	8558123
46	1 13/16	3830-46-VIP	8041823	3830-46-C	8228422	46	1 13/16	3832-46	8558147
48	1 7/8	3830-48-VIP	8041830	3830-48-C	8225483	48	1 7/8	3832-48	8558161
51	2	3830-51-VIP	8041847	3830-51-C	8225490	51	2	3832-51	8558185
52	2 1/6	3830-52-VIP	8041854	3830-52-C	8228439	52	2 1/6	3832-52	8558208
54	2 1/8	3830-54-VIP	8041861	3830-54-C	8225506	54	2 1/8	3832-54	8558222
56	2 3/16	3830-56-VIP	8152703	3830-56-C	8228446	56	2 3/16	3832-56	8558239
57	2 1/4	3830-57-VIP	8041878	3830-57-C	8225513	57	2 1/4	3832-57	8558246
59	2 5/16	3830-59-VIP	8041885	3830-59-C	8228453	59	2 5/16	3832-59	8558260
60	2 3/8	3830-60-VIP	8041892	3830-60-C	8225520	60	2 3/8	3832-60	8558284
62	2 7/16	3830-62-VIP	8234645	-	-	62	2 7/16	-	-
64	2 1/2	3830-64-VIP	8041908	3830-64-C	8225537	64	2 1/2	3832-64	8558307
65	2 9/16	3830-65-VIP	8041915	3830-65-C	8228460	65	2 9/16	3832-65	8558321
67	2 5/8	3830-67-VIP	8041922	3830-67-C	8225544	67	2 5/8	3832-67	8558345
68	2 11/16	3830-68-VIP	8196530	3830-68-C	8228477	68	2 11/16	3832-68	8558352
70	2 3/4	3830-70-VIP	8041939	3830-70-C	8225551	70	2 3/4	3832-70	8558369
73	2 7/8	3830-73-VIP	8041946	3830-73-C	8228484	73	2 7/8	3832-73	8558383
76	3	3830-76-VIP	8041953	3830-76-C	8225568	76	3	3832-76	8558406
79	3 1/8	3830-79-VIP	8041960	3830-79-C	8228491	79	3 1/8	3832-79	8558420
83	3 1/4	3830-83-VIP	8041977	3830-83-C	8225575	83	3 1/4	3832-83	8558444
86	3 3/8	3830-86-VIP	8041984	3830-86-C	8228507	86	3 3/8	3832-86	8558468
89	3 1/2	3830-89-VIP	8041991	3830-89-C	8225582	89	3 1/2	3832-89	8558482
92	3 5/8	3830-92-VIP	8042004	3830-92-C	8225599	92	3 5/8	3832-92	8558505
95	3 3/4	3830-95-VIP	8042001	3830-95-C	8225605	95	3 3/4	3832-95	8558529
98	3 7/8	3830-98-VIP	8042028	3830-98-C	8228514	98	3 7/8	3832-98	8558543
102	4	3830-102-VIP	8042035	3830-102-C	8225612	102	4	3832-102	8558567
105	4 1/8	3830-105-VIP	8042042	3830-105-C	8225629	105	4 1/8	3832-105	8558581
108	4 1/4	3830-108-VIP	8042059	3830-108-C	8228521	108	4 1/4	3832-108	8558604
111	4 3/8	3830-111-VIP	8042066	3830-111-C	8228538	111	4 3/8	3832-111	8558611
114	4 1/2	3830-114-VIP	8042073	3830-114-C	8225636	114	4 1/2	3832-114	8558628
121	4 3/4	3830-121-VIP	8042080	3830-121-C	8225643	121	4 3/4	3832-121	8558642
127	5	3830-127-VIP	8042097	3830-127-C	8225650	127	5	3832-127	8558666
133	5 1/4	3830-133-VIP	8042103	3830-133-C	8228545	133	5 1/4	3832-133	8558673
140	5 1/2	3830-140-VIP	8042110	3830-140-C	8228552	140	5 1/2	3832-140	8558680
146	5 3/4	3830-146-VIP	8042127	3830-146-C	8228569	146	5 3/4	3832-146	8558697
152	6	3830-152-VIP	8042134	3830-152-C	8225667	152	6	3832-152	8558703
168	6 5/8	3830-168	8040659	-	-	168	6 5/8	-	-
177	7	3830-177-HIGH	8101329	-	-	177	7	-	-
210	8 1/4	3830-210	8040666	-	-	210	8 1/4	-	-

Arbors and accessories

Bahco have arbors with shanks for many different kinds of chucks. Select the type most suitable for your machine.

Power Driver arbor stabilises the sawing operation and distributes efficiently the cutting forces on the saw.

