Freud’s Industrial Series of blades are designed for the serious woodworker. Available in a variety of styles for different applications, LU and LM blades feature thick carbide tips, precision-tensioned bodies and other premium features found in every Freud blade. Industrial blades include red Perma-SHIELD® coating or Silver I.C.E.™ coating to help reduce friction, heat build-up and gumming, which add up to longer blade life.
## Guide to Choosing a Blade

### Non-Ferrous Cutting
- **Description**: Thin Stock Non-Ferrous
- **Material Thickness**: MAX 1/4" MAX
- **Material Type**: Copper, Brass, Aluminum
- **Application**: Long life & Bar-true cuts in thick stock non-ferrous metals
- **Tooth Count**: 72T/80T
- **Tooth Design**: Triple Chip Grind
- **Hook Angle**: Full Carbide -7° -5°
- **Catalog Section**: Specialty Blades Pages 44 to 46
- **Blade Use**: Perma-SHEILD Full KERF Silver I.C.E.
- **Blade Use**: Thin KERF Silver I.C.E.

### Ripping
- **Description**: Thin Stock Non-Ferrous
- **Material Thickness**: MAX 1/4" MAX
- **Material Type**: Copper, Brass, Aluminum
- **Application**: Long life & Bar-true cuts in thick stock non-ferrous metals
- **Tooth Count**: 100T
- **Tooth Design**: Triple Chip Grind
- **Hook Angle**: Full Carbide 5°
- **Catalog Section**: Specialty Blades Pages 44 to 46
- **Blade Use**: Perma-SHEILD Full KERF Silver I.C.E.

### Ripping & Crosscutting
- **Description**: General Purpose Life & Finish
- **Material Thickness**: M 1/4" M A
- **Material Type**: Hardwoods, Softwoods, Veneered Plywoods
- **Application**: Glue line rips with material 1/4" to 2-1/4" thick
- **Tooth Count**: 24T
- **Tooth Design**: Flat Top Grind
- **Hook Angle**: Full Carbide 20°
- **Catalog Section**: Ripping Blades Pages 40 to 43

### Crosscutting
- **Description**: Combination
- **Material Thickness**: M 1/4" M A
- **Material Type**: Hardwoods, Softwoods, Veneered Plywoods
- **Application**: The blade that does it all - Crosscutting & Ripping
- **Tooth Count**: 30T
- **Tooth Design**: Fusion Grind
- **Hook Angle**: Full Carbide 12°
- **Catalog Section**: Ripping Blades Pages 42 to 43

### Use This Blade

**Impact Resistant**
Special carbide blend able to withstand extreme impact when cutting.

**Increasing Impact Strength**
- **Non-Ferrous TiCo® Hi-Density Carbide Blend**
  - High Cobalt content - allowing the carbide to withstand impact when cutting non-ferrous metals.
- **Ripping TiCo® Hi-Density Carbide Blend**
  - Medium Cobalt content - allowing the carbide to withstand the impact demands when ripping.
- **General Purpose TiCo® Hi-Density Carbide Blend**
  - A perfect blend of cobalt, titanium and tungsten - both impact resistant and hard carbide for general purpose applications.
- **Combination TiCo® Hi-Density Carbide Blend**
  - A little less Cobalt content and more Hi-Density tungsten carbide - allowing the carbide to keep an edge longer in combination applications.
- **Crosscutting TiCo® Hi-Density Carbide Blend**
  - More Hi-Density tungsten carbide content making the carbide very hard - allowing the carbide to maintain a sharp cutting edge in crosscut applications.

### More Work...

- **Freud-Made TiCo® Carbide**
  - Freud uses extremely dense, ultra-fine carbide grains (up to 40% smaller) giving more actual carbide per tooth for a sharper edge and longer life.

- **Laser Cut High Strength Steel**
  - Ensures stable, flat, true blades even after years of use.

- **Pretensioned Ring**
  - Balances the centrifugal & thermal forces on the blade for truer cuts under load.

- **Oversized Carbide Teeth**
  - 50-60% larger than standard carbide teeth for up to 4 times more sharpenings.
## 10" SAW BLADE

### Crosscutting
- **Ultimate Cut Off Blade**
- **Ultra Finish To Plywood, Wocs & Melamine**
- **Thick Stock Laminates/Melamine**
- **Single Sided Laminates/Melamine**
- **Double Sided Laminates/Melamine**

### Laminates / Melamine
- **Glass Smooth Finish**
- **Chip-free & Splinter-free cuts**

### Chipboard
- **80T**
- **80T**
- **60T**
- **80T**
- **40T**
- **72T**

### Plastics
- **ATB Grind**
- **High ATB Grind**
- **10°**
- **2°**

### Solid Surface
- **Scale**
- **Increasing Hardness**

### Description
- **Material Thickness**
- **Material Type**
- **Application**
- **Tooth Count**
- **Tooth Design**
- **Hook Angle**

### Use This Blade
- **Extra Hard Carbide**
- **Maintains a sharp cutting edge for fine finish, chip-free cuts, & long life**

### Laser Cut Anti-Vibration Slots
- **A breakthrough innovation designed & engineered by Freud to minimize blade vibration.**

### No Scoring Blade Needed
- **Reduces chatter leaving a flawless cut in laminates & melamine.**

### No Aftermarket Stabilizer Needed
- **Stable blade provides superior finish & long cutting life.**

### Drastically Reduces Vibration & Sideways Movement
- **For clean and true cuts in each application.**

### Use Full KERF Blades for Ultimate Stability
- **Use Thin KERF Blades For Fast Cuts or for saws under 3HP.**

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**Catalog Section**

- **LU85R010**
- **LU89R010**
- **LU80R010**
- **LU80M010**
- **LU79R010**
- **LU80M010**
- **LU97R010**
- **LU97M010**
- **LU96R010**
- **LU81M010**
- **LU94M010**

** perm - SHELL **
** perm - I.C.E. FULL KERF **
** perm - SHELL **
** perm - I.C.E. THIN KERF **
Introducing Freud’s New

The Most Technologically

Gives superior performance in both crosscutting and ripping

Flawless Crosscuts
Flawless Rips

Premier FUSION

Flawless Rips

Premier FUSION

Introducing Freud’s New Saw Blades!

