
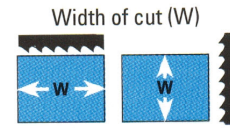


BI-METAL TOOTH SELECTION

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FOR CUSTOMIZED BAND SAW RECOMMENDATIONS



1. Determine the size and shape of material to be cut.
2. Identify the chart to be used (square solids, round solids, or tubing/structurals).
3. Read teeth per inch next to material size.

SQUARE/RECTANGLE SOLID Locate width of cut (W)

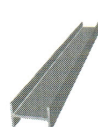
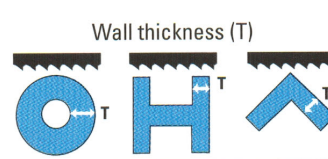
WIDTH OF CUT	
IN	.1 .2 .3 .4 .5 .6 .7 .8 .9 1 2 5 10 15 20 25 30 35 40 45 50
MM	2.5 5 7.5 10 12.5 15 17.5 20 22.5 25 50 125 250 375 500 625 750 875 1000 1125 1250
TPI	14/18 10/14 8/12 6/10 6/8 5/8 4/6 3/4 2/3 1.5/2.0 1.4/2.0 1.0/1.3 0.7/1.0

ROUND SOLID Locate diameter of cut (D)

DIAMETER OF CUT	
IN	.1 .2 .3 .4 .5 .6 .7 .8 .9 1 2 5 10 15 20 25 30 35 40 45 50
MM	2.5 5 7.5 10 12.5 15 17.5 20 22.5 25 50 125 250 375 500 625 750 875 1000 1125 1250
TPI	14/18 10/14 8/12 6/10 6/8 5/8 4/6 3/4 2/3 1.5/2.0 1.4/2.0 1.0/1.3 0.7/1.0

TUBING/PIPE/STRUCTURALS Locate wall thickness (T)

WALL THICKNESS	
IN	.05 .10 .15 .20 .25 .30 .40 .50 .60 .70 .80 .90 1 1.5 2
MM	1.25 2.5 3.75 5 6.25 7.5 10 12.5 15 17.5 20 22.5 25 37.5 50
TPI	14/18 10/14 8/12 6/10 6/8 5/8 4/6 3/4 2/3

BUNDLED/STACKED MATERIALS:

To select the proper number of teeth per inch (TPI) for bundled or stacked materials, find the recommended TPI for a single piece and choose one pitch coarser to cut the bundle

WHAT IS MERCURIZATION?



This enhanced mechanical design promotes more efficient tooth penetration and chip formation, easily cutting through the work hardened zone. The MERCURIZED symbol denotes any product that can be MERCURIZED. Consult your LENOX Technical Representative to determine if MERCURIZATION will benefit your operation.

