

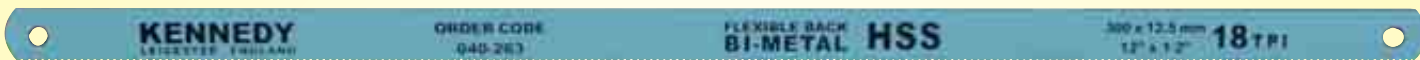
GROUP 040 HACKSAW & POWERSAW BLADES

KENNEDY Flexible Back Bi-metal Hacksaw Blades
QUALITY INDUSTRIAL TOOLING

The perfect combination of shatter resistant spring steel, used as the backing material, and tough, wear-resistant HSS teeth - Electron-beam welded together. Ideal for interrupted cuts in cramped places or where the blade is subject to stress caused by twisting or bending. Provides optimum tooth strength/life and reduced breakage and fracture when compared to traditional all-hard blades. **Made to BS 1919 : Part 1: 1993.**



CUTTING TOOLS



Improved re-usable packaging

Length	Width	Thickness	TPI	Weight per 100	Order Code KEN-040	Price/1 TB
10"	1/2"	.025	18T	1.50kg	-2130K	31.00
10"	1/2"	.025	24T	1.40kg	-2250K	31.00
10"	1/2"	.025	32T	1.40kg	-2320K	31.00
12"	1/2"	.025	14T	1.70kg	-2510K	31.00
12"	1/2"	.025	18T	1.70kg	-2630K	30.00
12"	1/2"	.025	24T	1.70kg	-2750K	30.00
12"	1/2"	.025	32T	1.70kg	-2870K	30.00

TPI Selection Guide

Group	Materials	Brinell Hardness HB	Rockwell Hardness HRC	Tensile Strength N/mm ²	Number of Teeth per Inch Section thickness or diameter		
					Below 2mm	2 - 5 mm	Above 5mm
1.1	Mild steel	<200	-	<700	32	24	18
1.4 to 1.5	Alloy steel & tool steel low to medium	<260	<26	<850	32	24	18 - 24
1.6	High alloy steel	>340	>36	>1200	32	24	24
2.1	Stainless steels	<290	<30	<1000	32	24	28
3.1	Grey cast iron	<300	-	-	24 - 32	18 - 24	18
6.1	Asbestos and copper	-	-	<500	24 - 32	18 - 24	18
6.3	Brass and bronze	-	-	<500	24 - 32	18 - 24	18
7.1	Aluminium	-	-	<500	24 - 32	18 - 24	18
8.1	Hard plastic	-	-	-	24 - 32	18 - 24	18

HSS All Hard Hacksaw Blades

Fully hardened for extra long tooth life and maximum straightness of cut. For use where workpiece is held securely in place. **Made to BS 1919 : Part 1: 1993.**



Improved re-usable packaging

Length	Width	Thickness	TPI	Weight per 100	Order Code KEN-040	Price/1 TB
10"	1/2"	.025	18T	1.40kg	-3130K	30.00
10"	1/2"	.025	24T	1.40kg	-3250K	30.00
12"	1/2"	.025	14T	1.70kg	-3510K	30.00
12"	1/2"	.025	18T	1.70kg	-3630K	30.00
12"	1/2"	.025	24T	1.70kg	-3750K	30.00
12"	1/2"	.025	32T	1.70kg	-3870K	30.00

Industrial Saw Blades

Junior Hand Saw Blades

Designed for use across a wide range of ferrous and non-ferrous materials. Suitable for mini hand saws and junior hacksaws. **Made to BS 6271 : 1990.**

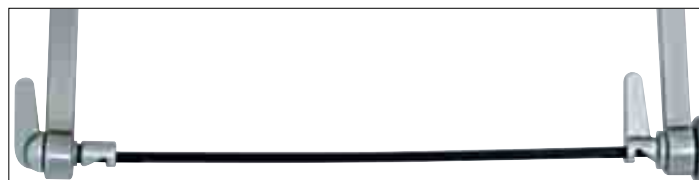


Type	Length	TPI	Weight per 100	Order Code KEN-040	Price TB
Metal Pack 10	150mm (6")	32	420g	-0620K	55.00/10
Wood	150mm (6")	14	390g	-0640K	10.00/1



Coping Saw Blades

For cutting and shaping in wood. Supplied in packs of 10.



Length	TPI	Weight per 100	Order Code KEN-040	Price/10 TB
150mm (6")	14	250g	-1020K	125.00

KENNEDY Industrial Power / Machine Saw Blades

Designed for use across a wide range of ferrous and non-ferrous materials.

Power Saw Blade Selection

Power Saw Hacksaw Blade Tooth Recommendations

TPI	Suitable for Section Width
18	up to 13mm (up to 1/2")
14	6 to 19mm (1/4" to 3/4")
10	8 to 25mm (5/16" to 1)
6	13 to 38mm (1/2" to 1 1/2")
4	19mm and above (3/4" and above)

Type of Machine	Coolant Required	Unannealed Tool Steel & Hard Metals	Annealed Tool Steel	Machinery Steel & Soft Metal
Light	No	40spm	50 - 60spm	50-60spm
Medium	No	40spm	50 - 60spm	50-60spm
Medium	Yes	60spm	60 - 90spm	100-110spm
Heavy	Yes	60spm	90spm	110-120spm
Ex. Heavy	Yes	60spm	90spm	110-120spm

18 Teeth Per Inch

Recommended for cutting thin cross-sections such as tubing, small bars and light angle iron. Because blades are relatively thin they should be used only on light machines.

