















2023 SAW BLADE GUIDE

www.klingspor.com
800-645-5555

TABLE OF CONTENTS

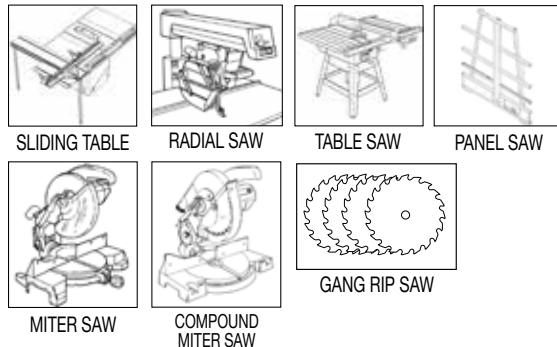
	RIPPING	4
	GLUE LINE RIPPING	4
	COMBINATION	5
	GENERAL PURPOSE	5
	GENERAL PURPOSE / CUT OFF	6
	ADJUSTABLE SCORING SET	6
	DOUBLE-SIDED MELAMINE / LAMINATE	7
	FINE TRIM & CROSSCUT	8
	HEAVY DUTY MITER / DOUBLE MITER	8
	SOLID SURFACE	9
	PLASTIC CUTTING	9
	NON-FERROUS (THIN WALL ALUMINUM)	10
	NON-FERROUS (THICK WALL ALUMINUM)	10
	REFERENCE	7 & 11

KLINGSPOR QUALITY

The combination of our high quality micro grain carbide, application based tooth geometry and our precision ground and balanced steel plates is what makes KLINGSPOR industrial carbide tipped saw blades superior in just about any market. Our blades are laser cut from virgin German steel and precision flattened, ground and tensioned, providing extremely tight tolerances and incredible performance.

Components include:

- **Heavy duty precision flattened saw plate**
- **Laser cut plate, bore and expansion slots**
- **Large carbide tips for numerous sharpening's**
- **Tri-foil brazing**
- **High quality micro grain carbide for incredible sharpness and durability**