Flawless Crosscuts

Introducing Freud’s New Saw Blades!

Flawless Rips

Introducing Freud’s New Saw Blades!

Flawless Crosscuts

Perma-SHIELD® non-stick coating virtually eliminates heat generated from friction, prevents corrosion, and reduces pitch build-up and blade drag
Advanced Blade On The Market!

The Fusion tooth design fuses Freud’s 30° Hi-ATB tooth with Freud’s unique double side grind tooth geometry. The design provides a glass smooth side finish while also giving a flawless top & bottom finish in veneered plywood, hardwoods, and melamine.

Combination of unique design and special polymer filler reduces vibration above and beyond any other blade resulting in superior performance.

One Blade Does It All—Crosscuts & Rips

Freud engineers have discovered the ultimate combination of fused tooth grind geometry, blade body rigidity, precise tensioning, a special carbide blend and superior carbide brazing, non-stick Perma-SHIELD® coating and high performance anti-vibration – all working together in concert to provide the ultimate cut. One blade does it all. Whether you’re ripping or crosscutting, a Premier Fusion blade will tackle any project.

<table>
<thead>
<tr>
<th>Perma-SHIELD™</th>
<th>Dia.</th>
<th>Teeth</th>
<th>Arbor</th>
<th>Kerf(K)</th>
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</table>

• Carbide Grade Chart •

Increasing Hardness

Increasing Impact Strength
Ultimate Plywood & Melamine Blades

LU80M

Flawless Finish In Veneered Plywood, Melamine & Laminates For Virtually Chip-Free Cuts

The LU80 saw blade provides flawless, chip-free edges in veneered plywood, fine moldings, melamine, laminates, and crosscuts in solid woods. Using advanced technology, Freud developed this line of saw blades that features laser-cut, anti-vibration slots that practically eliminate the vibrations that resonate in standard blades. The combination of High ATB tooth design and anti-vibration slots makes these blades the ultimate finish blades. The result is a cut so smooth it eliminates the need for stabilizer or a scoring blade!

Recommended Use & Cut Quality

<table>
<thead>
<tr>
<th>RIPS WOOD:</th>
<th>CROSSCUTS WOOD:</th>
<th>CHIP BOARD:</th>
<th>PLYWOOD:</th>
<th>NON-FERROUS:</th>
</tr>
</thead>
<tbody>
<tr>
<td>Not Recommended</td>
<td>Not Recommended</td>
<td>Not Recommended</td>
<td>Not Recommended</td>
<td>Not Recommended</td>
</tr>
</tbody>
</table>

CUT QUALITY: Fair > Good > Excellent
(Not recommended for ferrous metals or masonry)

Laser-Cut Anti-Vibration Slots drastically reduce vibration and sideways movement in the cut extending blade life and giving a crisp, splinter-free flawless finish

High Alternate Top Bevel (HiATB)
Tooth Design produces splinter-free cuts

Silver ICE™ Perma-SHIELD™

<table>
<thead>
<tr>
<th>Dia.</th>
<th>Teeth</th>
<th>Arbor</th>
<th>Kerf (K)</th>
<th>Plate (P)</th>
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</table>

Carbide Grade Chart

- Increasing Hardness
- Increasing Impact Strength

Tips

When you need a smooth finish on both sides of plywood or laminate use a zero clearance insert or blade with Hi-ATB teeth.
Thin Kerf Ultimate Plywood & Melamine Blades

LU79R

Flawless Finish In Veneered Plywood, Melamines & Laminates For Virtually Chip-Free Cuts

Using advanced technology, Freud developed the LU79 thin kerf line of saw blades that features laser-cut, anti-vibration slots that practically eliminate the vibrations that resonate in standard blades. This blade provides flawless, chip-free edges in veneered plywoods, fine moldings, melamine, laminates, and crosscuts in solid woods. The combination of Hi-ATB tooth design and anti-vibration slots makes these thin kerf blades the ultimate finish blades. The result is a cut so smooth it eliminates the need for a stabilizer or a scoring blade!

Recommended Use & Cut Quality

RIPS WOOD: Excellent
CROSSCUTS WOOD: Excellent
CHIP BOARD: Excellent
PLYWOOD: Excellent
LAMINATE: Excellent
NON-FERROUS: Not Recommended

CUT QUALITY: (Not recommended for ferrous metals or masonry)

Using advanced technology, Freud developed the LU79 thin kerf line of saw blades that features laser-cut, anti-vibration slots that practically eliminate the vibrations that resonate in standard blades. This blade provides flawless, chip-free edges in veneered plywoods, fine moldings, melamine, laminates, and crosscuts in solid woods. The combination of Hi-ATB tooth design and anti-vibration slots makes these thin kerf blades the ultimate finish blades. The result is a cut so smooth it eliminates the need for a stabilizer or a scoring blade!