10 - 14 Teeth Per Inch

Recommended for cutting small cross sections and hard stock. This is the most popular choice for machine shops that are cutting a wide variety of materials.

4 - 6 Teeth Per Inch

Recommended for cutting large sections of softer ferrous metals, most alloy steels and all non-ferrous metals. The increased gullet clearance is able to handle heavy chips without clogging.

Operating Recommendations

Lower speeds and higher feed give best results. Ensure that the machine lifts the blade slightly on the return stroke. Exact speed and feed for each job can be established only from tests. The table below is to be used for guidance only.

When matching a section thickness against a suitable Blade TPI there are usually a number of blade options - Use coarse pitches (less TPI) for faster cutting and finer pitches (more TPI) for better surface finishes.

HSS All Hard Power Saw Blades

Recommended for cutting thin cross-sections such as tubing, small bars and light angle iron. Because blades are relatively thin they should be used only on light machines.

Power Saw Hacksaw Blade Tooth Recommendations



Length	Width	Thickness	TPI	Weight per 10	Order Code KEN-040	Price/1 TB
12"	5/8"	.032"	18T	0.36kg	-4630K	90.00
12"	1"	.050"	10T	0.78kg	-5030K	240.00
12"	1"	.050"	14T	0.79kg	-5040K	240.00
14"	1"	.050"	10T	0.93kg	-5130K	250.00
14"	1"	.050"	14T	0.80kg	-5140K	250.00
14"	1 1/4"	.062"	6T	1.30kg	-5200K	350.00
14"	1 1/4"	.062"	10T	1.30kg	-5220K	350.00
14"	1 1/4"	.062"	14T	1.30kg	-5230K	350.00
16"	1 1/4"	.062"	6T	1.40kg	-5390K	380.00
16"	1 1/4"	.062"	10T	0.90kg	-5410K	380.00
16"	1 1/4"	.062"	14T	1.60kg	-5420K	380.00
16"	1 1/2"	.062"	4T	2.20kg	-5490K	480.00
16"	1 1/2"	.062"	6T	2.20kg	-5500K	480.00
17"	1 1/4"	.062"	10T	1.80kg	-5530K	550.00
18"	1 1/4"	.062"	6T	1.90kg	-5550K	560.00
18"	1 1/4"	.062"	10T	1.60kg	-5570K	560.00
18"	1 1/2"	.075"	6T	2.55kg	-5650K	550.00
19"	1 3/4"	.088"	6T	3.80kg	-5720K	950.00
20"	1 1/2"	.075"	6T	3.20kg	-5750K	1100.00
21"	1 1/2"	.075"	6T	3.00kg	-5770K	1200.00
21"	1 1/2"	.075"	10T	3.00kg	-5790K	1300.00
21"	1 3/4"	.088"	6T	5.30kg	-5820K	1350.00
24"	2"	.100"	6T	6.30kg	-5960K	1500.00

Speeds & Feeds - Recommended speeds, strokes per minute and TPI.

Group	Materials	Brinell Hardness HB	Rockwell Hardness HRC	Tensile Strength N/mm ²	Cutting Speed m/min	Strokes Per Min	Section Thickness or diameter-Recommended TPI			
							Below 10mm	10-40 mm	40-80 mm	Above 80mm
1.1 to 1.2	General purpose steels mild and structural	<200	-	<700	25 - 35	70 - 90	14	10 - 6	6 - 4	4
1.3	Non-alloy, plain and medium carbon steels and castings	<260	<26	<850	20 - 30	50 - 70	14	10 - 6	6 - 4	4 - 3
1.4	Alloy steels generally low to medium steels and castings	<260	<26	<850	20 - 30	50 - 70	14	10 - 6	6 - 4	4 - 3
1.5	Medium to high alloy steels tool steels and steel castings	>260 <340	>26 <36	>850 <1200	18 - 28	40 - 60	14	10 - 6	6 - 4	4 - 3
1.6	Heat treated high alloy steels and castings	>340 <450	>36 <48	>1200 <1500	15 - 25	30 - 45	14	10 - 6	6 - 4	4 - 3
2.1 to 2.3	Stainless steels free machine and austenitic	<290	<30	<1000	10 - 25	40 - 60	14	10 - 6	6 - 4	4 - 3
3.1 to 3.2	Grey cast iron	<300	-	-	30 - 40	70 - 90	14	10 - 6	6 - 4	4 - 3
3.3 to 3.4	S.G. iron nodular and malleable	<300	-	-	30 - 40	70 - 90	14	10 - 6	6 - 4	4 - 3
6.1 to 6.3	Non ferrous metals brass, copper and bronze	-	-	<800	40 - 60	80 - 115	14	10 - 6	6 - 4	4 - 3
7.1 to 7.4	Aluminium alloys to zinc and magnesium	-	-	<50	40 - 60	80 - 115	14 - 10	10 - 6	6 - 4	4 - 3