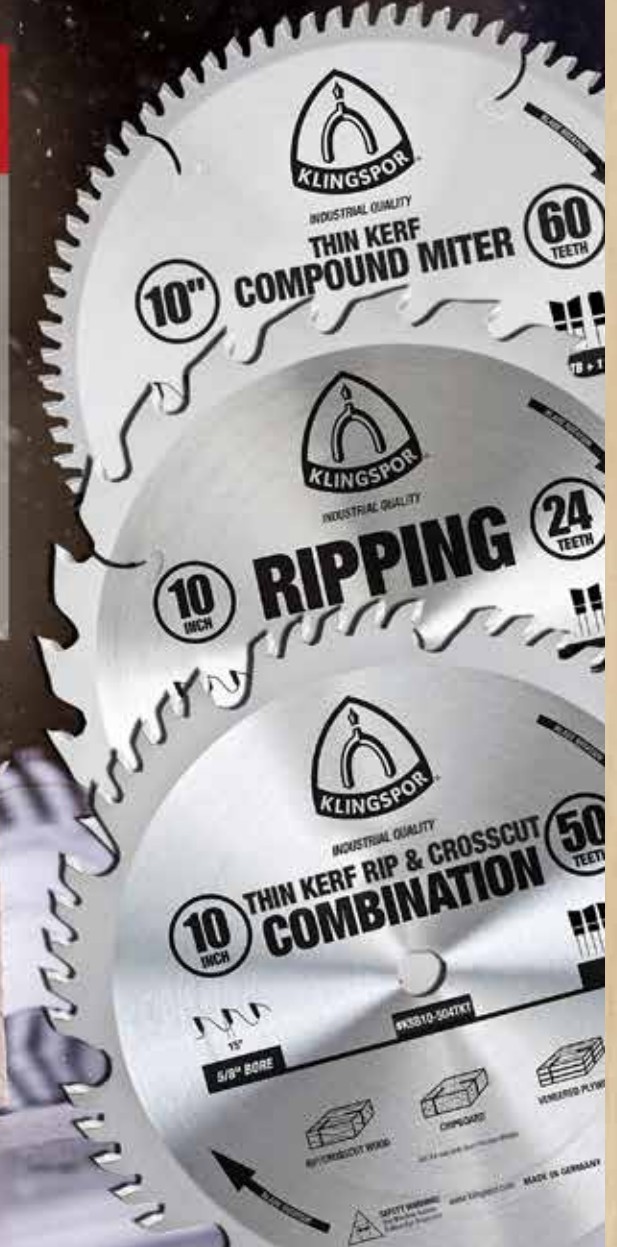


KLINGSPOR's Thin Kerf Blades!

Same great quality now offered in Thin Kerf

Benefits of a thin kerf:

- Remove Less Material
- Create Less Resistance and Friction
- Make Cuts Faster
- Reducing Power Drain



KLINGSPOR

The Most Sanding Power for Your Money Since 1893!



2555 Tate Boulevard, S.E.
PO Box 2367, Hickory
North Carolina 28603-2367

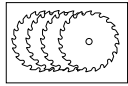
Call or email to purchase today! 800-645-5555 • orders@klingspor.com



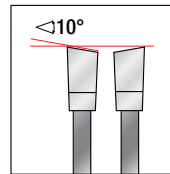
RIPPING



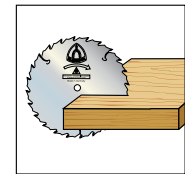
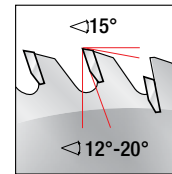
TABLE SAW



GANG RIP SAW



ATB GRIND
MODERATE ANGLE



SOFT & HARDWOOD
RIPPING



This blade is specifically designed for efficient, smooth ripping. The low tooth count and large gullets combine to make this blade fast and aggressive. This is suitable for use in table saws or gang-rip saws.

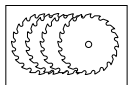
Dia.	Teeth	Kerf		Plate		Hook Angle	Bore	Pin-Hole	Tool No.
		MM	Inch	MM	Inch				
10"	24	3.2	.126	2.2	.087	20°	5/8"	—	KSB10-240
10"	24	2.38	.094	1.8	.071	20°	5/8"	—	KSB10-240TKT

! WARNING: Not recommended for cutting non-ferrous alloys, plastic, laminate and melamine.

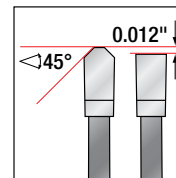
GLUE LINE RIPPING



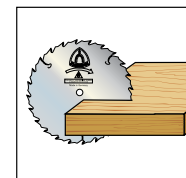
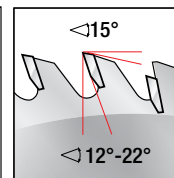
TABLE SAW



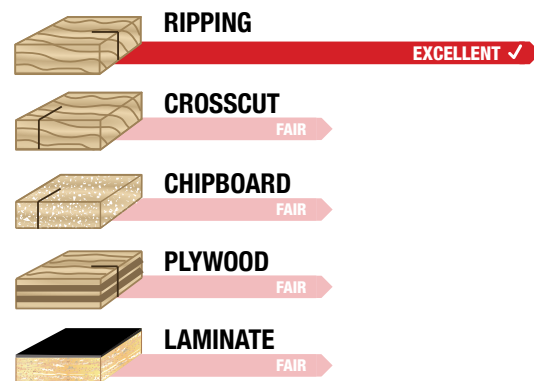
GANG RIP SAW



TC GRIND



SOFT & HARDWOOD
RIPPING



This special glue line blade shears the wood cleanly so there is no need to joint the stock prior to gluing. The precision triple-chip grind & extra-high hook angle allow aggressive feed rates, yet produce an extra-smooth cut finish. The thick plate and laser cut expansion slots minimize vibration. Use on table saws, sliding table saws, single and gang-rip operations.

