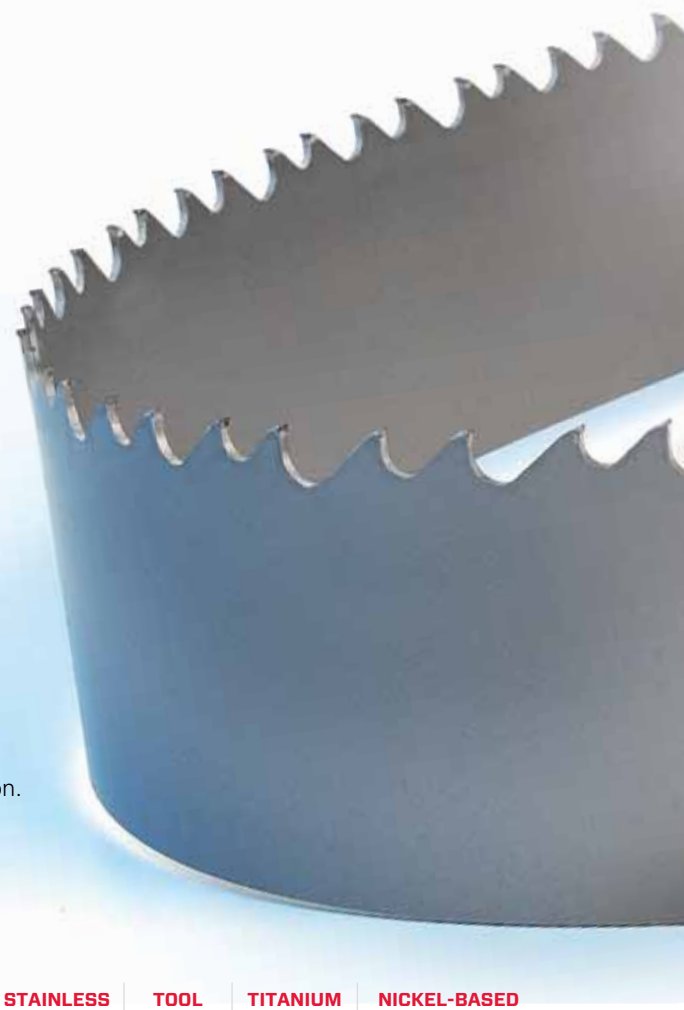
SELECTING CARBIDE TIPPED BAND SAW BLADES

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

PRODUCT NAME LENGTH X WIDTH X THICKNESS TEETH PER INCH

For Example: *ARMOR®* CT BLACK 16' x 1-1/4" x .042" 2.5/3.4 TPI



STEP #1: ANALYZE THE SAWING APPLICATION

Machine: Determine the band size for the machine (Length x Width x Thickness).

Material: Determine the following for the material to be cut:

- Material Type/Grade
- Size
- Shape

Operation: Is this a production, or general purpose sawing operation?

STEP #2: DETERMINE HIGH PERFORMANCE VS. SPECIAL APPLICATION

Use the charts below.

- Locate the type of material to be cut in the top row.
- Read down the chart to find which blade is recommended.

STEP #3: DETERMINE THE PROPER NUMBER OF TEETH PER INCH (TPI)

Use the Carbide Tooth Selection chart on page 15.

If having difficulty choosing between two pitches, the coarser 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 the largest continuous cross section.

STEP #4: CONFIRM THE DESIRED PRODUCT IS AVAILABLE

- Go to the product page for the product you have selected.
- Confirm that product is available in the correct blade width and TPI.

HIGH PERFORMANCE

ALUMINUM/ NON-FERROUS	CARBON STEELS	STRUCTURAL STEELS	ALLOY STEELS	BEARING STEELS	MOLD STEELS	STAINLESS STEELS	TOOL STEELS	TITANIUM ALLOYS	NICKEL-BASED ALLOYS (INCONEL®)
EASY ←				**MACHINABILITY**					→ **DIFFICULT**
	***ARMOR®* CT BLACK** Extreme Cutting Rates								
LENOX *TNT CT®*						**LENOX *TNT CT*** Extreme Performance on Super Alloys			
TRI-TECH CT™			***TRI-TECH CT*** Set Style Blade for Difficult to Cut Metals						
TRI-MASTER®			***TRI-MASTER*** Versatile Carbide Tipped Blade						

SPECIAL APPLICATION

WOOD	COMPOSITES	ALUMINUM (INCLUDING ALUM. CASTINGS)	CASE HARDENED MATERIALS (INCLUDING IHCP CYLINDER SHAFTS)	OTHER (COMPOSITES, TIRES, ETC.)
EASY ←		**MACHINABILITY**		→ **DIFFICULT**
			LENOX *HRc* Carbide Tipped Blade for Case and Through-Hardened Materials	
CAST MASTER™ Superior Performance When Sawing Castings				
TRI-MASTER				
	MASTER-GRIT®		***MASTER-GRIT*** Carbide Grit Edge Blade for Cutting Abrasive and Hardened Materials	

Note: We can provide solutions for many cutting applications not listed here. Please call LENOX *Technical Support at 800-642-0010, or go to sawcalc.com.*

CARBIDE TOOTH SELECTION

VISIT SAWCALC.COM
FOR CUSTOMIZED BAND SAW RECOMMENDATIONS

ARMOR® CT BLACK

WIDTH OR DIAMETER OF CUT														
INCHES	1	2.5	3	4	5	6	7	8	10	12	13	15	17	20+
MM	25	60	70	100	120	150	170	200	250	300	330	380	430	500+
										0.9/1.1 TPI				
									1.4/1.6 TPI					
								1.8/2.0 TPI						
							2.5/3.4 TPI							

LENOX *TNT CT*®

WIDTH OR DIAMETER OF CUT																	
INCHES	1	2.5	3	4	5	6	7	8	10	12	13	15	16	17	18	20	34+
MM	25	60	70	100	120	150	170	200	250	300	330	380	410	430	460	500	865
										0.9/1.1 TPI							
									1.4/1.8 TPI								
								1.8/2.0 TPI									
							2.5/3.4 TPI										

TRI-TECH CT™

WIDTH OR DIAMETER OF CUT														
INCHES	1	2.5	3	4	5	6	7	8	10	12	13	15	17	20+
MM	25	60	70	100	120	150	170	200	250	300	330	380	430	500+
													0.6/0.8 TPI	
												0.9/1.1 TPI		
											1.4/1.8 TPI			
										1.8/2.0 TPI				
									2.5/3.4 TPI					

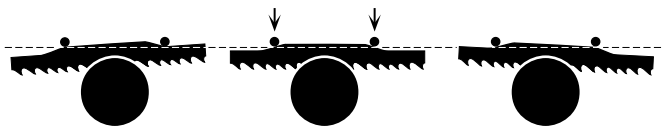
TRI-MASTER® • LENOX *HRC*® • *CAST MASTER*™

WIDTH OR DIAMETER OF CUT														
INCHES	1	2.5	3	4	5	6	7	8	10	12	13	15	17	20
MM	25	60	70	100	120	150	170	200	250	300	330	380	430	500
														1.2/1.8 TPI
													1.5/2.3 TPI	
												2/3 TPI		
											3 TPI			
										3/4 TPI				

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.*

WHAT IS MERCURIZATION?

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



ARMOR® CT BLACK

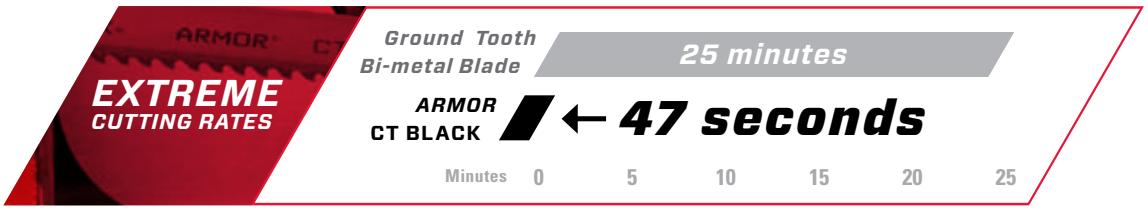
For Extreme Cutting Rates

ARMOR COATING PROVIDES FASTER CUTTING AND HIGHER PRODUCTIVITY
Aluminum, Titanium and Nitrogen (AlTiN) combine to form a tough coating that protects each tooth from heat and wear with an armor-like barrier

EXTENDS BLADE LIFE BY PREVENTING HEAT BUILD UP
Improved, thicker coating now forces even more heat into the chips, instead of the blade or workpiece

HIGH PERFORMANCE BACKING STEEL WITH EXCELLENT FATIGUE LIFE
Optimized heat treat and backing steel preparation minimizes premature band breaks

TAILORED TO CUT A WIDE RANGE OF METALS
High quality, micro grained carbide



Material: 6-1/2" (165mm) Round 17-4 PH Stainless Steel. Based on internal test results.

WIDTH X THICKNESS		TPI			
IN	MM	0.9/1.1	1.4/1.6	1.8/2.0	2.5/3.4
1-1/4 x .042	34 x 1.07			•	•
1-1/2 x .050	41 x 1.27		•	•	•
2 x .063	54 x 1.60	•	•	•	•
2-5/8 x .063	67 x 1.60	•	•		
3 x .063	80 x 1.60	•			

APPLICATION

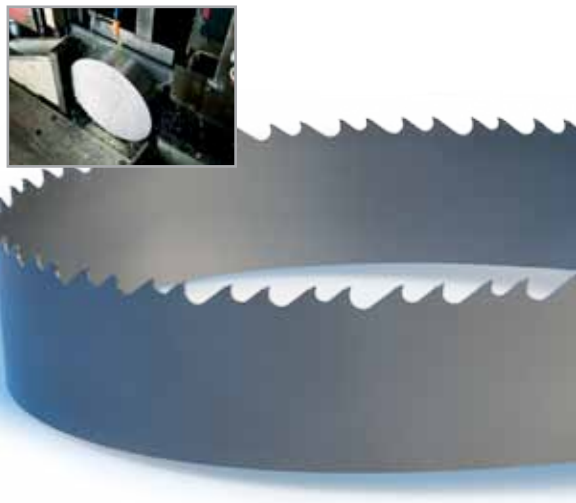
Carbon Steels	Mold Steels
Alloy Steels	Tool Steels
Bearing Steels	Titanium Alloys
Stainless Steels	Structural Steels

LENOX *TNT CT*®

Extreme Performance on Super Alloys

HIGH PERFORMANCE CARBIDE AND SPECIAL GROUND TOOTH FORM
Superior wear resistance when sawing difficult to cut materials

HIGH PERFORMANCE BACKING STEEL
Excellent fatigue life



WIDTH X THICKNESS		TPI			
IN	MM	0.9/1.1	1.4/1.8	1.8/2.0	2.5/3.4
1-1/4 x .042	34 x 1.07			•	•
1-1/2 x .050	41 x 1.27	•	•	•	•
2 x .063	54 x 1.60	•	•	•	•
2-5/8 x .063	67 x 1.60	•		•	
3 x .063	80 x 1.60	•			