Laser-Cut Anti-Vibration Slots drastically reduce vibration and sideways movement in the cut extending blade life and giving a crisp, splinter-free flawless finish

Perma-SHIELD™

<table>
<thead>
<tr>
<th>Dia.</th>
<th>Teeth</th>
<th>Arbor</th>
<th>Kerf(K)</th>
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<td>96 Hi-ATB</td>
<td>1&quot;</td>
<td>.098&quot;</td>
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When you need a smooth finish on both sides of plywood or laminate use a zero clearance insert or blade with Hi-ATB teeth.
Industrial Ultimate Cut-Off Blades

LU85R

Features TiCo™ High Density Carbide Crosscutting Blend For Maximum Performance

No Stabilizers Needed

Ultimate Crosscutting Blades For Glass-Smooth Finishes

This superior blade gives glass-smooth finishes when crosscutting hard and soft woods, so no sanding is required. What makes this blade so special is the unique side grinding of each tooth. The teeth actually polish the material as it cuts. New laser-cut anti-vibration slots practically eliminate the vibration that resonates in standard blades, producing glass-smooth finishes. With a finish this perfect you won't need stabilizers!

Recommended Use & Cut Quality

RIPS WOOD:
CROSSCUTS WOOD:
CHIP BOARD:
PLYWOOD:
LAMINATE:
NON-FERROUS:

CUT QUALITY: Fair Good Excellent
(Not recommended for ferrous metals or masonry)

Unique Side Grind polishes the material to produce a superior finish

Laser-Cut Anti-Vibration Slots drastically reduce vibration and sideways movement in the cut extending blade life, and giving a crisp, flawless finish

Perma-SHIELD™ Dia. Teeth Arbor Kerf(K) Plate(P)
LU85R008 8" 64 ATB 5/8" .116 .098
LU85R009 9" 72 ATB 5/8" .116 .098
LU85R010 10" 80 ATB 5/8" .116 .098
LU85R012 12" 96 ATB 1" .116 .098
LU85R014 14" 108 ATB 1" .136 .118
LU85R015 15" 108 ATB 1" .136 .118

Tips

When crosscutting, 5 to 7 teeth should be working in the wood at one time.
Industrial Thin Kerf Ultimate Cut-Off Blades

LU74R

Recommended Use & Cut Quality

RIPS WOOD: CROSSCUTS WOOD: CHIP BOARD: PLYWOOD: LAMINATE: NON-FERROUS: Not Recommended

CUT QUALITY: Fair Good Excellent
(Not recommended for ferrous metals or masonry)

This thin kerf blade produces glass smooth surfaces when crosscutting hardwoods and softwoods, thanks to Freud’s unique side grinding technology. The larger blades are ideal for miter box applications. Thin kerf blades remove less material than standard carbide blades, thus requiring less horsepower to produce equally good results.

Perma-SHIELD™

Dia. Teeth Arbor Kerf(K) Plate(P)
LU74R008 8" 64 ATB 5/8" .087 .063
LU74R010 10" 80 ATB 5/8" .091 .071
LU74R012 12" 96 ATB 1" .091 .071
LU74R014 14" 108 ATB 1" .118 .087

Carbide Grade Chart

Increasing Hardness
H001 H005 H010 H015 H020 H025
Increasing Impact Strength
Tips

Maintain a proper feed rate. Feeding too slow causes burning of the material. Feeding too fast can be dangerous and produces a poor dull cut.
Industrial Thin Kerf Fine Finish Crosscut Blades

LU88R

Crosscutting Blades For Fine Finish With Underpowered Saws

Recommended Use & Cut Quality

- **RIPS WOOD:**
- **CROSSCUTS WOOD:**
- **CHIP BOARD:**
- **PLYWOOD:**
- **LAMINATE:**
- **NON-FERROUS:** Not Recommended

**CUT QUALITY:**
- Fair
- Good
- Excellent

(Not recommended for ferrous metals or masonry)

This Perma-SHIELD™ coated blade gives new life to underpowered saws and produces smooth crosscuts in hardwoods, softwoods and moldings. Coated blades pull 1/3 less on the saw, which translates into 33% more cutting power. Thin kerf blades remove less material than standard carbide blades, thus requiring less horsepower to produce equally good results.

**Perma-SHIELD™**

- **Dia.**
- **Teeth**
- **Arbor**
- **Kerf(K)**
- **Plate(P)**

<table>
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<tr>
<th>Model</th>
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<td>80 ATB</td>
<td>1&quot;</td>
<td>.094</td>
<td>.071</td>
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</table>

**Carbide Grade Chart**

- **Increasing Hardness:**
  - R360
  - R290
  - R180
  - R110
  - H100
  - H600
  - H900
  - H1000

- **Increasing Impact Strength:**

Tips

- If you experience burning on one side of the cut you should check and adjust the saw’s alignment.
- Consult your saw owner’s manual for alignment instructions.
Industrial Thin Kerf Sliding Compound Miter Saw Blades

**LU91M**

**LU91R**

**Fine Finish Blades For Sliding Miter & Radial Arm Saws**

**Recommended Use & Cut Quality**

- **Rips Wood:**
- **Crosscuts Wood:**
- **Chip Board:**
- **Plywood:**
- **Laminate:**
- **Non-Ferrous:** Not Recommended

**CUT QUALITY:**

- Fair
- Good
- Excellent

(Not recommended for ferrous metals or masonry)

**Depth of Cut**

- 1/2" MIN.
- 2 3/4" MAX.

**Negative Hook Angle** minimizes climbing for better control

**Thin Kerf** requires less power and allows for faster feed rate

**Features**

- TiCo™ High Density Carbide Crosscutting Blend For Maximum Performance

**Application**

- This thin kerf industrial blade provides a superior finish cut with sliding compound miter saws. The 5° negative hook angle helps prevent the blade from being too aggressive and pushes the work piece down and towards the fence. Thin kerf blades remove less material than standard carbide blades, thus requiring less horsepower to produce equally good results.

