


# 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)



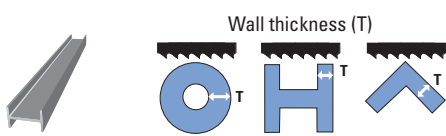
		WIDTH OF CUT																			
<b>IN</b>	.1	.2	.3	.4	.5	.6	.7	.8	.9	1	2	5	10	15	20	25	30	35	40	45	50
<b>MM</b>	2.5	5	7.5	10	12.5	15	17.5	20	22.5	25	50	125	250	375	500	625	750	875	1000	1125	1250
<b>TPI</b>	14/18	10/14	8/12	6/10	6/8	5/8	4/6	3/4	2/3	1.5/2.0	1.4/2.0	1.0/1.3	0.7/1.0								

**ROUND SOLID** Locate diameter of cut (D)




		DIAMETER OF CUT																			
<b>IN</b>	.1	.2	.3	.4	.5	.6	.7	.8	.9	1	2	5	10	15	20	25	30	35	40	45	50
<b>MM</b>	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
<b>TPI</b>	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														
<b>IN</b>	.05	.10	.15	.20	.25	.30	.40	.50	.60	.70	.80	.90	1	1.5	2	
<b>MM</b>	1.25	2.5	3.75	5	6.25	7.5	10	12.5	15	17.5	20	22.5	25	37.5	50	
<b>TPI</b>	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 WAVE TECH?



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