APPLICATION

- Nickel-Based Alloys (Inconel®)
- Stainless Steels
- Tool Steels
- Titanium Alloys
- Aluminum/ Non-Ferrous

TRI-TECH CT™

Set Style Carbide Blade for Difficult to Cut Metals

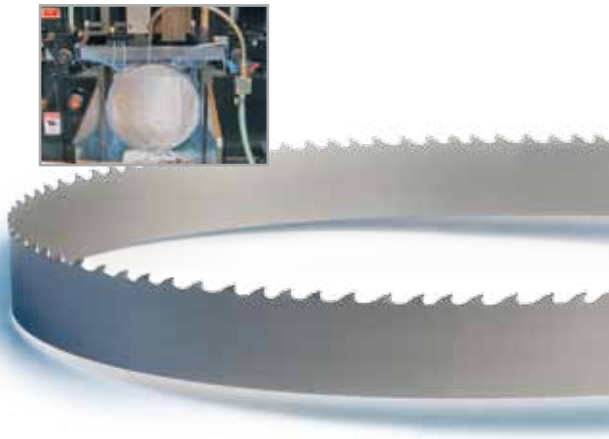
STRAIGHT CUTS. NO PINCHING.
Set style tooth pattern eliminates pinching in high stress metals

Wide kerf clearance enables plunge cutting

PROLONGED BLADE LIFE
High grade carbide tips are precision ground for efficient cutting

High performance backing steel minimizes body breakage

EXTREME VERSATILITY
Cuts a range of materials from high strength steels to Nickel-based alloys



WIDTH X THICKNESS		TPI				
IN	MM	0.6/0.8	0.9/1.1	1.4/1.8	1.8/2.0	2.5/3.4
1-1/4 x .042	34 x 1.07				•	•
1-1/2 x .050	41 x 1.27			•	•	•
2 x .063	54 x 1.60		•	•	•	•
2-5/8 x .063	67 x 1.60	•	•	•		
3 x .063	80 x 1.60	•	•			

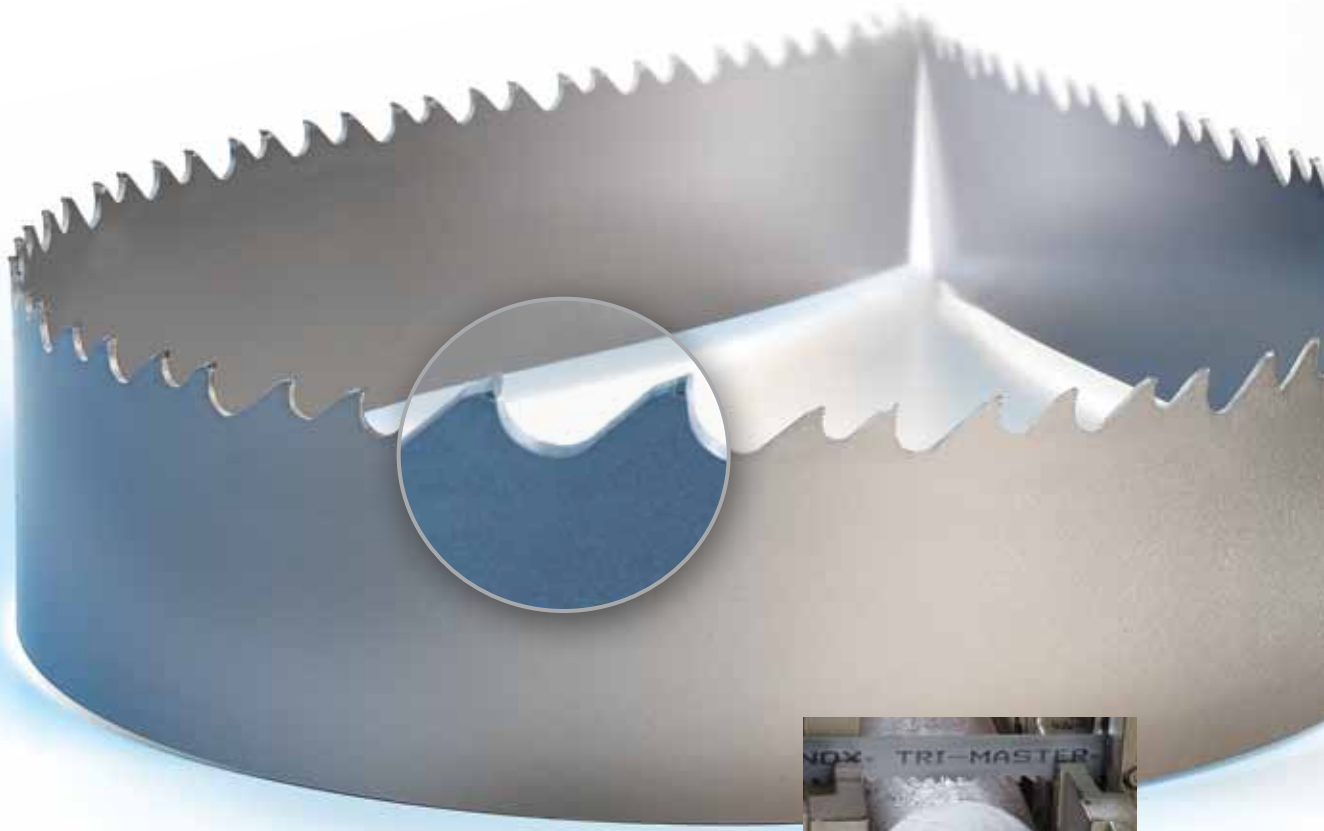
APPLICATION

- Nickel-based Alloys (Inconel®)
- Iron Based Super Alloys
- Titanium Alloys
- High Chrome Alloys
- Stainless Steel
- Mold and Tool Steels
- Aluminum/ Non-Ferrous

LENOX®

TRI-MASTER®

Versatile Carbide Tipped Blade



PRECISION TRIPLE CHIP GRIND
Smooth cuts, excellent finish

HIGH PERFORMANCE BACKING STEEL
Excellent fatigue life

GENERAL PURPOSE BLADE
Perfect for cutting of a wide variety of materials

WIDTH X THICKNESS		TPI				STANDARD TPI
IN	MM	1.2/1.8	1.5/2.3	2/3	3/4	3
3/8 x .032	9.5 x 0.80				•	•
1/2 x .025	12.7 x 0.64					•
3/4 x .035	19 x 0.90					•
1 x .035	27 x 0.90			•	•	•
1-1/4 x .042	34 x 1.07		•	•	•	•
1-1/2 x .050	41 x 1.27	•		•	•	•
2 x .063	54 x 1.60	•		•		
2-5/8 x .063	67 x 1.60	•				
3 x .063	80 x 1.60	•				

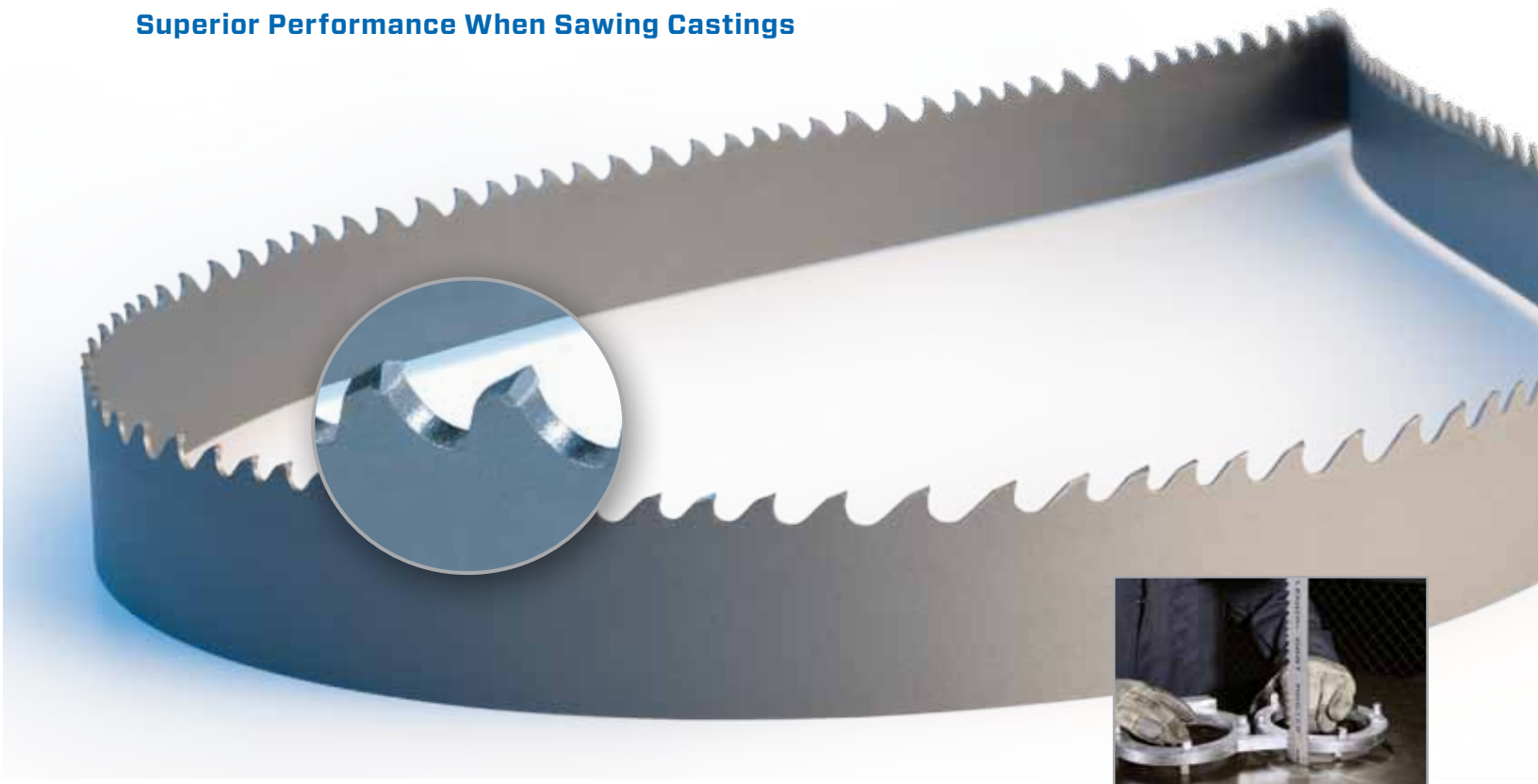
MERCURIZED

APPLICATION

Aluminum/ Non-Ferrous	Mold Steels
Carbon Steels	Tool Steels
Alloy Steels	Wood
Bearing Steels	Titanium Alloys
Stainless Steels	Nickel-Based Alloys (Inconel®)

CAST MASTER™

Superior Performance When Sawing Castings



EXCEPTIONAL BLADE LIFE IN HAND FED FOUNDRY APPLICATIONS
Sub-micron grade carbide designed for cutting aluminum and non-ferrous parts

