

HOW TO SELECT YOUR BAND SAW BLADES

The following information needs to be specified when a band saw blade is ordered:

For example:	Product Name	Length x Width x Thickness	Teeth Per Inch
	CONTESTOR GT®	16' x 1-1/4" x .042" 4860mm x 34mm x 1.07mm	3/4 TPI

These steps are a guide to selecting the appropriate product for each application:

Step #1 Analyze the sawing application

Machine: For most situations, knowing the blade dimensions (length x width x thickness) is all that is necessary.

Material: Find out the following characteristics of the material to be cut.

- Grade • Hardness (if heat treated or hardened) • Shape • Size
- Is the material to be stacked (bundled) or cut one at a time?

Other Customer Needs: The specifics of the application should be considered.

- Production or utility/general purpose sawing operation?
- What is more important, fast cutting or tool life?
- Is material finish important?

Step #2 Determine which product to use

Use the charts on pages 5, 12, 13 and 20.

- Find the material to be cut in the top row.
- Read down the chart to find which blade is recommended.
- For further assistance, contact LENOX® Technical Support Department at 800-642-0010.

Step #3 Determine the proper number of teeth per inch (TPI)

Use the tooth selection chart on page 22.

- If having difficulty choosing between two pitches, the finer of the two will generally give better performance.
- When compromise is necessary, choose the correct TPI first.

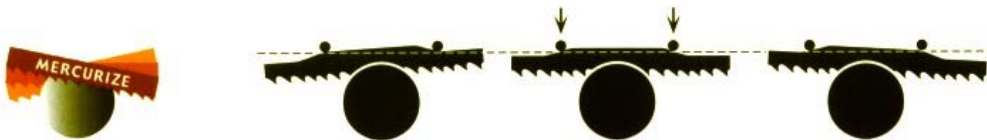
A general rule for bundles: Determine the correct TPI for one piece, and choose one pitch coarser for the bundle.

Step #4 Order LENOX® Sawing Fluids and Lubricants

...for better performance and longer life on any blade.

Step #5 Determine the need for MERCURIZATION

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



Step #6 Install the blade and fluid

Step #7 Break in the blade properly

For break-in recommendations, refer to *SAWCALC*® or contact LENOX® Technical Support 800-642-0010.

Step #8 Run the blade at the correct speed and feed rate

Refer to the Bi-metal and Carbide Speed Charts. For additional speed and feed recommendations, refer to *SAWCALC*® or contact LENOX® Technical Support 800-642-0010.