Dia.	Teeth	Kerf		Plate		Hook Angle	Bore	Pin-Hole	Tool No.
		MM	Inch	MM	Inch				
10"	32	3.7	.145	2.5	.098	12°	5/8"	—	KSB10-301

! WARNING: Not recommended for cutting non-ferrous alloys, plastic and melamine.

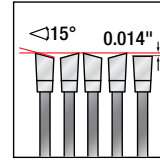
COMBINATION



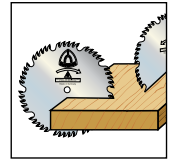
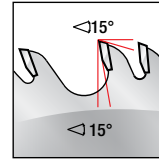
TABLE SAW



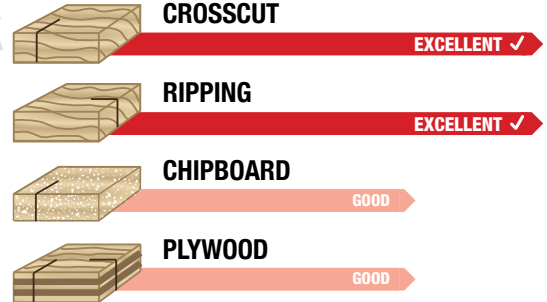
SLIDING TABLE



COMB 4+1 GRIND
FOUR ATB FOLLOWED BY ONE RAKER, THEN AN "OPEN" GULLET FOR CHIP CLEARANCE



COMBINATION RIP & CROSSCUT



In many woodworking shops one blade must cut a wide variety of materials. This blade will effectively rip and crosscut hardwoods, softwoods, as well as sheet stock such as plywood and particleboard. It features the time-tested combination blade design - four alternate top bevel teeth with a flat-top raker. This is the best blade for all-purpose cutting.

Dia.	Teeth	Kerf		Plate		Hook Angle	Bore	Pin-Hole	Tool No.
		MM	Inch	MM	Inch				
10"	50	3.2	.126	2.2	.087	15°	5/8"	—	KSB10-500
10"	50	2.38	.094	1.8	.071	15°	5/8"	—	KSB10-504TKT

WARNING: Not recommended for cutting non-ferrous alloys.

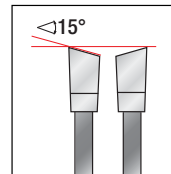
GENERAL PURPOSE



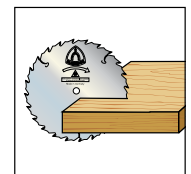
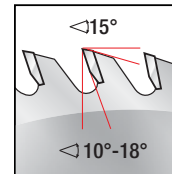
TABLE SAW



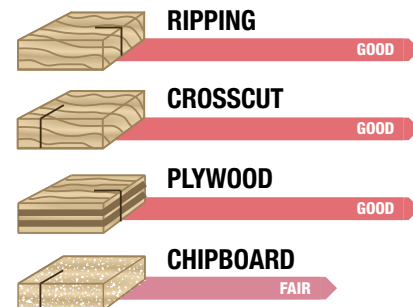
SLIDING TABLE



ATB GRIND
MODERATE ANGLE



SOFT & HARDWOOD
CROSSCUT

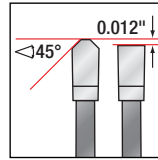


In some cases, a customer doesn't want to change blades from ripping to crosscutting to rough cutting in a variety of materials. A good general purpose blade usually fits the bill, as it works pretty well on different materials and applications.