Precision grind on the rake face prevents material build up on the tooth edge

CUTS PARTS FREELY WITH LIMITED FEED PRESSURE
Optimized rake angle and narrow kerf enable high speed cutting without pulling the part

Multi-chip tooth design reduces cutting forces and limits vibration

HIGH ALLOY BACKING STEEL INCREASES FATIGUE LIFE
Advanced backing steel preparation minimizes band breaks

WIDTH X THICKNESS		TPI			
IN	MM	2	2/3	3	3/4
1/2 x .025	12.7 x 0.64			•	
3/4 x .035	19 x 0.90			• *	•
1 x .035	27 x 0.90		•	• *	•
1-1/4 x .042	34 x 1.07	•	•	•	•
1-1/2 x .050	41 x 1.27		•		

• Multi-chip Design
* Set Style (Cast Master SST)

APPLICATION

Aluminum/ Non-Ferrous	Wood
Castings	Composites
Gates & Risers	

LENOX

LENOX *HRc*®

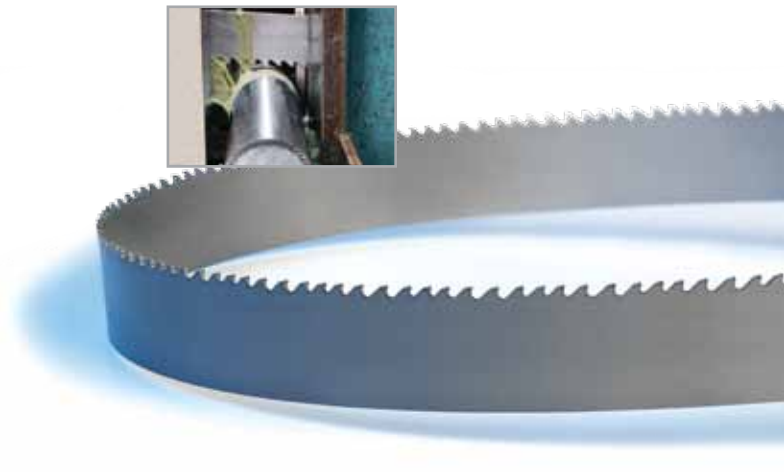
Carbide Tipped Blade for Case and Through-Hardened Materials

HIGH QUALITY, MICRO-GRAINED CARBIDE
Outstanding durability

STRONG TOOTH DESIGN
Superior edge strength and strip resistance

NEW HIGH PERFORMANCE BACKING STEEL
Excellent fatigue life

REPLACES ABRASIVE CUT OFF OPERATIONS



WIDTH X THICKNESS		*VARI-TOOTH*® TPI		STANDARD TPI
IN	MM	2/3	3/4	3
1 x .035	27 x 0.90			•
1-1/4 x .042	34 x 1.07		•	•
1-1/2 x .050	41 x 1.27		•	
2 x .063	54 x 1.60	•		

APPLICATION

Carbon Steels
Stainless Steels
Case Hardened Materials

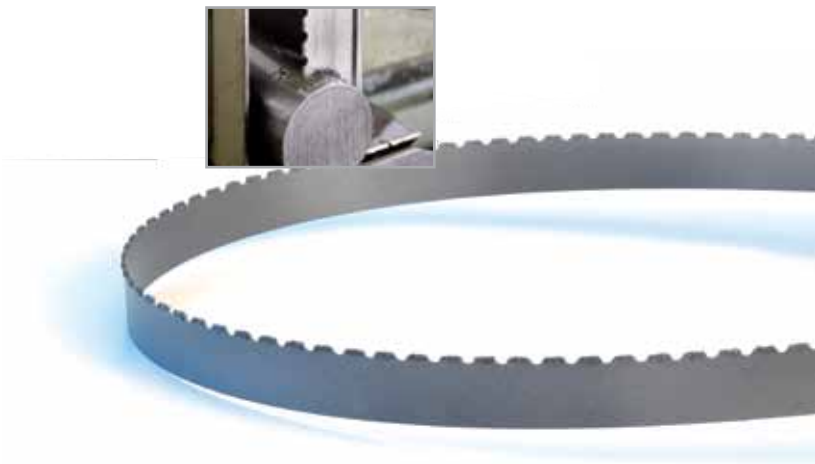
MASTER-GRIT®

Carbide Grit Edge Blade for Cutting Abrasive and Hardened Materials

TUNGSTEN CARBIDE PARTICLE GRIT
Metallurgically bonded edge

GULLETED
For applications greater than 1/4"(6.4mm) in cross-section

CONTINUOUS
For applications less than 1/4"(6.4mm) in cross-section

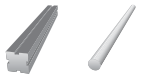


		GRIT EDGE PREPARATION				
WIDTH X THICKNESS		GULLETED			CONTINUOUS	
IN	MM	MED	MED COARSE	COARSE	MED	COARSE
1/4 x .020	6.4 x 0.50				•	
3/8 x .025	9.5 x 0.64	•	•			
1/2 x .025	12.7 x 0.64	•	•		•	
3/4 x .032	19 x 0.80		•	•		
1 x .035	27 x 0.90		•	•	•	•
1-1/4 x .042	34 x 1.07			•		

APPLICATION

Case Hardened Materials

Other: Fiberglass, Steel Belted Radial Tires, Composites



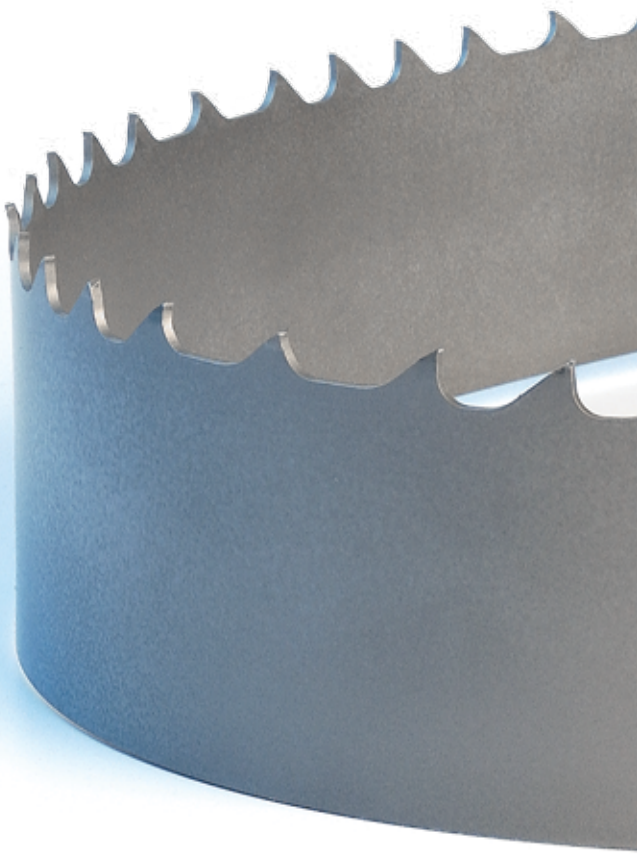
CARBIDE SPEED CHART

VISIT SAWCALC.COM
FOR CUSTOMIZED BAND SAW RECOMMENDATIONS

MATERIALS		ARMOR® CT BLACK		LENOX TNT CT®		TRI-TECH™		TRI-MASTER®		CAST MASTER™		LENOX HRc®	
TYPE	GRADE	FPM	MPM	FPM	MPM	FPM	MPM	FPM	MPM	FPM	MPM	FPM	MPM
Aluminum Alloys	2024, 5052, 6061, 7075			3,500–8,500*	1000–2600	3,500 - 8,500	1,000 - 2,600	3,500–8,500*	1000–2600	3,500–8,500*	1000–2600		
Copper Alloys	CDA 220 CDA 360 Cu Ni (30%) Be Cu			240 300 220 180	75 90 65 55	240 300 220 180	73 91 67 55	210 295 200 160	65 90 60 50	210 295 200 160	65 90 60 50	280	85
Bronze Alloys	AMPCO 18 AMPCO 21 AMPCO 25 Leaded Tin Bronze Al Bronze 865 Mn Bronze 932 937			205 180 115 300 200 220 300 300	60 55 35 90 60 65 90 90	205 180 115 300 180 220 300 300	62 55 35 91 55 67 91 91	180 160 110 290 150 215 280 250	55 50 35 90 45 65 85 75	180 160 110 290 150 215 280 250	55 50 35 90 45 65 85 75		
Brass Alloys	Cartridge Brass Red Brass (85%) Naval Brass			260 230	80 70	240 230	73 70	220 200	65 60			220 200	65 60
Leaded, Free Machining Low Carbon Steels	1145 1215 12L14	370 425 450	115 130 135			290 325 350	88 99 107	290 325 350	90 100 105				
Structural Steel	A36	350	105										
Low Carbon Steels	1008, 1018 1030	310 290	95 90			250 240	76 73	250 240	75 75			270** 250**	80 75
Medium Carbon Steels	1035 1045	285 275	85 85			230 220	70 67	230 220	70 65			240** 230**	75 70
High Carbon Steels	1060 1080 1095	260 250 240	80 75 75									200** 195** 185**	60 60 55
Mn Steels	1541 1524	260 240	80 75										
Cr-Mo Steels	4140 41L50 4150H	300 310 290	90 95 90			220 250	67 76						
Cr Alloy Steels	6150 52100 5160	315 300 315	95 90 95			190 190	58 58						
Ni-Cr-Mo Steels	4340 8620 8640 E9310	300 310 305 315	90 95 95 95			190 190	58 58						
Low Alloy Tool Steel	L-6	300	90	240	75	240	73	190	60				
Water-Hardening Tool Steel	W-1	300	90	240	65	220	67	175	55				
Cold-Work Tool Steel	D-2	240	75	210	65	210	64	170	50				
Air-Hardening Tool Steels	A-2 A-6 A-10	270 240 190	80 75 60	230 220 160	70 65 50	230 220 160	70 67 49	185 175 130	55 55 40				
Hot Work Tool Steels	H-13 H-25	240 180	75 55	220 150	55 45	220 150	67 46	175 120	55 35				
Oil-Hardening Tool Steels	O-1 O-2	260 240	80 75	240 220	75 65	240 220	73 67	190 175	60 55				
High Speed Tool Steels	M-2, M-10 M-4, M-42 T-1 T-15	140 130 120 100	45 40 35 30	110 105 100 80	35 30 30 25	110 105 100 80	34 32 30 24	90 85 80 65	25 25 25 20				
Mold Steels	P-3 P-20	300 280	90 85	200 160	60 50	200 160	61 49	160 130	50 40				
Shock Resistant Tool Steels	S-1 S-5, S-7	220 200	65 60										
Stainless Steels	304 316 410,420 440A 440C	260 240 290 250 240	80 75 90 75 75	220 180 250 200 200	65 55 75 60 60	190 180 250 200 200	58 55 76 61 61	155 125 175 140 140	45 40 55 45 45			220 180 250 200 200	65 55 75 60 60
Precipitation Hardening Stainless Steels	17-4 PH 15-5 PH	300 300	90 90	160 140	50 45	160 160	49 49	110 100	35 30			160 140	50 45
Free Machining Stainless Steels	420F 301	340 320	105 100	270 230	80 70	270 230	82 70	190 160	60 50			270 230	80 70
Nickel Alloys	Monel® K-500 Duranickel® 301			90 80	25 25	90 80	27 24	90 80	25 25				
Iron-Based Super Alloys	A286, Incoloy® 825 Incoloy 600 Pyromet® X-15			80 75 90	25 25 25	105 85 90	32 26 27	80 75 90	25 25 25				
Nickel-Based Alloys	Inconel® 600, Inconel 718 Nimonic® 90 NI-SPAN-C® 902, RENE® 41 Inconel® 625 Hastalloy B, Waspalloy Nimonic® 75, RENE® 88			85 85 115 75 75	25 25 35 25 25	105 100 105 105 100 105	32 30 32 32 30 32	85 85 115 75 75	25 25 35 25 25				
Titanium Alloys	CP Titanium Ti-6A1-4V	230 230	70 70	180 180	55 55	180 180	55 55	150 150	45 45				
Cast Irons	A536 (60-40-18) A536 (120-90-02) A48 (Class 20) A48 (Class 40) A48 (Class 60)	360 175 250 160 115	110 55 75 50 35										