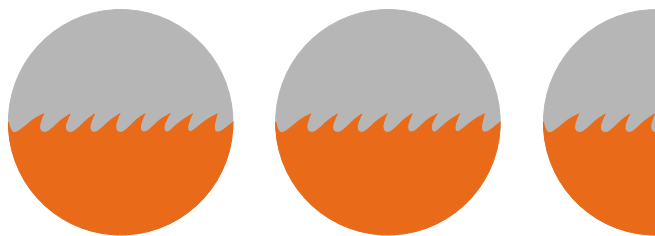


Product code	EAN code 731151+	Description
Arbors in cardboard packaging		
Arbors for Ø 14-30 mm		
3834-ARBR-630	8015558	Hexagonal shank 6.4 mm
3834-ARBR-730	8167974	Triangular shank 6.4 mm
3834-ARBR-930	8015565	Hexagonal shank 8.5 mm
3834-ARBR-1130	8015572	Hexagonal shank 11.1 mm
3834-ARBR-SD30	8203818	Shank for quick-change chucks (SDS)
Arbor for Ø 32-100 mm		
3834-ARBR-9100	8015589	Power Driver arbor with hexagonal shank 8.5 mm
3834-ARBR-9100QC	8249830	Quick-change arbor with hexagonal shank 8.5 mm.
Arbors for Ø 32-210 mm		
3834-ARBR-11152	8015596	Power Driver arbor with hexagonal shank 11.1 mm.
3834-ARBR-11152QC	8167967	Quick-change arbor with hexagonal shank 11.1 mm.
3834-ARBR-16152	8015602	Power Driver arbor with hexagonal shank 15.8 mm
3834-ARBR-SD152QC	8203825	Quick-change arbor with shank for quick-change chucks (SDS).
Arbors in display packaging		
Arbors for Ø 14-30 mm		
3834-ARBR-630-C	8228576	Hexagonal shank 6.4 mm
3834-ARBR-730-C	8225674	Triangular shank 6.4 mm
3834-ARBR-930-C	8225681	Hexagonal shank 8.5 mm
3834-ARBR-1130-C	8228583	Hexagonal shank 11.1 mm
Arbors for Ø 32-100 mm		
3834-ARBR-9100-C	8228590	Power Driver arbor with hexagonal shank 8.5 mm
3834-ARBR-9100QC-C	8225704	Quick-change arbor with hexagonal shank 8.5 mm.
Arbors for Ø 32-210 mm		
3834-ARBR-11152-C	8225698	Power Driver arbor with hexagonal shank 11.1 mm.
3834-ARBR-11152QC-C	8225711	Quick-change arbor with hexagonal shank 11.1 mm.
Accessories		
Adapter		
3834-ADP	8454425	Make small arbors fit larger holesaws (Max Ø 44 mm).
Drive plate		
3834-DP-75	8018061	For Ø 76-105 mm. Used at high feed forces. Increases stability.
3834-DP-100	8018054	For Ø 108-210 mm. Used at high feed forces. Increases stability.
Pilot drills		
3834-DRL	8234638	For accurate centering in thin and thick materials
3834-DRL-2-SS	8199371	For stainless steel
3834-DRL-CT	8953201	For drilling in abrasive materials (bricks, tile, etc)
Extensions		
3834-EXT-1	8040673	For arbors 1130, 11152, 11152QC. Hexagonal shank 11.1 mm. Length 330 mm
3834-EXT-2	8168070	For arbors 930, 9100. Hexagonal shank 8.5 mm. Length 330 mm
Morse taper		
3834-MRS-2	8015626	For arbors 1130, 11152, 11152QC
3834-MRS-3-11	8165130	For arbors 1130, 11152, 11152QC
3834-MRS-3	8015633	For arbor 16152
Ejector spring		
3834-ES	8454418	For pilot drills, to aid core removal

Holesaws sets

Bahco Sandflex® Bi-Metal

Containing the most popular sizes within the engineering, water and sanitation, HVAC (Heating, Ventilation, Air Condition) and electrical installation industry.



Our holesaw sets protect your holesaws and keep them in order.