**Silver ICE™ Perma-SHIELD™**

<table>
<thead>
<tr>
<th>Dia.</th>
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**Carbide Grade Chart**

- Increasing Hardness
- Increasing Impact Strength

**Tips**

- For safety and best results when using a miter saw, securely clamp the material before cutting.
When cutting on a table saw, put the finish side of your work piece facing up. When cutting with a radial arm saw or hand-held saw, put the finish side down. This will reduce splintering.
When cutting manmade products, such as laminates, melamines, MDF, and particle board, use a blade with Triple Chip Grind (TCG) for longest blade life.
Industrial Double Sided Laminate/Melamine Blades

LU97M

Proper blade height is essential to chip-free cuts. If you experience chipping on the bottom of the material, lower the blade slightly. If there is chipping on the top of the material the blade height should be increased slightly.

Industrial Double Sided Laminate/Melamine Blades
LU97M

For Ultra Long Life In Double Sided Manmade Materials

Recommended Use & Cut Quality

RIPS WOOD:
CROSSCUTS WOOD:
CHIP BOARD:
PLYWOOD:
MELAMINE:
LAMINATE:
NON-FERROUS:

CUT QUALITY:
Fair
Good
Excellent

(Not recommended for ferrous metals or masonry)

Triple Chip Grind (TCG) Tooth Design with a negative hook angle for superior life in abrasive man-made materials

Laser-Cut Anti-Vibration Slots drastically reduce vibration and sideways movement in the wood extending blade life and giving a crisp, splinter-free flawless finish

Depth of Cut
1/4" MIN.
1 5/8" MAX.

Silver ICE™ Perma-SHIELD™

Dia. Teeth Arbor Kerf(K) Plate(P)
LU97M008 LU97R008 8" 64 TCG 5/8" .126 .087
LU97M010 LU97R010 10" 80 TCG 5/8" .126 .087
LU97M012 LU97R012 12" 96 TCG 1" .126 .087
LU97M014 LU97R014 14" 108 TCG 1" .138 .098

Tips
Techniques

Proper blade height is essential to chip-free cuts. If you experience chipping on the bottom of the material, lower the blade slightly. If there is chipping on the top of the material the blade height should be increased slightly.
Industrial Thin Kerf Double Sided Laminate/Melamine

LU96R

For Ultra Long Life In Double Sided Manmade Materials

Recommended Use & Cut Quality

- RIPS WOOD: Chip-Free Bottom of Cut
- CROSSCUTS WOOD: Chip-Free Top of Cut
- CHIP BOARD: No Scoring Blade Needed
- PLYWOOD:
- MELAMINE:
- LAMINATE:
- NON-FERROUS: Not Recommended

CUT QUALITY: Fair Good Excellent
(Not recommended for ferrous metals or masonry)

The LU96R is a thin kerf blade that is designed to give long life and excellent finish on the top and bottom of laminates, melamine & veneered plywood. The laser-cut anti-vibration design yields the plate acoustically dead. This reduces the sideways movement of the cutting edge to prevent chipping in manmade materials such as laminates. This dramatically extends cutting life and finish. No scoring blades needed with this blade!

Triple Chip Grind (TCG) Tooth Design with a negative hook angle for superior life in abrasive man-made materials

Thin Kerf requires less power and allows for faster feed rate

<table>
<thead>
<tr>
<th>Perma-SHIELD™</th>
<th>Dia.</th>
<th>Teeth</th>
<th>Arbor</th>
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<th>Plate(P)</th>
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<td>1&quot;</td>
<td>.091</td>
<td>.071</td>
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Proper blade height is essential to chip-free cuts. If you experience chipping on the bottom of the material, lower the blade slightly. If there is chipping on the top of the material the blade height should be increased slightly.
Industrial Thick-Stock Laminate Blades

LU92M

Long Life Production Blades For Double Sided Laminates And Stacked Chipboard

Features TiCo™ High Density Carbide Laminate Blend For Maximum Performance

Recommended Use & Cut Quality

RIPS WOOD: CROSSCUTS WOOD: CHIP BOARD: PLYWOOD: LAMINATE: NON-FERROUS: Not Recommended

CUT QUALITY: Fair Good Excellent

(Not recommended for ferrous metals or masonry)

Silver ICE™

<table>
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<tr>
<th>Dia.</th>
<th>Teeth</th>
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<th>Plate(P)</th>
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Modified Triple Chip Grind (MTCG) Tooth Design for long life and chip-free cuts in thick stock manmade materials

Negative Hook Angle minimizes chipping in laminates and melamine

Depth of Cut

1" MIN.
2 1/2" MAX.

• Carbide Grade Chart •

Increasing Hardness

Increasing Impact Strength

Proper blade height is essential to chip-free cuts. If you experience chipping on the bottom of the material, lower the blade slightly. If there is chipping on the top of the material the blade height should be increased slightly.
Industrial Heavy Duty Stacked Chipboard Blades

LU81M

Recommended Use & Cut Quality

- **RIPS WOOD:**
- **CROSSCUTS WOOD:**
- **CHIP BOARD:**
- **PLYWOOD:**
- **LAMINATE:**
- **NON-FERROUS:** Not Recommended

**CUT QUALITY:**
- Fair
- Good
- Excellent

(Not recommended for ferrous metals or masonry)

Heavy Duty Fast Stacked Chipboard Blades

This blade is ideal for sizing sheet goods (chipboard, plywood, laminates, MDF) where speed is more important than a smooth finish or when cutting stacks of material. These blades are best used when cutting plywood and composition material, but they can also be used with hardwood and softwood.

