






For angle, tubing, pipe, and other structural shapes, find the wall thickness in size column & move right for tooth size

MATERIAL SIZE (INCHES)	TEETH PER INCH	MATERIAL SIZE (METRIC)	WALL THICKNESS (INCHES)	TEETH PER INCH	WALL THICKNESS (METRIC)
0		0	1/16		1.8
.1	14/18	14/18	1/8	10/14	3.2
.2	10/14		3/16	8/12	4.8
.3	8/12	10/14	1/4	6/10	6.3
.4	8/12		5/16	5/8	7.9
.5	6/10	8/12	3/8		9.5
.6	6/10		7/16		11.0
.7	5/8	6/10	1/2		12.7
.8	5/8		9/16	4/6	14.3
.9		5/8	5/8		15.8
1			11/16		17.5
1-1/4			3/4		19.0
1-1/2	4/6		13/16		20.6
1-3/4		4/6	7/8		22.0
2			15/16	3/4	23.8
2-1/4		4/6	1		25.4
2-1/2			1-1/8		28.6
2-3/4		4/6	1-1/4		32.0
3			1-3/8	2/3	35.0
3-1/4	3/4		1-1/2		38.0
3-1/2		3/4			
3-3/4					
4		3/4			
5					
6	2/3				
7		2/3			
8					
9		2/3			
10	1.4/2.5				
15		1.4/2.5			
30	1/1.5				
		1/1.5			

 **RECTANGULAR SOLIDS:**
(USE WIDTH)
  **ROUND SOLIDS:**
(USE DIAMETER)


PIPETUBINGSTRUCTURALS
 (USE WALL THICKNESS)

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

Cutting speed - Structural Rule of thumb:
When cutting structurals use a cutting speed of 250-325 S.F.M. Wet • 200-250 S.F.M. Dry

BLADE BREAK-IN EXTREMELY IMPORTANT!

The extremely sharp tooth points and edges of new blades must be broken-in before applying full feed pressure to the blade. A good analogy is that of writing with a freshly sharpened wooden pencil.

RECOMMENDED PROCEDURE

- Maintain proper blade speed for the material to be cut.
- Reduce blade feed pressure or feed rate by 50% for the first 50 to 100 square inches of material cut.
- Gradually increase feed pressure or feed rate after break-in to full pressure or rate.