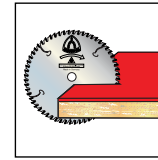
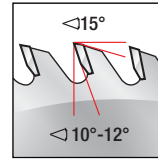
Dia.	Teeth	Kerf		Plate		Hook Angle	Bore	Pin-Hole	Tool No.
		MM	Inch	MM	Inch				
10"	40	3.2	.126	2.2	.087	15°	5/8"	—	KSB10-400

WARNING: Not recommended for cutting non-ferrous alloys, plastic and melamine.

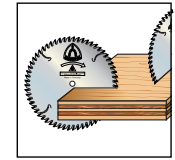
PLYWOOD / LAMINATE CUTOFF








TC GRIND
FOLLOWED BY FLAT RAKER



PLASTIC LAMINATE
SINGLE SIDED



PLYWOOD

-  **LAMINATE (Single Sided)** EXCELLENT ✓
-  **MDF** EXCELLENT ✓
-  **CHIPBOARD** EXCELLENT ✓
-  **PLYWOOD** GOOD
-  **CROSSCUT** FAIR

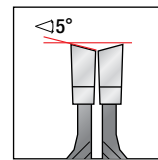
These blades are specifically designed for clean cuts in single-sided plywood laminates. The greater number of teeth, triple-chip grind and 10°-12° hook angle provide an excellent balance between feed resistance and finish. This leaves a clean finish on the top side of the plywood or plastic laminate materials. Some table saws require special scoring blades (KSB120-T14 see below) in conjunction with the KSB12-721-30 below to accomplish clean cuts on double sided laminates.

Dia.	Teeth	Kerf		Plate		Hook Angle	Bore	Pin-Hole	Tool No.
		MM	Inch	MM	Inch				
10"	60	3.2	.126	2.2	.087	12°	5/8"	—	KSB10-601
10"	80	3.2	.126	2.2	.087	10°	5/8"	—	KSB10-801
12"	72	3.2	.126	2.2	.087	12°	1"	—	KSB12-721
300mm	72	3.2	.126	2.2	.087	10°	30mm	✦	KSB12-721-30

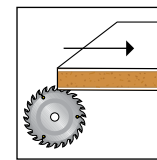
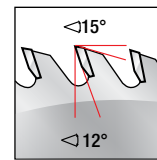
✦ 30mm bore accepts pin-hole arrangements of: 2/10/60, 2/7/42 & 2/9/46.

WARNING: Not recommended for cutting non-ferrous alloys and melamine.

ADJUSTABLE SCORING SETS



ATB GRIND
MODERATE ANGLE



SCORING PARTICLE
BOARD & DOUBLE
SIDED MDF LAMINATE

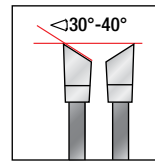
-  **DOUBLE-SIDED MELAMINE** EXCELLENT ✓
-  **PLASTIC LAMINATE** EXCELLENT ✓

Used on panel saws and sliding table saws (ex. SCM, & Altendorf), with separate scoring units for chip-free cuts on both sides of the material. Adjustable scoring sets consist of two 12-tooth saw blades with shims to adjust the kerf width (2.8mm to 3.6mm). These are used in combination with our plywood/ laminate series Triple chip blade above.

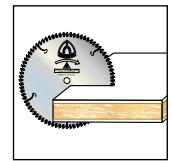
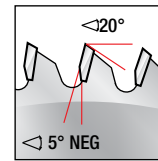
Dia.	Teeth	Kerf		Plate		Hook Angle	Bore	Pin-Hole	Tool No.
		MM	Inch	MM	Inch				
120mm	12x2	2.8-3.6	.110-.144	2.2(x2)	.087(x2)	12°	22mm	—	KSB120-T14

WARNING: Not recommended for cutting non-ferrous alloys.