**Positive Hook Angle** for fast cutting and easy feeding in production applications

**Triple Chip Grind (TCG) Tooth Design** offers longer life when cutting abrasive manmade materials

---

**Recommended Use & Cut Quality**

**Application**

**Carbide Grade Chart**

- **Increasing Hardness**
- **Increasing Impact Strength**

Resin build up can cause a blade to drag in the cut, resulting in shorter blade life, burning in the cut and unnecessary strain on the saw. For best results, be sure the blade is clean before use.
Industrial Heavy Duty Multi-Purpose Blades

LU82M

Features TiCo™ High Density Carbide General Purpose Blend For Maximum Performance

For Long Life In Stacked Chipboard And Manmade Materials

Recommended Use & Cut Quality

RIPS WOOD
CROSSCUTS WOOD
CHIP BOARD
PLYWOOD
LAMINATE
NON-FERROUS

CUT QUALITY: Fair > Good > Excellent
(Not recommended for ferrous metals or masonry)

This multi-purpose blade will cut stacks of manmade wood products as well as hardwood and softwood up to 2-3/4” thick. The blade’s deep gullets and TCG rip and crosscut through hardwoods and softwoods with ease. Although the ideal working range is 1/2” to 2-3/4” thick, thinner or thicker materials may be cut, resulting in some loss of surface finish.

Freud-Made TiCo™ Carbide is durable and chemical-resistant for long life and razor-sharp cuts

Precision Tensioning with computer-controlled equipment keeps the blade flat and true while maximizing blade life and performance

<table>
<thead>
<tr>
<th>Silver ICE™</th>
<th>Dia.</th>
<th>Teeth</th>
<th>Arbor</th>
<th>Kerf(K)</th>
<th>Plate(P)</th>
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<tbody>
<tr>
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<td>96 TCG</td>
<td>1&quot;</td>
<td>.177</td>
<td>.118</td>
</tr>
</tbody>
</table>

Never use oven cleaner or other caustic substances to clean Freud saw blades. To remove pitch buildup on blades, soak overnight in kerosene in a sealed container then scrub with a stiff, nylon bristle brush. Caution: kerosene is flammable. Take necessary precautions to avoid injury from fire.
Industrial General Purpose Blades

LU72M

For Heavy-Duty General Purpose Applications

Recommended Use & Cut Quality

- **RIPS WOOD 1/4" to 1":** Good
- **CROSSCUTS WOOD 3/4" to 3 1/2":** Excellent
- **CHIP BOARD:** Good
- **PLYWOOD:** Good
- **LAMINATE:** Good
- **NON-FERROUS:** Not Recommended

**CUT QUALITY:**
- **Fair**
- **Good**
- **Excellent**

(Not recommended for ferrous metals or masonry)

For best results, set your saw so that one half of a carbide tip protrudes beyond the material to be cut.

Positive Hook Angle for fast cutting and easy feeding in production applications

Heavy-Duty Thick Kerf and Plate ensure a stable, flat blade for long cutting life

<table>
<thead>
<tr>
<th>Silver ICE™</th>
<th>Dia.</th>
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<th>Arbor</th>
<th>Kerf(K)</th>
<th>Plate(P)</th>
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*Carbide Grade Chart*

- **H005**
- **H012**
- **H018**
- **H025**
- **H030**
- **H035**

Increasing Hardness

13º

Increasing Impact Strength

15º

For best results, set your saw so that one half of a carbide tip protrudes beyond the material to be cut.
Industrial Thin Kerf General Purpose Blades

LU86R

For Heavy-Duty General Purpose Applications

Recommended Use & Cut Quality

RIPS WOOD 1/4" to 1":
CROSSCUTS WOOD 3/4" to 3 1/2":
CHIP BOARD:
PLYWOOD:
LAMINATE:
NON-FERROUS: Not Recommended

CUT QUALITY: Fall Good Excellent
(Not recommended for ferrous metals or masonry)

Crosscutting

3/4" MIN. 3 1/2" MAX.

Ripping

1/4" MIN. 1" MAX.

This heavy-duty thin kerf blade is good for crosscutting thick hardwoods and softwoods and thinner stock materials. The ideal working range is from 3/4" to 3-1/2" thick for crosscutting, and 1/4" to 1" thick for ripping. Thinner or thicker material may be cut, but some loss of surface finish may occur.

Positive Hook Angle for fast cutting and easy feeding in production applications

Heavy-Duty Thick Kerf and Plate ensure a stable, flat blade for long cutting life

Perma-SHIELD™

Dia. Teeth Arbor Kerf(K) Plate(P)
LU86R008 8" 34 ATB 5/8" .087 .063
LU86R010 10" 40 ATB 5/8" .094 .071
LU86R012 12" 48 ATB 1" .094 .071
LU86R014 14" 54 ATB 1" .106 .079

Carbide Grade Chart

Increasing Hardness

Increasing Impact Strength

For best results, set your saw so that one half of a carbide tip protrudes beyond the material to be cut.
Industrial High-Production General Purpose Blades

LU71M

Recommended Use & Cut Quality

**RIPS WOOD:**
- **CROSSCUTS WOOD:**
- **CHIP BOARD:**
- **PLYWOOD:**
- **LAMINATE:**
- **NON-FERROUS:**

**CUT QUALITY:**
- Fair
- Good
- Excellent

(Not recommended for ferrous metals or masonry)

This highly aggressive general purpose blade is ideal for a production environment. With its low number of teeth and steep hook angle, this blade can operate at high feed rates. These features also make it the blade of choice when crosscutting extremely thick stock. Use it with dimension stock where speed is more important than surface quality. The ideal working range is from 1/4" to 1-1/4" thick for ripping and 1-1/2" to 3-1/2" thick for crosscutting. Thicker or thinner material may be cut, but some loss of surface finish may occur.