FPM = Feet Per Minute | MPM = Meters Per Minute **For metal cutting saws run between 275 and 350 FPM. **Typically for hardened and case hardened carbon steels up to 61 Rc.*

SELECTING BI-METAL BAND SAW BLADES



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

PRODUCT NAME LENGTH X WIDTH X THICKNESS TEETH PER INCH

For Example: *Contestor GT®* 16' x 1-1/4" x .042" 3/4 TPI

STEP #1: ANALYZE THE SAWING APPLICATION

Machine: Determine the band size for the machine (Length x Width x Thickness).

Material: Determine the following for the material to be cut:

- Material Type/Grade
- Size
- Shape
- Will material be stacked/bundled, or cut one at a time?

Operation: Is this a production, or general purpose sawing operation?

STEP #2: DETERMINE THE BEST PRODUCT FOR THE APPLICATION

Use the charts below.

- Locate the type of material to be cut in the top row.
- Read down the chart to find which blade is recommended.

STEP #3: DETERMINE THE PROPER NUMBER OF TEETH PER INCH (TPI)

- Use the Bi-metal Tooth Selection chart on page 25.

STEP #4: CONFIRM THE DESIRED PRODUCT IS AVAILABLE

- Go to the product page for the product you have selected.
- Confirm that product is available in the correct blade width and TPI.

FOR ASSISTANCE, CONTACT LENOX TECHNICAL SUPPORT 800-642-0010.

PRODUCTION SAWING

ALUMINUM NON-FERROUS	CARBON STEELS	STRUCTURAL STEELS	ALLOY STEELS	BEARING STEELS	MOLD STEELS	TOOL STEELS	STAINLESS STEELS	TITANIUM ALLOYS	NICKEL-BASED ALLOYS (INCONEL®)
EASY ←			MACHINABILITY					→	DIFFICULT
Qxp™			***Qxp*** Long Life. Fast Cutting						
					CONTESTOR GT® Long Life. Straight Cuts				
	ARMOR® Rx®+ Long Life. Structurals/Bundles								
	LENOX *Rx®+* Structurals/Bundles								
CLASSIC PRO™ Long Life. Extremely Versatile						***CLASSIC PRO***			

GENERAL PURPOSE

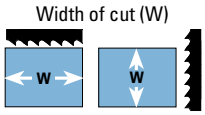
LENOX *CLASSIC®* 3/4" and Wider Blades	**LENOX *CLASSIC***
DIEMASTER 2® 1/2" and Narrower Blades	***DIEMASTER 2***

Note: We can provide solutions for many cutting applications not listed here. Please call LENOX *Technical Support at 800-642-0010, or go to sawcalc.com.*

BI-METAL TOOTH SELECTION

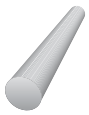
VISIT SAWCALC.COM
FOR CUSTOMIZED BAND SAW RECOMMENDATIONS

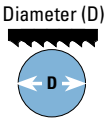
1. Determine the size and shape of material to be cut.
2. Identify the chart to be used (square solids, round solids, or tubing/structurals).
3. Read teeth per inch next to material size.



SQUARE/RECTANGLE SOLID Locate width of cut (W)

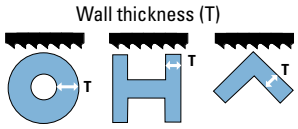
WIDTH OF CUT																								
IN	.1	.2	.3	.4	.5	.6	.7	.8	.9	1	2	5	10	15	20	25	30	35	40	45	50			
MM	2.5	5	7.5	10	12.5	15	17.5	20	22.5	25	50	125	250	375	500	625	750	875	1000	1125	1250			
TPI	14/18		10/14		8/12		6/10		6/8 5/8		4/6		3/4	2/3	1.5/2.0 1.4/2.0		1.0/1.3			0.7/1.0				





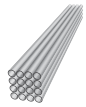
ROUND SOLID Locate diameter of cut (D)

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					

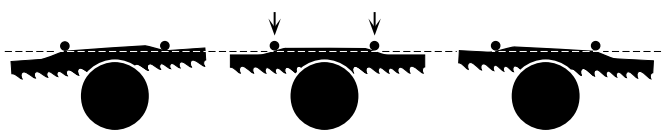


BUNDLED/STACKED MATERIALS:

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

WHAT IS MERCURIZATION?

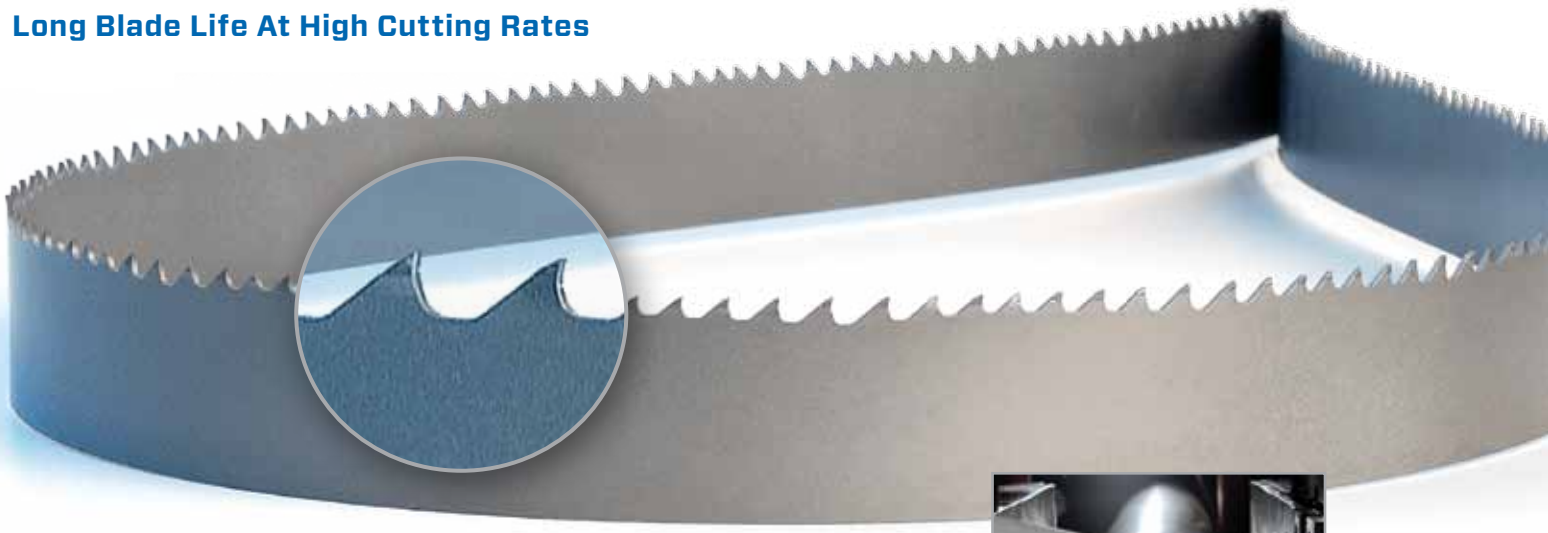
This enhanced mechanical design promotes more efficient tooth penetration and chip formation, easily cutting through the work hardened zone. The MERCURIZED symbol denotes any product that can be MERCURIZED. Consult your LENOX Technical Representative to determine if MERCURIZATION will benefit your operation.



LENOX

QXP™

Long Blade Life At High Cutting Rates



LONG LIFE. FAST CUTTING
Solids of mild to moderate machinability

Proprietary backing steel preparation provides increased fatigue life

PENETRATES WITH LESS FEED FORCE
Extreme positive rake tooth form

INCREASED CUTTING RATES
Deep gullet design

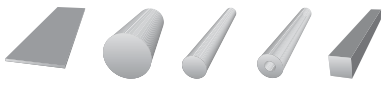
WIDTH X THICKNESS		TPI					
IN	MM	1.0/1.3	1.5/2.0	2/3	3/4	4/6	5/8
3/4 x .035	19 x 0.90					◆	
1 x .035	27 x 0.90			◆	◆	◆	◆
1-1/4 x .042	34 x 1.07		◆	◆	◆	◆	◆
1-1/2 x .050	41 x 1.27		◆	◆	◆	◆	
2 x .063	54 x 1.60	◆	◆	◆	◆	◆	
2-5/8 x .063	67 x 1.60	◆	◆	◆			
3 x .063	80 x 1.60	◆					

◆ LENOX *LXP*® spec

MERCURIZED

APPLICATION

Aluminum/ Non-Ferrous	Bearing Steels
Carbon Steels	Mold Steels
Alloy Steels	Stainless Steels
	Tool Steels



FOR LONG BLADE LIFE

Q PERFORMANCE SOLUTION™

LONG LIFE. SMOOTH CUTTING.
BLADE AFTER BLADE. GUARANTEED.*

*The recommended Q Performance Solution Blade will outperform your current product or your money back. Contact your LENOX Technical Sales Representative for more information.