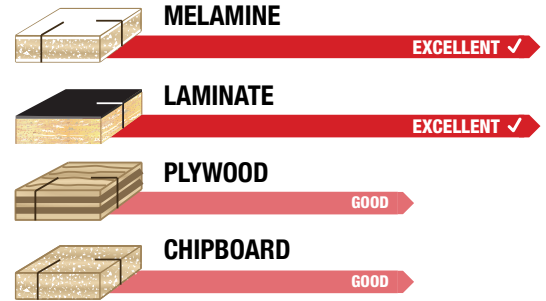
DOUBLE-SIDED MELAMINE



H-ATB GRIND
HIGH OR ACUTE ANGLE ALTERNATIVE
TOP BEVEL



MELAMINE SINGLE &
DOUBLE SIDED



This blade is designed for smooth crosscuts in a variety of materials from hardwoods, softwoods and sheet stock including chipboard. Not intended for sliding miter or radial arm saw applications.

Dia.	Teeth	Kerf		Plate		Hook Angle	Bore	Pin-Hole	Tool No.
		MM	Inch	MM	Inch				
10"	80	3.2	.126	2.2	.087	-5°	5/8"	—	KSB10-803
12"	96	3.2	.126	2.5	.100	-5°	1"	—	KSB12-963

WARNING: Not recommended for cutting non-ferrous alloys.

TERMINOLOGY

- Blow out:** A condition in which the saw blade blows out the grain of a workpiece.
- Chipping:** A condition that occurs when the saw blade lifts and tears the wood fibers as it exits the material.
- Crosscutting:** Cutting wood against the grain.
- Cut off:** Cutting a piece to length (Same as Crosscut)
- Hook Angles:** The amount of forward or backward lean each tooth has. The angle is measured by the intersection of two imaginary lines. The first line is drawn flush with the face of the tooth, the second line is drawn vertically through the center of the arbor hole.
- Kerf:** The width of the cut made when the blade passed through the material, determined by the width of the tooth.
- Miter:** A finish cut made at an angle.
- Negative Hook Angle:** The negative face of the tooth is much less likely to cause chipping in the surface of the material because it is oriented in a counter-rotation direction. This will prevent self feeding.
- Non-Ferrous:** Any metal not containing iron.
- Positive Hook Angle:** The higher the hook angle, the more aggressive the blade will cut the material. This is great for getting through a lot of material fast.
- Ripping:** Cutting wood in the same direction as the grain.
- Run out:** The amount of wobble in a saw blade, also known as warp.
- Thick Wall:** Cutting a non ferrous metal over 1/4" thick
- Thin Wall:** Cutting a non ferrous metal under 1/4" thick

FINE TRIM & CROSSCUT

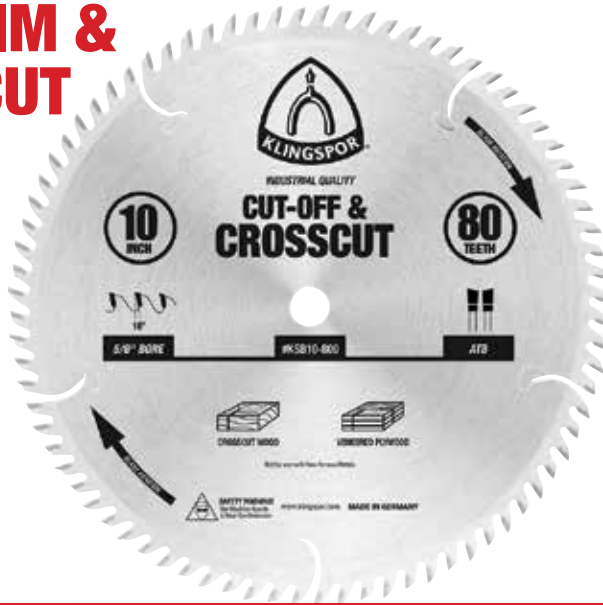
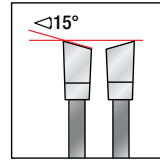


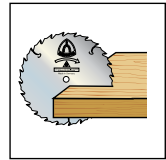
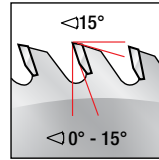
TABLE SAW