Positive Hook Angle for fast cutting and easy feeding in production applications

Heavy Duty Thick Plate ensures a stable, flat blade for long cutting life

<table>
<thead>
<tr>
<th>Silver ICE™</th>
<th>Dia.</th>
<th>Teeth</th>
<th>Arbor</th>
<th>Kerf(K)</th>
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<td>.177</td>
<td>.118</td>
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</table>

• Carbide Grade Chart •

Increasing Hardness
- H00S
- H00X
- H01S
- H01X
- H02S
- H02X

Increasing Impact Strength
- 15°
- 13°

Tips Techniques

Maintain a proper feed rate. Feeding too slow causes burning of the material. Feeding too fast can be dangerous and produces a poor dull cut.
**Industrial Combination Blades**

**LU84M**

- **Features TiCo High Density Carbide Combination Blend For Maximum Performance**
- **No Stabilizers Needed**

**LU84R**

- **Heavy-Duty Combination Blades**

**Recommended Use & Cut Quality**

<table>
<thead>
<tr>
<th>Rips Wood:</th>
<th>Crosscutting</th>
</tr>
</thead>
<tbody>
<tr>
<td>Large Gullets in front of flat top rakers allow for fast ripping and easy chip removal</td>
<td></td>
</tr>
</tbody>
</table>

**CUT QUALITY:**

- **Ripping:**
  - 3/4" MIN.
  - 3 1/2" MAX.

- **Crosscutting:**
  - 3/8" MIN.
  - 1 1/2" MAX.

**CUT QUALITY:**

- **Fair**
- **Good**
- **Excellent**

(Not recommended for ferrous metals or masonry)

**Laser-Cut Anti-Vibration Slots**

- Drastically reduce vibration and sideways movement in the cut extending blade life, and giving a crisp, flawless finish.

**Crosscutting**

- **3/4" MIN.**
- **3 1/2" MAX.**

**Ripping**

- **3/8" MIN.**
- **1 1/2" MAX.**

**Silver ICE™ Perma-SHIELD™**

<table>
<thead>
<tr>
<th>Dia.</th>
<th>Teeth</th>
<th>Arbor</th>
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</table>

**Carbide Grade Chart**

- **Increasing Hardness:**
  - H32X
  - K18S
  - N81S
  - H80K
  - H80X

- **Increasing Impact Strength:**
  - H32X
  - K18S
  - N81S
  - H80K
  - H80X

**Tips**

Kickbacks are one of the most dangerous hazards in woodworking. Choose a saw blade with a kickback-reducing design. This design places a chip limitator before each tooth, restricting tooth bite to the maximum safe amount for a more secure work environment.
Industrial Thin Kerf Combination Blades

LU83R

The ultimate combination blade is now available in a thin kerf design with Freud’s LU83R. The groups of five teeth include one flat tooth for ripping, followed by four alternate top bevel teeth for crosscutting and a large gullet for effective chip clearance. This blade also features laser cut anti-vibration slots, practically eliminating the vibration that resonates in standard blades. With this combination blade, there is no need for stabilizers.

Recommended Use & Cut Quality

RIPS WOOD: Crosscutting
CROSSCUTS WOOD: 3/4" MIN. 3/8" MAX.
CHIP BOARD: 3/8" MIN. 1 1/2" MAX.
PLYWOOD: 10º
LAMINATE: 15º
NON-FERROUS: Not Recommended

Laser-Cut Anti-Vibration Slots drastically reduce vibration and sideways movement in the cut extending blade life, and giving a crisp, flawless finish

Perma-SHIELD™

<table>
<thead>
<tr>
<th>Dia.</th>
<th>Teeth</th>
<th>Arbor</th>
<th>Kerf(K)</th>
<th>Plate(P)</th>
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</table>

Tips

Kickbacks are one of the most dangerous hazards in woodworking. Choose a saw blade with a kickback-reducing design. This design places a chip limitator before each tooth, restricting tooth bite to the maximum safe amount for a more secure work environment.
Industrial Glue Line Ripping Blades

**LM74M**

RIPPING BLADES

Heavy-Duty Thick Kerf and Plate ensure a stable, flat blade for long cutting life

*Carbide Grade Chart*
- **G** Increasing Hardness
- **N** Increasing Impact Strength

**Silver ICE™ Perma-SHIELD™**

<table>
<thead>
<tr>
<th>Dia.</th>
<th>Teeth</th>
<th>Arbor</th>
<th>Kerf(K)</th>
<th>Plate(P)</th>
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</table>

For best results, set your saw so that one half of a carbide tip protrudes beyond the material to be cut.
Industrial Heavy-Duty Rip Blades

LM72M

LM72R

Recommended Use & Cut Quality

RIPS WOOD: Crosscuts Wood: Chip Board: Plywood: Laminate: Non-Ferrous: Not Recommended

CUT QUALITY: Fair Good Excellent

(Not recommended for ferrous metals or masonry)

Extra Large, Flat Tooth Design leaves a smooth finish without the need for sanding or jointing

Laser-Cut Anti-Vibration Slots drastically reduce vibration and sideways movement in the cut extending blade life, and giving a crisp, swirl-free flawless finish

Application

Smooth, Fast Heavy-Duty Ripping

This blade gives smooth, fast rips in hardwoods and softwoods. The combination of a rigid blade body and razor sharp flat top carbide teeth will provide a "glue line" precision cut. These blades are precision balanced and can be used in gang-rip operations. The ideal working range is from 3/4" to 2-3/4" thick. This blade also features laser cut anti-vibration slots, practically eliminating the vibration that resonates in standard blades. With this ultimate ripping blade, there is no need for stabilizers.

