## TOOTH SELECTION

Band saw tooth pitch (teeth per inch) is determined by the size and type of material to be cut and the desired finish. Select a pitch based on the chart to the right. Find material dimension on chart and move right for appropriate teeth per inch.

Pipe Tubing

For angle, tubing, and pipe - multiply wall thickness by 2-1/2 to determine average width.

## **Cutting Speed – Structurals**

Rule of Thumb: When cutting structurals use a cutting

speed of: 350 S.F.P.M. Wet

200-250 S.F.P.M. Dry

Minimum	Radius per Bla	de Width
Blade Width	Minimum Radius	Materials Thickness 1" / 25mm
1" / 25mm	7-1/4" / 184mm	
3/4" / 19mm	5-7/16" / 138mm	
5/8" / 16mm	3-3/4" / 95mm	
1/2" / 13mm	2-1/2" / 63mm	
3/8" /10mm	1-1/4" / 32mm	
1/4" / 6mm	5/8" / 16mm	-///
3/16" / 5mm	3/8" / 10mm	_ / / /
1/8" / 3mm	7/32" / 5.5mm	<i>—)</i> , ,

	Rectangular Solids: (Use Width)	Round Solids: (Use Diameter)	Structurals: Use Average Width (See Left)
IN. 0 -			[ ]
.1 -	14/18	14/18	14/18
.2 - .3 - .4 - .5 - .6 - .7 - .8 - .9 -	10/14	10/14	10/14
.4 –	8/12	10/14:	8/12
.5 –	W. 4	8/12	$-$ 5/10. $\pm$
.6 –	6/10		5/8
./ -		6/10	3/6
.0 –	5/8		
1 -		5/8	4/6
11/4 -		<u> </u>	4/0
1½ -	4/6	neco es	2 2 20
1¾ – 2 –	1	4/6	
21/4 -			
21/2 -			3/4
2¾ -			
3 -	3/4		
31/4 -			
3½ – 3¾ –		3/4	
3%4 -			
5 -			
4 - 5 - 6 - 7 - 8 -			2/3
7 -	2/3		
		2/3	
9 -			
10 –			