CONTESTOR GT®

High Performance Sawing

STRAIGHTER CUTS ON LARGER, DIFFICULT TO CUT MATERIALS
Unique gullet design for increased beam strength

OPTIMUM CHIP FORMATION IN WORK HARDENING ALLOYS
Precision ground teeth—smoother tooth face and gullet surfaces

Patented special set and tooth profile

IMPROVED LIFE WITH OPTIONAL M-51 EDGE MATERIAL
Increased heat and wear resistance

Available as listed below

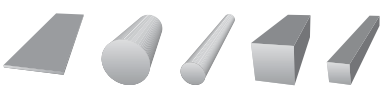
WIDTH X THICKNESS		TPI					
IN	MM	0.7/1.0	1.0/1.3	1.4/2.0	2/3	3/4	4/6
1 x .035	27 x 0.90				•	•	•
1-1/4 x .042	34 x 1.07			◆	◆	◆	◆
1-1/2 x .050	41 x 1.27			◆	◆■	◆■	◆
2 x .050	54 x 1.27		◆	◆	◆		
2 x .063	54 x 1.60	◆	◆	◆	◆■	◆	
2-5/8 x .063	67 x 1.60	◆	◆■	◆■	◆		
3 x .063	80 x 1.60	◆	◆	◆			

• = Milled tooth
◆ = Ground tooth
■ = Available with M-51 edge

MERCURIZED

APPLICATION

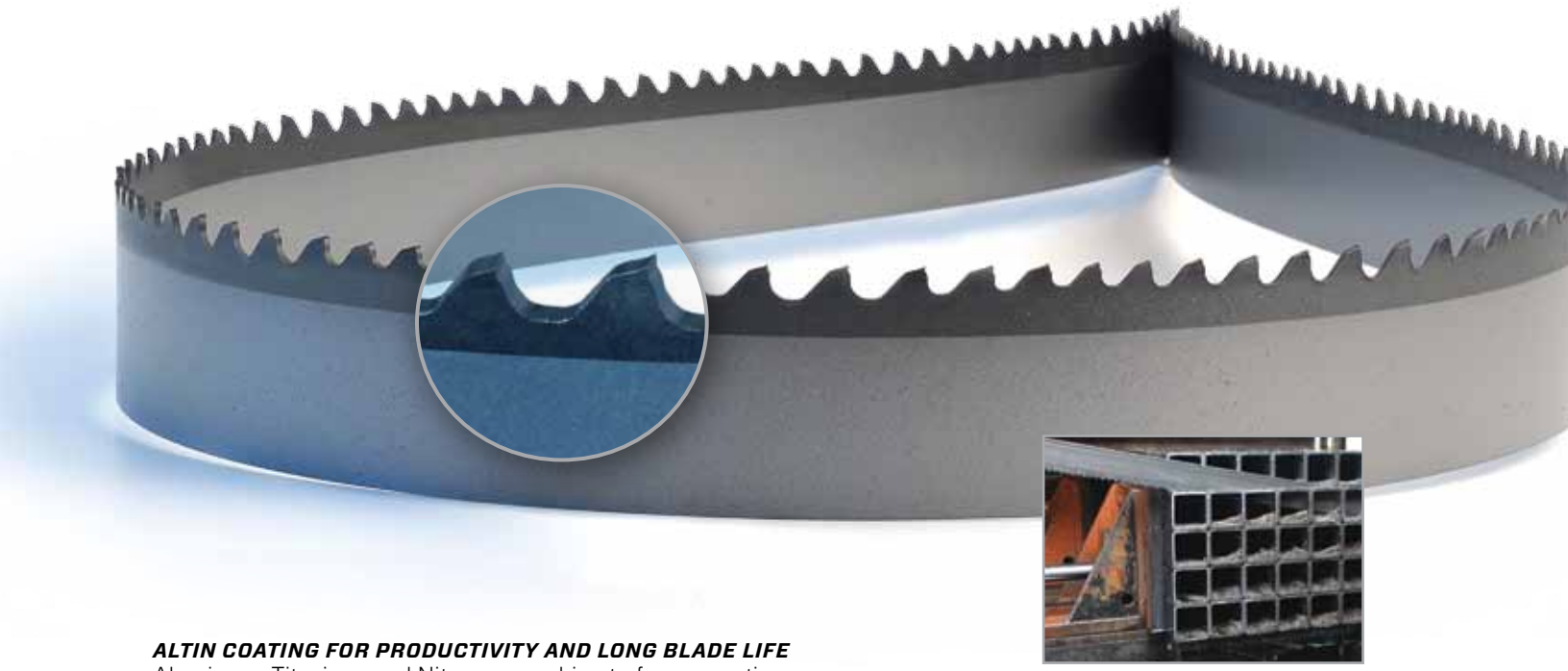
Mold Steels
Stainless Steels
Tool Steels
Titanium Alloys
Nickel-Based Alloys (Inconel®)



LENOX

ARMOR RX®†

Engineered for Long Life



ALTIN COATING FOR PRODUCTIVITY AND LONG BLADE LIFE
Aluminum, Titanium, and Nitrogen combine to form a coating that is hard and tough, protecting each tooth from heat and wear with an armor-like barrier

UNIQUE, PATENTED TOOTH PROFILE
Special, reinforced tooth design for reduced tooth strippage at higher feed rates

Minimized harmonics and vibrations

Quiet cutting

HIGH PERFORMANCE BACKING STEEL
For longer fatigue life

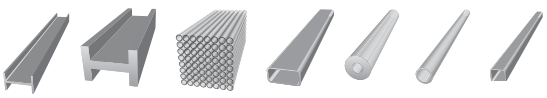
WIDTH X THICKNESS		TPI		
IN	MM	2/3	3/4	4/6
1-1/4 x .042	34 x 1.07		◆†	◆
1-1/2 x .050	41 x 1.27	◆	◆†	◆†
2 x .063	54 x 1.60	◆	◆†	

†= Extra heavy set available to prevent blade pinching

APPLICATION

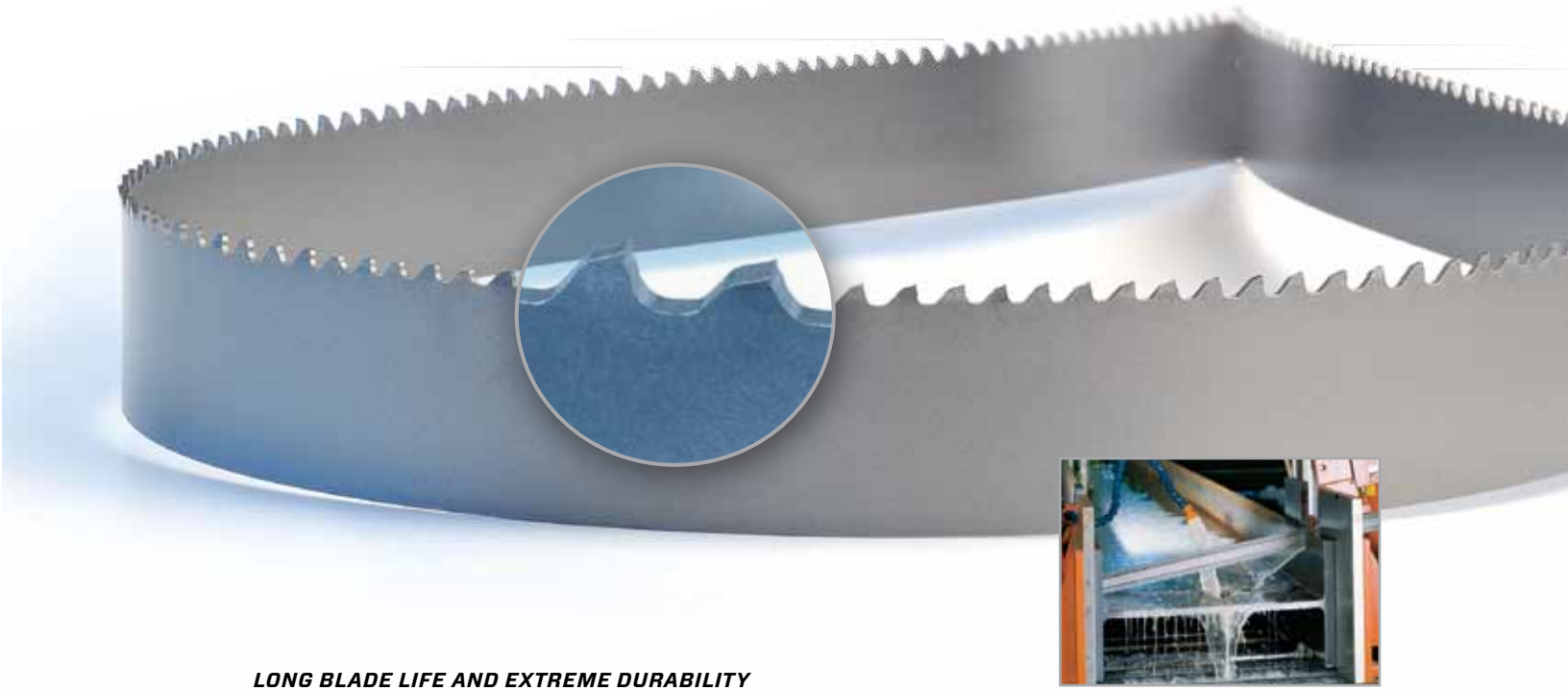
Carbon Steels

Structural Steels



LENOX *RX*®+

Engineered to Cut Structurals, Tubing and Bundles



LONG BLADE LIFE AND EXTREME DURABILITY
Patented tooth profile resists tooth strippage, even at higher feed rates

QUIET CUTTING, REDUCED VIBRATION
Optimized tooth pitch/set sequence

WIDTH X THICKNESS		TPI				
IN	MM	2/3	3/4	4/6	5/8	10/14
5/8 x .032	16 x 0.80					*
3/4 x .035	19 x 0.90			◆	◆	
1 x .035	27 x 0.90	◆	◆	◆	◆	
1-1/4 x .042	34 x 1.07	◆†	◆†	◆†	◆	
1-1/2 x .050	41 x 1.27	◆†	◆†	◆†	◆	
2 x .050	54 x 1.27	◆	◆†	◆	◆	
2 x .063	54 x 1.60	◆†	◆†	◆		
2-5/8 x .063	67 x 1.60	◆†	◆†	◆		