Recommended Use & Cut Quality

This blade gives smooth, fast rips in hardwoods and softwoods. The combination of a rigid blade body and razor sharp flat top carbide teeth will provide a "glue line" precision cut. These blades are precision balanced and can be used in gang-rip operations. The ideal working range is from 3/4" to 2-3/4" thick. This blade also features laser cut anti-vibration slots, practically eliminating the vibration that resonates in standard blades. With this ultimate ripping blade, there is no need for stabilizers.

Silicon Carbide Carbide Grade Chart

Increasing Hardness

Increasing Impact Strength

When ripping wood, 3 to 5 teeth should be working in the wood at one time.
Industrial Thin Kerf Rip Blades

**Features TiCo High Density Carbide Ripping Blend For Maximum Performance**

**SAW BLADES-INDUSTRIAL**

**Ripping Blades**

**LU87R**

**Industrial Thin Kerf Rip Blades**

**Thin Kerf allows for faster feed rate and reduced waste**

**Positive Hook Angle for fast cutting and easy feeding in ripping applications**

**Recommended Use & Cut Quality**

- **RIPS WOOD:**
  - Good
- **CROSSCUTS WOOD:**
  - Good
- **CHIP BOARD:**
  - Good
- **PLYWOOD:**
  - Good
- **LAMINATE:**
  - Good
- **NON-FERROUS:**
  - Not Recommended

**CUT QUALITY:**

- **Fair**
- **Good**
- **Excellent**

(Not recommended for ferrous metals or masonry)

**Heavy-Duty Ripping Blades For Underpowered Saws**

This blade gives new life to underpowered table saws and radial arm saws because the thin kerf does not require much horsepower. The Perma-SHIELD™ coating helps this blade pull 1/3 less on the saw, which translates into over 33% more cutting power. The ideal working range is from 3/4" to 2-3/4" thick.

**Application**

- **Depth of Cut**
  - 3/4" MIN.
  - 2 3/4" MAX.

**Perma-SHIELD™**

<table>
<thead>
<tr>
<th>Dia.</th>
<th>Teeth</th>
<th>Arbor</th>
<th>Kerf(K)</th>
<th>Plate(P)</th>
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<tr>
<td>LU87R008</td>
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<td>24 FLAT</td>
<td>5/8&quot;</td>
<td>.094</td>
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</table>

**• Carbide Grade Chart •**

- Increasing Hardness
  - R380
  - R205
  - R185
  - H11S
  - H60D
  - H60K
  - H60X

- Increasing Impact Strength

**Tips Techniques**

Maintain a proper feed rate. Feeding too slow causes burning of the material. Feeding too fast can be dangerous and produces a poor dull cut.
Industrial Thick Stock Rip Blades

LM71M

Features TiCo™ High Density Carbide Ripping Blend For Maximum Performance

Application

**Recommended Use & Cut Quality**

- **Rips Wood:** Not Recommended
- **Crosscuts Wood:** Not Recommended
- **Chip Board:** Not Recommended
- **Plywood:** Not Recommended
- **Laminate:** Not Recommended
- **Non-Ferrous:** Not Recommended
- **Cut Quality:** Fair, Good, Excellent
  
  *Not recommended for ferrous metals or masonry*

**For Glue Line Joints In Thick Stock (1½" – 3½")**

This blade is ideal for high-speed ripping operations in hardwood and softwood. The low tooth count also makes this blade ideal for ripping thick material. It can be used with manual feeding as well as with power feeders in single or gang-ripping operations. The ideal working range is 1-1/2" to 3-1/2" thick. Thinner or thicker material may be cut, but some loss of surface finish may occur.

**Heavy-Duty Thick Plate** ensures a stable, flat blade for long cutting life in extreme ripping conditions

**Large Gullets** allow for fast ripping and easy chip removal

<table>
<thead>
<tr>
<th>Silver ICE™</th>
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<th>Teeth</th>
<th>Arbor</th>
<th>Kerf(K)</th>
<th>Plate(P)</th>
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<tr>
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<td>28 FLAT</td>
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<td>.177</td>
<td>.118</td>
</tr>
</tbody>
</table>

**Carbide Grade Chart**

- Increasing Hardness
- Increasing Impact Strength

**Tips Techniques**

When ripping wood, 3 to 5 teeth should be working in the wood at one time.
To determine if the metal you wish to cut is non-ferrous, hold the metal next to a magnet. If it attracts the magnet, it is a ferrous metal and should not be cut with a non-ferrous blade.

This blade produces a smooth, burr-free finish when cutting thin aluminum, brass and other non-ferrous metal extrusions. A high tooth count with a 5° hook angle allows the teeth to slice efficiently through the material without binding. The requirements on the cutting edge greatly differ with nonferrous metals than with cutting wood. With this in mind, Freud formulated a special carbide with high impact strength for this blade. Freud recommends use of a liquid lubricant when cutting non-ferrous materials. This can be accomplished with a spray of WD-40 or other similar type of lubricant every 4 or 5 cuts. Wax sticks are not recommended.