MITER SAW



ATB GRIND
MODERATE ANGLE



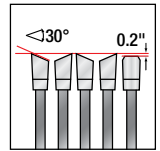
SOFT & HARDWOOD
PLYWOOD



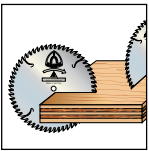
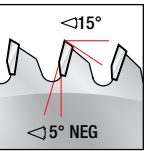
Dia.	Teeth	Kerf		Plate		Hook Angle	Bore	Pin-Hole	Tool No.
		MM	Inch	MM	Inch				
10"	80	3.2	.126	2.2	.087	10°	5/8"	—	KSB10-800
12"	96	3.2	.126	2.2	.087	10°	1"	—	KSB12-960

WARNING: Not recommended for cutting non-ferrous alloys, plastic, laminate and melamine.

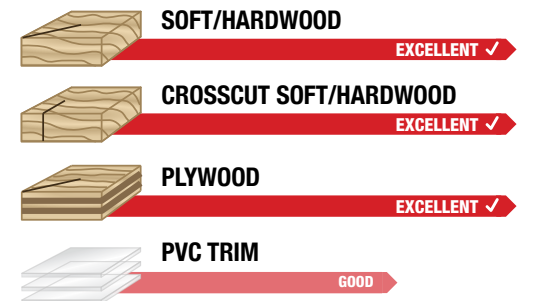
HEAVY-DUTY MITER/DOUBLE MITER



4 H-ATB + 1 TCG GRIND
FOUR HIGH ALTERNATE TOP BEVEL
FOLLOWED BY ONE TRIPLE CHIP GRIND



MITER



WARNING: Not recommended for cutting non-ferrous alloys.



COMPOUND
MITER SAW



MITER SAW



RADIAL SAW

The KLINGSPOR Heavy-Duty Single/Double Miter blades were designed especially for glass smooth compound miters cuts in moldings or picture frame stock for use in a miter box, radial arm, and single/double miter saws. This style blade is the perfect choice for picture frame and millwork shops.

Dia.	Teeth	Kerf		Plate		Hook Angle	Bore	Pin-Hole	Tool No.
		MM	Inch	MM	Inch				
10"	80	3.0	.118	2.5	.098	-5°	5/8"	—	KSB10-806
12"	100	3.0	.118	2.5	.098	-5°	1"	—	KSB12-106
10"	60	2.4	.094	1.8	.071	-5°	5/8"	—	KSB10-606TKT
10"	80	2.3	.090	1.8	.071	0°	5/8"	—	KSB10-816TKT
12"	72	2.4	.094	1.8	.071	-3°	1"	—	KSB12-726TKT



SOLID SURFACE



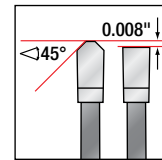
RADIAL SAW



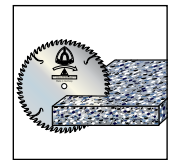
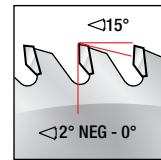
TABLE SAW



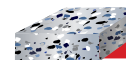
SLIDING TABLE



M-TC GRIND



SOLID SURFACE

-  **SOLID SURFACE** EXCELLENT ✓
-  **PLEXIGLAS®/VINYL** EXCELLENT ✓
-  **LAMINATE** GOOD

This blade is specifically designed for cutting plastic laminate, Plexiglas®, and solid surface materials such as Avonite®, Dupont Corian®, Wilsonart®, Gibraltar®, Earthstone® Fountainhead®, Surrell®, Staron® and other acrylic based materials. The triple chip grind is especially configured to leave a swirl-free cut in solid surface materials. The thick, stable plate reduces vibration that degrades the cut and shortens tool life. The blade is suitable for a variety of saw configurations and its 0° hook angle virtually eliminates self-feeding when it is used with a radial arm saw.