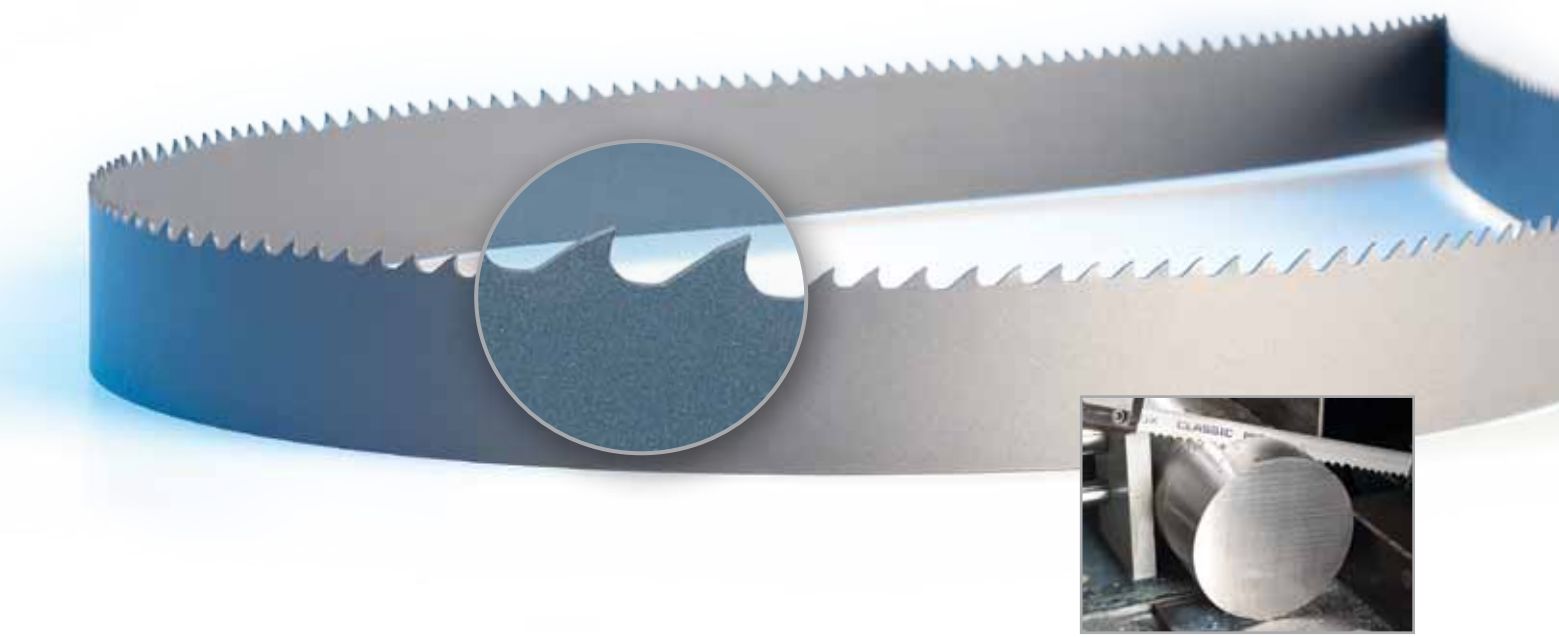
*= Matrix edge
†= Extra heavy set available to prevent blade pinching

APPLICATION

Carbon Steels
Structural Steels

LENOX *CLASSIC PRO*™

The Ultimate Multi-Purpose Blade for Production Cutting



EXCEPTIONAL BLADE LIFE

Proprietary backing steel preparation increases fatigue life and minimizes band breaks

Robust M-42 high speed steel edge provides superior heat and wear resistance

EXTREMELY VERSATILE

Cuts a wide range of metals from low carbon steels to higher strength alloys

Advanced design enables production cutting of solids and structurals

Positive rake angle improves tooth penetration on saws with limited feed force

CONSISTENT PERFORMANCE CUT AFTER CUT

Unique tooth geometry and set minimizes noise and vibration from the very first cut

Smooth, straight cuts when cutting multiple pieces or wide cross sections

WIDTH X THICKNESS		TPI				
IN	MM	1.4/2.0	2/3	3/4	4/6	5/8
1 x .035	27 x 0.90		◆	◆†	◆	◆
1-1/4 x .042	34 x 1.07	◆	◆	◆†	◆	◆
1-1/2 x .050	41 x 1.27	◆	◆	◆†	◆	◆
2 x .050	54 x 1.27		◆	◆	◆	
2 x .063	54 x 1.60	◆	◆†	◆†	◆	
2-5/8 x .063	67 x 1.60	◆	◆†	◆†		

† = Extra heavy set available to prevent blade pinching

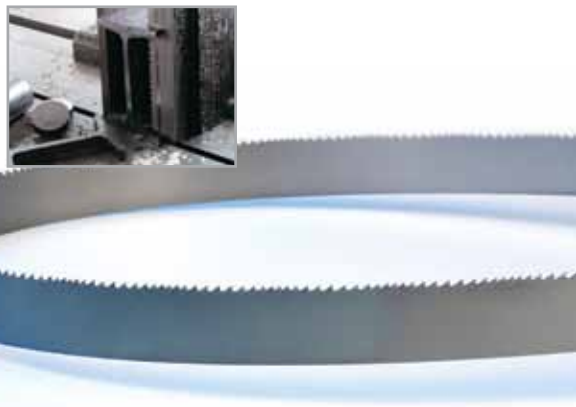
APPLICATION

Carbon Steels	Stainless Steels
Alloy Steels	Tool Steels
Mold Steels	Structural Steels

Aluminum/Non Ferrous

LENOX *CLASSIC*®

The Ultimate Multi-Purpose Blade



DESIGNED FOR LONG LIFE IN GENERAL PURPOSE CUTTING APPLICATIONS

Patented *TUFF TOOTH*™ design reduces tooth strippage

M-42 high speed steel edge for excellent heat and wear resistance

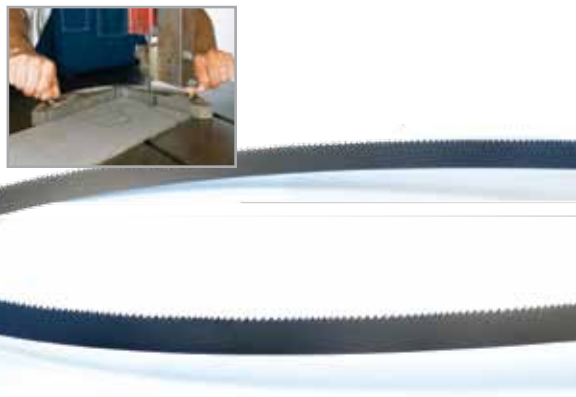
WIDTH X THICKNESS		TOOTH FORM: *TUFF TOOTH*™ TPI		*VARI-TOOTH*™ TPI				WAVY TPI		HOOK TPI
IN	MM	4/6	6/8	5/8	6/10	8/12	10/14	14	18	3
3/4 x .035	19 x 0.90	◆	◆	◆	◆	◆	◆	◆	◆	◆
1 x .035	27 x 0.90	◆	◆	◆	◆	◆	◆		◆	
1-1/4 x .042	34 x 1.07	◆	◆	◆	◆	◆				

APPLICATION

- Aluminum/ Non-Ferrous
- Carbon Steels
- Structural Steels
- Alloy Steels
- Stainless Steels
- Tool Steels

DIEMASTER 2®

Engineered for Contour Cutting



FASTER CUTTING WITH M-42 HIGH SPEED STEEL TOOTH EDGE

Runs at twice the speed of carbon blades for faster, easier cutting

LONGER BLADE LIFE

Lasts 10 times longer than carbon blades

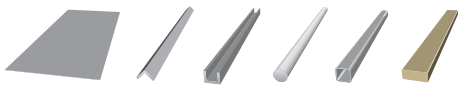
FOR GENERAL PURPOSE HAND-FED APPLICATIONS

Tool and die shops, machine shops, maintenance facilities

WIDTH X THICKNESS		TOOTH FORM: *VARI-TOOTH*™ TPI				STANDARD TPI				HOOK TPI		
IN	MM	6/10	8/12	10/14	14/18	10	14	18	24	3	4	6
1/4 x .025	6.4 x 0.64			◆	◆							◆
1/4 x .035	6.4 x 0.90			◆								◆
3/8 x .025	9.5 x 0.64			◆	◆							
3/8 x .035	9.5 x 0.90					◆					◆	◆
1/2 x .020	12.7 x 0.50			*	*		*	*	*			
1/2 x .025	12.7 x 0.64	◆	◆	◆	◆		◆	◆			◆	◆
1/2 x .035	12.7 x 0.90					◆	◆			◆	◆	◆

APPLICATION

- Aluminum/ Non-Ferrous
- Carbon Steels
- Structural Steels
- Alloy Steels
- Stainless Steels
- Tool Steels
- Wood



* = Matrix edge

LENOX

BI-METAL SPEED CHART

VISIT SAWCALC.COM
FOR CUSTOMIZED BAND SAW RECOMMENDATIONS

	MATERIALS		BAND SPEED	
	TYPE	GRADE	FEET/ MIN	METER/ MIN
ALUMINUM / NON-FERROUS	Aluminum Alloys	2024, 5052, 6061, 7075	300+	85+
	Copper Alloys	CDA 220 CDA 360 Cu Ni (30%) Be Cu	210 295 200 160	65 90 60 50
	Bronze Alloys	AMPCO 18 AMPCO 21 AMPCO 25 Leaded Tin Bronze Al Bronze 865 Mn Bronze 932 937	180 160 110 290 150 215 280 250	55 50 35 90 45 65 85 75
	Brass Alloys	Cartridge Brass, Red Brass (85%) Naval Brass	220 200	65 60
CARBON STEELS	Leaded, Free Machining Low Carbon Steels	1145 1215 12L14	270 325 350	80 100 105
	Low Carbon Steels	1008, 1018 1030	270 250	80 75
	Medium Carbon Steels	1035 1045	240 230	75 70
	High Carbon Steels	1060 1080 1095	200 195 185	60 60 55
STRUCTURAL STEEL	Structural Steel	A36	250	75
ALLOY STEEL	Mn Steels	1541 1524	200 170	60 50
	Cr-Mo Steels	4140 41L50 4150H	225 235 200	70 70 60
	Cr Alloy Steels	6150 5160	190 195	60 60
	Ni-Cr-Mo Steels	4340 8620 8640 E9310	195 215 185 160	60 65 55 50
BEARING STEEL	Cr Alloy Steels	52100	160	50
MOLD STEEL	Mold Steels	P-3 P-20	180 165	55 50
STAINLESS STEEL	Stainless Steels	304 316 410, 420 440A 440C	115 90 135 80 70	35 25 40 25 20
	Precipitation Hardening Stainless Steels	17-4 PH 15-5 PH	70 70	20 20
	Free Machining Stainless Steels	420F 301	150 125	45 40
TOOL STEEL	Low Alloy Tool Steel	L-6	145	45
	Water-Hardening Tool Steel	W-1	145	45
	Cold-Work Tool Steel	D-2	90	25
	Air-Hardening Tool Steels	A-2 A-6 A-10	150 135 100	45 40 30
	Hot Work Tool Steels	H-13 H-25	140 90	40 25
	Oil-Hardening Tool Steels	O-1 O-2	140 135	40 40
	High Speed Tool Steels	M-2, M-10 M-4, M-42 T-1 T-15	105 95 90 60	30 30 25 20
	Shock Resistant Tool Steels	S-1 S-5, S-7	140 125	40 40
TITANIUM ALLOY	Titanium Alloys	CP Titanium Ti-6Al-4V	85 65	25 20
NICKEL BASED ALLOY	Nickel Alloys	Monel® K-500 Duranickel 301	70 55	20 15
	Iron-Based Super Alloys	A286, Incoloy® 825 Incoloy® 600 Pyromet X-15	80 55 70	25 15 20
	Nickel-Based Alloys	Inconel® 600, Inconel® 718, Nimonic 90, NI-SPAN-C 902, RENE 41 Inconel® 625 Hastalloy B, Waspalloy Nimonic 75, RENE 88	60 60 80 55 50	20 20 25 15 15
OTHER	Cast Irons	A536 (60-40-18) A536 (120-90-02) A48 (Class 20) A48 (Class 40) A48 (Class 60)	225 110 160 115 95	70 35 50 35 30

The Speed Chart recommendations apply when cutting 4" wide (100mm), annealed material with a bi-metal blade and flood sawing fluid:

