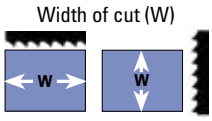
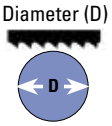
BI-METAL TOOTH SELECTION

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



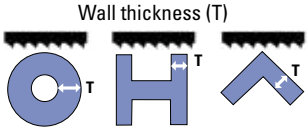
SQUARE/RECTANGLE SOLID Locate width of cut (W)

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

CARBIDE BAND SAWS

CARBIDE TOOTH SELECTION

AEROWOLF™ MAX CT™ • METALWOLF™ CAST MASTER™ • ALLOYWOLF™ VERSA PRO™
ALLOYWOLF™ ARMOR VP™ • AEROWOLF™ GEN-TECH™

WIDTH OR DIAMETER OF CUT														
IN	1	2	3	4	5	6	7	8	10	11	14	16	18	20+
MM	25	50	75	100	125	150	175	200	250	275	350	400	450	500+
									0.9/1.1					
								1.0/1.4						
						1.4/2.0								
	2/3													
	3/4													

METALWOLF™ TRI-MASTER® • METALWOLF™ HRc® • METALWOLF™ CAST MASTER™

WIDTH OR DIAMETER OF CUT										
IN	1	2	3	4	5	6	7	8	10	11
MM	25	50	75	100	125	150	175	200	250	275
			2/3							
		3								
	3/4									

Note: Aluminum and other soft materials cut on machines with extremely high band speed may change your tooth selection.
Please call LENOX Technical Support at 800-642-0010 for more information or go to sawcalc.com.