Dia.	Teeth	Kerf	Plate	Hook	Bore	Pin-Hole	Tool No.
MM	Inch	MM	Inch	Angle			
10"	72	3.2	.126	0°	5/8"	—	KSB10-728

WARNING: Not recommended for cutting non-ferrous alloys.

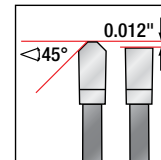
PLASTIC



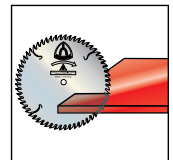
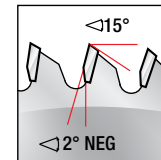
TABLE SAW






SLIDING TABLE



M-TC GRIND



PLASTIC

-  **PLASTIC** EXCELLENT ✓
-  **THIN-WALLED PHENOLIC & HARD PLASTIC** EXCELLENT ✓
-  **LAMINATE** GOOD

Designed for smooth, chip-free cutting of plastics, these blades have a higher tooth count and will work fantastic in thinner material. They are also suitable for crosscutting, trimming, and mitering wood and work well for plywood and laminate cutting.

Dia.	Teeth	Kerf	Plate	Hook	Bore	Pin-Hole	Tool No.
MM	Inch	MM	Inch	Angle			
10"	80	2.5	.098	-2°	5/8"	—	KSB10-802

WARNING: Not recommended for cutting non-ferrous alloys.

NON-FERROUS FOR THIN WALLED ALUMINUM



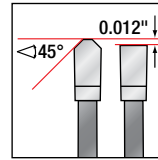
TABLE SAW



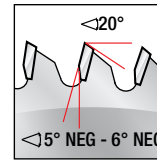
RADIAL SAW



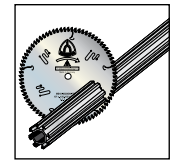
MITER SAW

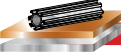
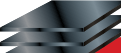
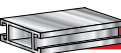



TC GRIND



NON-FERROUS ALLOYS



-  **NON-FERROUS ALLOYS** EXCELLENT ✓
-  **THIN-WALLED PHENOLIC & HARD PLASTIC** EXCELLENT ✓
-  **ALUMINUM** EXCELLENT ✓
-  **BRASS/COPPER** EXCELLENT ✓

Designed specifically for cutting relatively thin-walled aluminum and non-ferrous extrusions and frames on table or miter saw applications. Use a coolant or blade wax and clamp down the work piece when cutting non-ferrous metals. (<1/4")

Dia.	Teeth	Kerf	Plate	Hook	Bore	Max RPMs	Tool No.		
MM	Inch	MM	Inch	Angle					
10"	80	3.2	.126	2.5	.098	-5°	5/8"	7,600	KSB10-805
12"	100	3.2	.126	2.5	.098	-5°	1"	6,200	KSB12-105

! WARNING: Never attempt to cut ferrous metals (steel, iron, etc.) with these blades.

NON-FERROUS FOR THICK WALLED ALUMINUM



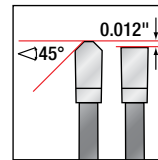
TABLE SAW



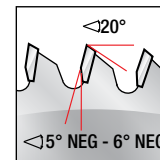
RADIAL SAW



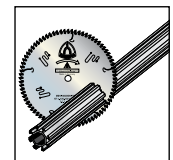
MITER SAW

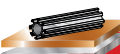





TC GRIND



NON-FERROUS ALLOYS



-  **NON-FERROUS ALLOYS** EXCELLENT ✓
-  **THIN-WALLED PHENOLIC & HARD PLASTIC** EXCELLENT ✓
-  **ALUMINUM** EXCELLENT ✓
-  **BRASS/COPPER** EXCELLENT ✓