ADJUST BAND SPEED FOR DIFFERENT SIZED MATERIALS

MATERIAL	BAND SPEED
1/4" (6mm)	Chart Speed + 15%
3/4" (19mm)	Chart Speed + 12%
1-1/4" (32mm)	Chart Speed + 10%
2-1/2" (64mm)	Chart Speed + 5%
4" (100mm)	Chart Speed - 0%
8" (200mm)	Chart Speed - 12%

ADJUST BAND SPEED FOR DIFFERENT FLUID TYPES

FLUID TYPES	BAND SPEED
Spray lube	Chart Speed - 15%
No fluid	Chart Speed - 30–50%

ADJUST BAND SPEED FOR HEAT TREATED MATERIALS

ROCKWELL	BRINELL	DECREASE BAND SPEED
Up to 20	226	-0%
22	237	-5%
24	247	-10%
26	258	-15%
28	271	-20%
30	286	-25%
32	301	-30%
36	336	-35%
38	353	-40%
40	371	-45%

Reduce band speed 50% when sawing with carbon blades

BLADE BREAK-IN

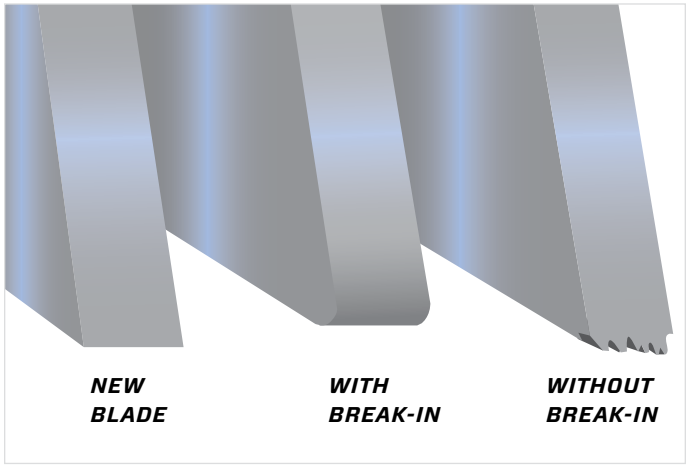
Getting Long Life from a New Band Saw Blade

WHAT IS BLADE BREAK-IN?

A new band saw blade has razor sharp tooth tips. In order to withstand the cutting pressures used in band sawing, tooth tips should be honed to form a micro-fine radius. Failure to perform this honing will cause microscopic damage to the tips of the teeth, resulting in reduced blade life

Why Break-In a Band Saw Blade?

Completing a proper break-in on a new band saw blade will dramatically increase its life



HOW TO BREAK IN A BLADE

Select the proper band speed for the material to be cut
(see chart on page 32)

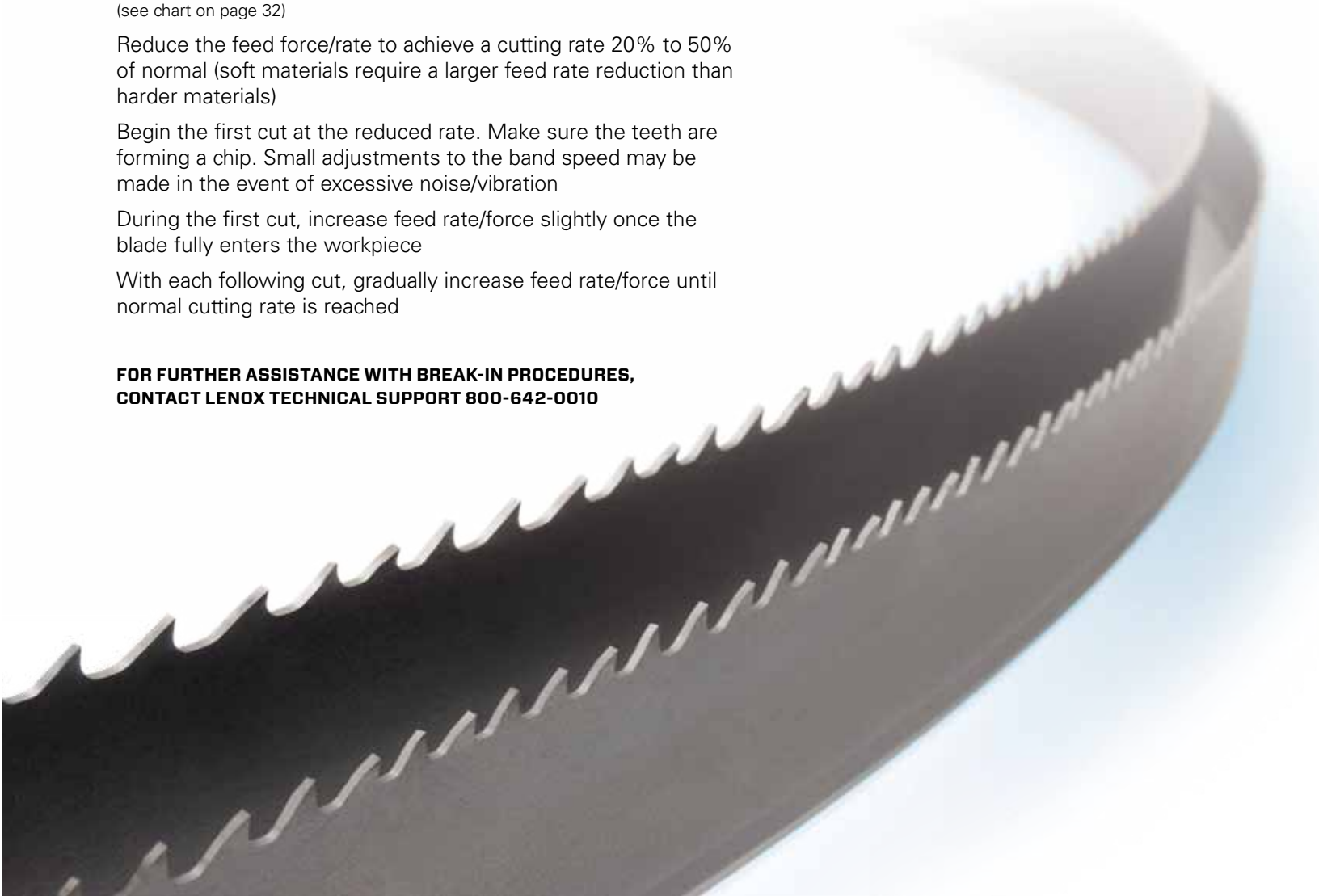
Reduce the feed force/rate to achieve a cutting rate 20% to 50% of normal (soft materials require a larger feed rate reduction than harder materials)

Begin the first cut at the reduced rate. Make sure the teeth are forming a chip. Small adjustments to the band speed may be made in the event of excessive noise/vibration

During the first cut, increase feed rate/force slightly once the blade fully enters the workpiece

With each following cut, gradually increase feed rate/force until normal cutting rate is reached

FOR FURTHER ASSISTANCE WITH BREAK-IN PROCEDURES, CONTACT LENOX TECHNICAL SUPPORT 800-642-0010



CARBON
BAND SAW BLADES

NEO-TYPE®

Hard Back Carbon Steel Blade

STRAIGHTER, EASIER CUT
The body of this blade is heat treated for extra stability while cutting

Recommended for use at band speeds less than 4,000 feet (1,200 meters) per minute

DESIGNED FOR USE ON VERTICAL CONTOUR SAWS AND SMALL CUT-OFF SAWS
Perfect for utility cutting of a wide variety of materials

WIDTH X THICKNESS		TOOTH FORM								
		STANDARD						HOOK		
		RAKER SET TPI					WAVY TPI	RAKER SET TPI		
IN	MM	6	8	10	14	18	24	3	4	6
1/4 x .025	6.4 x 0.64			◆	◆	◆	◆		◆	◆
3/8 x .025	9.5 x 0.64		◆	◆	◆	◆		◆	◆	◆
1/2 x .025	12.7 x 0.64	◆	◆	◆	◆	◆	◆		◆	
5/8 x .032	16 x 0.80			◆	◆					
3/4 x .035	19 x 0.90	◆	◆	◆	◆	◆		◆	◆	
1 x .035	25.4 x 0.90	◆	◆	◆	◆			◆		

APPLICATION

Aluminum	Carbon
Brass	Graphite
Bronze	Plastics
Copper	Mild Steels
Fiberglass	

FLEX BACK

Carbon Steel Blade

EXCELLENT FATIGUE LIFE
Designed to cut a wide variety of materials

Flexible carbon steel is very durable even at high band speeds—up to 15,000 feet (4,500 meters) per minute

DESIGNED FOR USE ON VERTICAL CONTOUR SAWS
Perfect for utility cutting of a wide variety of materials

WIDTH X THICKNESS		TOOTH FORM									
		STANDARD			HOOK					SKIP	
		RAKER SET TPI			RAKER SET TPI				ALT TPI	RAKER SET TPI	
IN	MM	6	10	14	2	3	4	6	2	4	6
1/4 x .025	6.4 x 0.64		◆	◆			◆	◆		◆	◆
3/8 x .025	9.5 x 0.64		◆	◆		◆	◆	◆			
1/2 x .025	12.7 x 0.64	◆	◆	◆		◆	◆	◆			
3/4 x .032	19 x 0.80				◆	◆	◆	◆			
1 x .035	25.4 x 0.90				◆	◆					
2 x .035	50.8 x 0.90								◆		

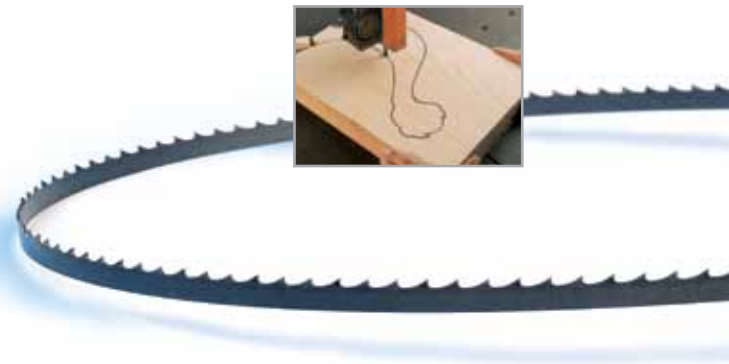
APPLICATION

Aluminum	Carbon
Brass	Graphite
Bronze	Plastics
Copper	Wood
Fiberglass	

LENOX

#32 WOOD

Specialized Woodworking Applications



STRAIGHTER, EASIER CUTTING
Manufactured with a heavier gauge (.032") flexible carbon steel material

DESIGNED FOR CONTOUR CUTTING OF WOOD
Perfect for furniture manufacturing operations