**Recommended Use & Cut Quality**

<table>
<thead>
<tr>
<th>Application</th>
<th>Rip Wood</th>
<th>Crosscuts Wood</th>
<th>Chip Board</th>
<th>Plywood</th>
<th>Laminate</th>
<th>Non-Ferrous</th>
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<td>Rips Wood</td>
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<td>Not Recommended</td>
<td>Not Recommended</td>
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<td>Not Recommended</td>
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</tbody>
</table>

**Cut Quality:**

- **Fair**
- **Good**
- **Excellent**

(Not recommended for ferrous metals or masonry)

**Positive Hook Angles** produce a smoother cut with less material distortion and burr free cuts.

**Freud-Made TiCo™ Carbide** specifically designed to cut non-ferrous metals extends tooth life and withstands impact.

<table>
<thead>
<tr>
<th>Model</th>
<th>Diameter (Dia.)</th>
<th>Teeth</th>
<th>Arbor</th>
<th>Kerf (K)</th>
<th>Plate (P)</th>
</tr>
</thead>
<tbody>
<tr>
<td>LU90M010</td>
<td>10&quot;</td>
<td>100 TCG</td>
<td>5/8&quot;</td>
<td>.110</td>
<td>.087</td>
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<tr>
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<td>120 TCG</td>
<td>1&quot;</td>
<td>.118</td>
<td>.098</td>
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</tbody>
</table>

**Carbide Grade Chart**

- Increasing Hardness
  - HSS
  - TiCN
  - TiAlN
  - TiCN/TiAlN
- Increasing Impact Strength
  - 15°
  - 25°
  - 45°

To determine if the metal you wish to cut is non-ferrous, hold the metal next to a magnet. If it attracts the magnet, it is a ferrous metal and should not be cut with a non-ferrous blade.
To determine if the metal you wish to cut is non-ferrous, hold the metal next to a magnet. If it attracts the magnet, it is a ferrous metal and should not be cut with a non-ferrous blade.
Industrial Thin Kerf Non-Ferrous Metal Blades

LU77M

Recommended Use & Cut Quality

RIPS WOOD: Not Recommended
CROSSECTS WOOD: Not Recommended
CHIP BOARD: Not Recommended
PLYWOOD: Not Recommended
LAMINATE: Not Recommended
NON-FERROUS: Not Recommended

CUT QUALITY: Fair > Good > Excellent
(Not recommended for ferrous metals or masonry)

Cutting Non-Ferrous Materials And Aluminum

This thin kerf heavy-duty, non-ferrous metal cutting blade produces an excellent finish. These blades have custom designed gullets to minimize chip build-up and specially formulated carbide for long life. Freud recommends use of a liquid lubricant when cutting. This can be accomplished with a spray of WD-40 or other lubricant every 4 to 5 cuts. Wax sticks are not recommended.

Silver ICE™

<table>
<thead>
<tr>
<th>Silver ICE™</th>
<th>Dia.</th>
<th>Teeth</th>
<th>Arbor</th>
<th>Kerf(K)</th>
<th>Plate(P)</th>
</tr>
</thead>
<tbody>
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<td>.079</td>
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</table>

Tips

To determine if the metal you wish to cut is non-ferrous, hold the metal next to a magnet. If it attracts the magnet, it is a ferrous metal and should not be cut with a non-ferrous blade.
Industrial Plastic Blades

LU94M

This industrial blade cuts acrylics, polycarbonates and other plastics, leaving a smooth finish without melting. By combining micrograin carbide tips with a specially modified triple chip grind these blades will give a clean smooth cut. These blades produce less heat keeping the cut edge crisp.

Recommended Use & Cut Quality

- Plexiglass
- Plastics
- Chip Board
- Plywood
- Non-ferrous

Cut Quality: Fair, Good, Excellent

(Not recommended for ferrous metals or masonry)

- Depth of Cut
  - 1/4" Min.
  - 1 5/8" Max.
- Negative Hook Angle

Silver ICE™

<table>
<thead>
<tr>
<th>Dia.</th>
<th>Teeth</th>
<th>Arbor</th>
<th>Kerf(K)</th>
<th>Plate(P)</th>
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<td>LU94M008</td>
<td>8&quot;</td>
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<td>80 MTCG</td>
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<td>LU94M012</td>
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<td>.110</td>
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</table>

Carbide Grade Chart

- Increasing Hardness
- Increasing Impact Strength

Tips

For best results, set your saw so that the blade is exposed only enough that one half of a carbide tip protrudes beyond the material to be cut.
Industrial Solid Surface Blades

LU95M

Features TiCo™ High Density Carbide Plastic Blend For Maximum Performance

LU95R

No Stabilizers Needed

Heavy-Duty Solid Surface Blades For Swirl & Burn-Free Cuts

Recommended Use & Cut Quality

<table>
<thead>
<tr>
<th>SOLID SURFACE</th>
<th>PLEXIGLASS:</th>
<th>VINYL:</th>
<th>CHIPSBOARD:</th>
<th>LAMINATE:</th>
<th>NON-FERROUS:</th>
<th>CUT QUALITY:</th>
</tr>
</thead>
</table>

SOLID SURFACE: Not Recommended
PLEXIGLASS: Good
VINYL: Good
CHIPBOARD: Good
LAMINATE: Good
NON-FERROUS: Not Recommended

Depth of Cut
1/4" MIN.
1 3/8" MAX.

SPECIALTY BLADES

CUT QUALITY: Fair > Good > Excellent
(Not recommended for ferrous metals or masonry)

Special Side-Grind Tooth Design enables blade to remain cool while cutting, eliminating melting

Laser-Cut Anti-Vibration Slots drastically reduce vibration and sideways movement in the cut, extending blade life, and giving a crisp, swirl-free flawless finish

Silver ICE™ Perma-SHIELD™

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Teeth</th>
<th>Arbor</th>
<th>Kerf(K)</th>
<th>Plate(P)</th>
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<tbody>
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<td>96 MTCG</td>
<td>1&quot;</td>
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</tbody>
</table>

CARBIDE GRADE CHART

Increasing Hardness

Increasing Impact Strength

Proper blade height on a table saw is one half of the carbide tip higher than the material to be cut.