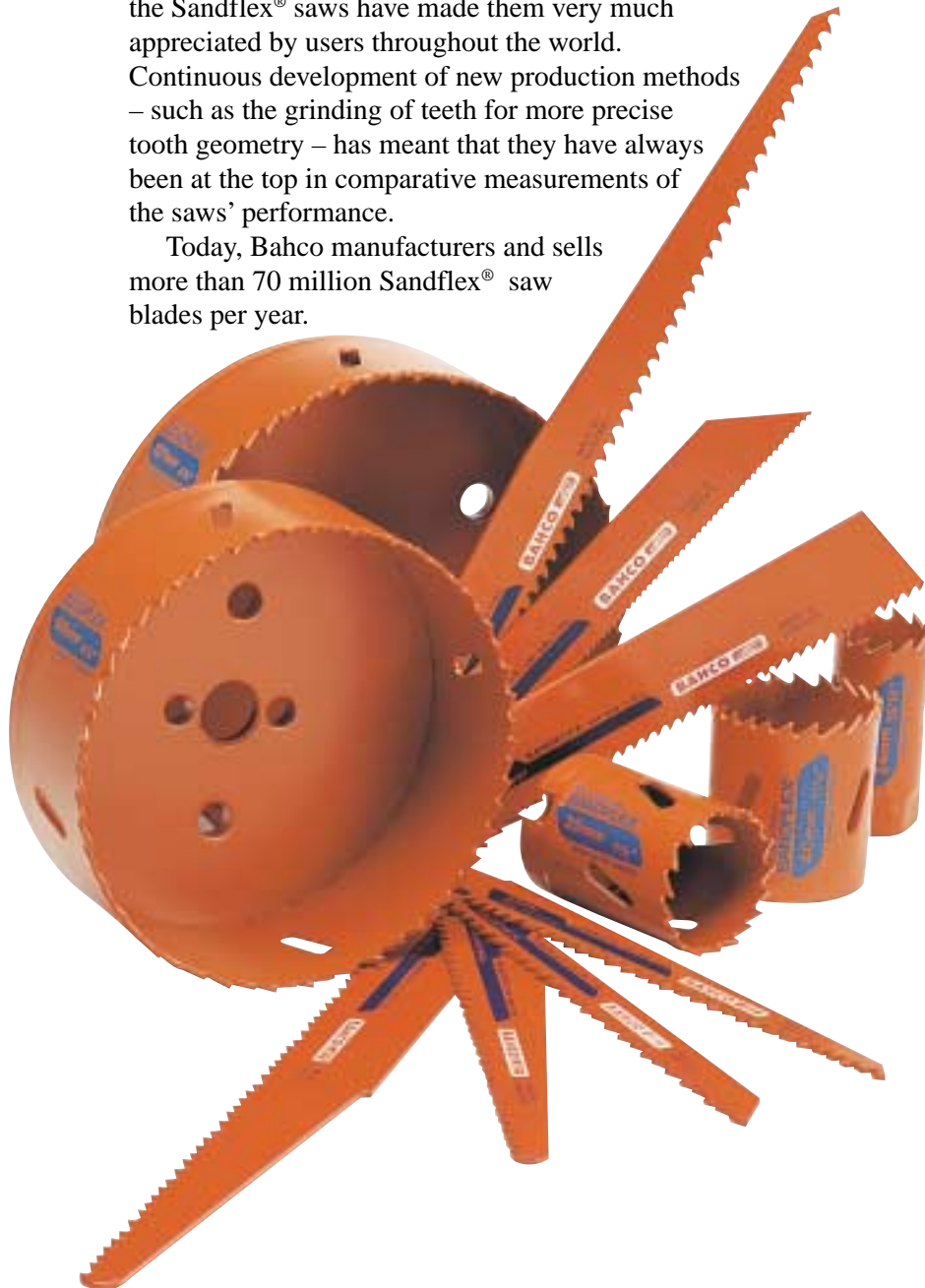
Product code	EAN code 731151+	Holesaws Ø mm	Arbors	Accessories included
3834-SET-65-16/51	8159900	16, 20, 25, 32, 40, 51	ARBR 1130, ARBR 11152	Pilot drill, Allen key, Chip brush
3834-SET-65-22/64	8159917	22, 29, 35, 44, 51, 64	ARBR 1130, ARBR 11152	Pilot drill, Allen key, Chip brush
3834-SET-72	8044992	19, 22, 29, 35, 44, 51, 64	ARBR 930, ARBR 9100	-
3834-SET-87	8181772	19, 22, 29, 38, 43, 48, 52, 65	ARBR 930, ARBR 9100	Pilot drill, Allen key, Chip brush, Ejector spring
3834-SET-92	8044985	16, 22, 25, 29, 32, 41, 51, 73, 83	ARBR 930, ARBR 9100	-
3834-SET-94	8166458	16, 19, 22, 25, 30, 35, 41, 51, 67	ARBR 1130, ARBR 11152	Allen key, Chip brush
3834-SET-95	8159894	16, 19, 22, 29, 35, 44, 52, 57, 64	ARBR 1130, ARBR 11152	Pilot drill, Allen key, Chip brush
3834-SET-42	8241988	51, 76, 86, 111	ARBR 9100	Ejector spring
3834-SET-62	8228040	19, 21, 22, 29, 38, 48	ARBR 930, ARBR 9100	-
3834-SET-86	8224295	25, 32, 35, 51, 54, 76, 92, 114	ARBR 1130, ARBR 11152	Pilot drill, Allen key, Adapter

Bahco Sandflex®

Metal saws for professionals around the world

The superior durability and unique performance of the Sandflex® saws have made them very much appreciated by users throughout the world. Continuous development of new production methods – such as the grinding of teeth for more precise tooth geometry – has meant that they have always been at the top in comparative measurements of the saws' performance.

Today, Bahco manufactures and sells more than 70 million Sandflex® saw blades per year.



www.bahco.com