The special carbide formulation and blade geometry makes this blade ideal for cutting aluminum and non-ferrous metal bars such as copper, brass, bronze and lead. They are also, good for cutting relatively thick-walled extrusions and profiles. The negative hook angle, triple-chip grind and thick plate combine to produce a superior finish. Use a coolant or blade wax and clamp down the work piece when cutting non-ferrous metals. The blade can be used to cut other "difficult" materials such as plastic, PVC tubing and fiberglass on table or miter saw applications. (<1/4")

Dia.	Teeth	Kerf	Plate	Hook	Bore	Max RPMs	Tool No.		
MM	Inch	MM	Inch	Angle					
10"	60	3.2	.126	2.5	.098	-6°	5/8"	7,600	KSB10-605

! WARNING: Never attempt to cut ferrous metals (steel, iron, etc.) with these blades.



SAW BLADE APPLICATION GUIDE

SOLID WOOD:

- RIP:** KSB10-240 – More aggressive, faster & leaves a rougher cut
KSB10-301 – Less aggressive and better edge finish
KSB10-240TKT – Thin Kerf
- Crosscut:** KSB10-800 / KSB12-960 (For use on a table saw)
KSB10-500
KSB10-806 / KSB12-106 (For use on Miter saws, sliding miter saws & Radial Arm)
- Combo** (Rip & crosscut wood, plywood, chipboard):
KSB10-500 Better overall results on solid wood
KSB10-400 More aggressive and faster for rough cutting in wood
KSB10-504TKT – Thin Kerf

PLYWOOD:

- KSB10-601 (Single-sided only – may chip on the back side)
KSB10-801 (same blade, but with more teeth – 80 vs 60)
KSB12-721 & 721-30 (Single-sided only – may chip the back side)
KSB10-800 (Different tooth configuration – ATB – and better for double-sided & prefinished plywood applications).
Also good for crosscutting solid wood.

LAMINATE (single sided):

- KSB10-728 Solid surface blade
KSB10-802 Plastic blade
KSB10-803 / KSB12-963 Melamine blade

MDF/Chipboard:

- KSB10-801 Plywood/Laminate
KSB10-803 / KSB12-963 Melamine blade

MELAMINE:

- KSB10-803 / KSB12-963

PLASTIC:

- KSB10-802 (Phenolic & hard plastics)
KSB10-728 (Plexiglass)
KSB10-805 / KSB12-105 (Phenolic, Hard plastics & aluminum)

NON-FERROUS (Brass, copper, aluminum, etc.):

- KSB10-805 / KSB12-105 (Thin wall – less than 1/4")
KSB10-605 (Thick wall - greater than 1/4")

MITER CUTS:

- KSB10-806 10" Miter Blade
KSB12-106 12" Miter Blade
KSB10-816TKT 12" Thin Kerf Miter
KSB10-606TKT 10" Thin Kerf Sliding Miter
KSB12-726TKT 12" Thin Kerf Sliding Miter

KLINGSPOR GUARANTEE & WARRANTY: KLINGSPOR warrants to the original purchaser at retail that each new saw blade shall be free from defects in material and workmanship. Upon verification of failure or malfunction, KLINGSPOR shall, at its option, within forty five (45) days of purchase, replace the saw blade, subject to the Guidelines below. • In the event of failure or malfunction, return the product, properly packaged and postage prepaid, to KLINGSPOR. Please call KLINGSPOR at 800 645-5555. • KLINGSPOR assumes no liability for defects or damage caused by abuse or misuse of any product or unauthorized service of any product. The product must have been used for its recommended purpose and not modified by sharpening or other changes. Normal wear and tear is not covered under KLINGSPOR warranties.



2555 Tate Boulevard, S.E.
PO Box 2367
Hickory, North Carolina 28603-2367
Toll Free 800-645-5555
Corporate 828-322-3030
Toll Free Fax 800-524-6758
Fax 828-326-0296
www.klingspor.com

PUB230515SBG