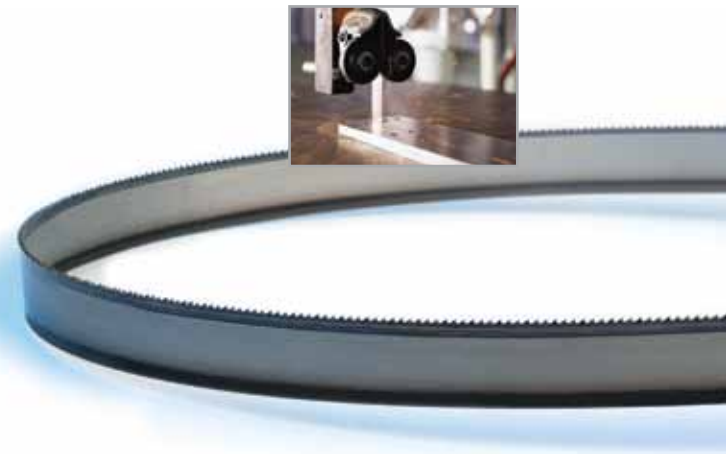
Note: Not recommended for blades shorter than 15' (4500mm) long. If shorter blade is required, LENOX *Flex Back is recommended*

WIDTH X THICKNESS		TOOTH FORM: HOOK — RAKER SET TPI			ALTERNATE TPI		
IN	MM	2	3	4	2	3	4
1/4 x .032	6.4 x 0.80			◆			◆
3/8 x .032	9.5 x 0.80		◆	◆	◆	◆	◆
1/2 x .032	12.7 x 0.80	◆	◆	◆		◆	

APPLICATION: Wood

FRICTION BAND

Friction Cutting Operations



FAST CUTTING
Special set design for increased frictional heat

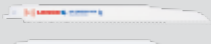
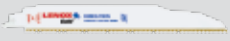
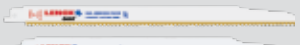
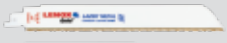
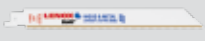
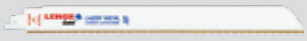
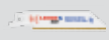
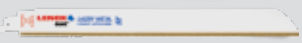
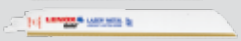
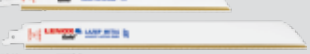
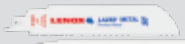
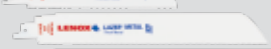
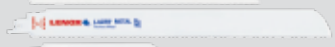
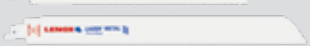
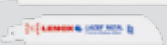
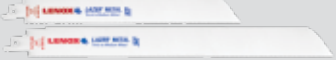
LONG LASTING
Special silicon carbon steel provides extended fatigue life

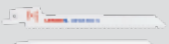
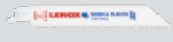
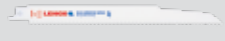
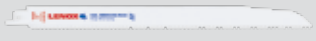
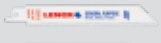
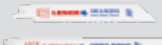
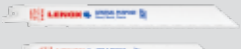
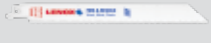
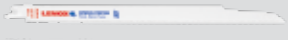
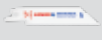
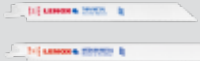
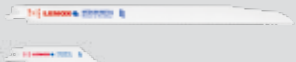
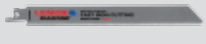
Note: Operates at band speeds up to 20,000 feet per minute (6,000 meters per minute)

WIDTH X THICKNESS		TOOTH FORM: STANDARD LENOX SET TPI
IN	MM	10
1 x .035	25.4 x 0.90	◆

APPLICATION: Ferrous metals

RECIPROCATING SAW BLADES CROSS REFERENCE CHART

	TPI	LENGTH IN	LENGTH MM	DESC	SHAPE	BOSCH® / BOSCH EDGE	DEWALT®	MILWAUKEE®/ MILWAUKEE ICE	MK MORSE®
LENOX Gold®	6	6	152	676GRC					
	6	6	152	656GR					
	6	6	152	6066GR					
	6	9	229	956GR					
	6	9	229	966GR					
	6	12	305	156GR					
	6	12	305	106GR					
	8	6	152	6108GR					
	8	9	229	9108GR					
	10	6	152	610GR					
	10	6	152	6110GR					
	10	8	203	810GR					
	10	9	229	9110GR					
	10	12	305	12110GR					
	14	4	102	414GR					
	14	6	152	614GR					
	14	6	152	6114GR					
	14	9	229	9114GR					
	14	12	305	12114GR					
	18	4	102	418GR					
	18	6	152	618GR					
	18	6	152	6118GR					
	18	8	203	818GR					
	18	9	229	9118GR					
	18	12	305	12118GR					
	24	4	102	424GR					
	24	6	152	624GR					
	24	8	203	824GR					
LENOX DIAMOND™	Grit	9	225	800DTDG					—
	Grit	11	275	100DTDG					—
LAZER®	8	6	152	6108R		RSM6X2, RSM7X2 RESM6X2	—	5700, 5701	—
	8	9	229	9108R		RSM9X2, RESM9X2	—	5705, 5706	—
	8	12	305	12108R		RSM12X2	—	5710, 5711	—
	10	6	152	6110R		S123XF, RPRM6, SAPP6, RESM6X2	—	5712, 4712	RB66210, RBFR66210W, RBMC64210
	10	9	229	9110R		RESM9X2	—	5713, 4713	RB1010, RBMC95010
	10	12	305	12110R		RAP1210	—	5714	RB1210, RB126210, RBFR126210W, RBMC125010
	14	6	152	6114R		RCM6X2, RECM6X2	DWA4186	5782, 4782	RBFR66214W, RBMC64214
	14	9	229	9114R		RCM9X2, RECM9X2	DWA4188	5787, 5795, 4788	RBFR96214W, RBMC95014
	14	12	305	12114R		RCM12X2	DWA4112	5794	RB1214, RBFR126214W, RBMC125014, RBU10514
	18	6	152	6118R		RCTM6X2,RECM6X2	—	5784, 4784	RB65018, RBMC64218
	18	9	229	9118R		RECM9X2	—	5788, 5798, 4788	RBMC95018
	18	12	305	12118R		—	—	5789	RBMC125018

	TPI	LENGTH IN	LENGTH MM	DESC	SHAPE	BOSCH® / BOSCH EDGE	DEWALT®	MILWAUKEE®/ MILWAUKEE ICE	MK MORSE®
DEMOLITION	6	6	152	6066R		RDN6V	DW4862	5021, 5701	RB66206C
	6	9	229	966R		RDN9V	DW4863	5026	RB96206
	6	12	305	106R		RDN12V	DW4806, DW4806B, DW4845, DW4877	5027	RB126206
	10	9	229	960R		REDM6X2, REDM9X2	—	—	RB96210, RBFR96210W
STANDARD BI-METAL	4	6	152	634R		S234XF	DW4801	—	RC603
	6	4	102	456RP		—	—	5052	RB606
	6	6	152	636RP		RDW66	—	—	RB606P
	6	6	152	656R		RDN6V, RHN66, RW66, RN66, RN96, RN126	DW4802, DW4802B, DW4847, DW4848B, DW4876	5031, 5035	RB63506, RB65006, RB65058, RC606
	6	6	152	676RC		—	DW4816	5041	RB65006C
	6	6	152	606R		—	DW4850	5012, 5015	RB606ST, RB658, RC606ST
	6	9	229	956R		RPRW8, RDN9V, RSN9V, RHN96, RW96	DW4803, DW4803B, DW4848	5016, 5036	RB93506, RB95006, RC905, RC906
	6	12	305	156R		RHN126, RW126	DW4804, DW4804B, DW4849	5017, 5037	RB123506, RB125006, RB125058ST, RB125058, RC1206
	10	6	152	610R		RPRAP6, RAP610	DW4806, DW4806B, DW4845, DW4877	4091, 5090, 5091, 5092	RB610, RB65010, RBMC610, RC610
	10	8	203	810R		RPRAP8, RAP810, RAP910	DW4865B	5093, 5175	RB810, RB8501014, RBMC810
	10/14	6	152	635R					
	10/14	6	152	650R		RD6V, RRD6V, SRD6, RAP6V	DW4864, DW4864B	—	RB61014, RB6501014, RB6501014T
	10/14	8	203	835R				5193	
	10/14	8	203	850R		RD9V, RRD9V, SRD9, RAP9V	DW4865	5193	RB81014, RB8501014
	10/14	12	305	110R		RD12V, RRD12V, SRD12, RFM10V, SHMF10, RAP12V	DW4838	5094, 5194	RB121014, RB12501014, RB12501014ST, RB12501014
	14	3-5/8	92	314RC		—	DW4814	5161, 5162	—
	14	4	102	414R		—	DW4807, DW4807B	5181	RB414, RH414
	14	6	152	614R		RM614	DW4808, DW4808B	5182, 5282, 4182	RB614, RB65014, RBMC614, RH614
	14	8	203	814R		RM914	—	5187, 4187	RB814, RBMC814
	14	9	225	9514R					
	18	3-5/8	92	318RC		RSM418	—	5163	RB318S, RH318S, RH324S
	18	4	102	418R		RS418	DW4810	5183	RB418, RH318, RH418
	18	6	152	618R		RS618, RM618	DW4811, DW4811B, DW4878	5184, 5284, 4184	RB618, RBMC618, RH618
	18	8	203	818R		RM918	DW4921	5188, 4188	RB814, RB818, RBMC818
	18	12	305	118R		RM1218	—	5189, 4189	RB1018, RB1218, RBMC1218
	24	4	102	424R		S518A, S518AF, S518AF-100, S518EF, S518G	DW4812	5185	RB424, RH424
	24	6	152	624R		RM624	DW4815	5186, 5286, 4186	RB624, RBMC624, RH624
	24	8	203	824R		RM924	—	—	—
LENOX *DIAMOND*™	Grit	8	203	800DRDG		RCB8DG	—	1450	—
CARBIDE GRIT	Grit	6	152	600RG		RCB6G	DW4844	1400, 1410, 1420	RTCG4, RTCG6
	Grit	8	203	800RG		RCB9G	DW4843	1430	RTCG8
	Grit	10	254	100RG		—	—	—	RTCT6065
CARBIDE TIPPED	3	8	203	8535RCT		—	—	—	RTCT6065
	6	6	152	6565RCT		—	—	—	RCFP66
	6	6	152	6563RCT		—	—	—	—
FLEAM GROUND	6	6	152	6W6R		—	—	5015	—
	6	9	229	9W6R		—	—	5016	—

LENOX

MASTER-BAND™ BLADES

Maximum Performance for Portable Band Saws

ENHANCED BEAM STRENGTH
Specially treated bands of .023 and .025 thicknesses offer increased blade strength, reducing deflection and twisting of blades during severe cutting conditions

SHATTER RESISTANT
Bi-metal blades bend and resist breaking and extend blade life

LONG LASTING
LENOX *TUFF TOOTH* design reinforces tooth for longer blade life

TPI	LENGTH X WIDTH X THICKNESS IN	LENGTH X WIDTH X THICKNESS MM	EDGE MATERIAL	3-PACK PROD NO	25-PACK PROD NO	APPLICATION
10/14	44-7/8 x 1/2 x .023	1140 x 12.7 x .6	Matrix	8011438EW1014	9403B38EW1014	1/4" & larger, most metals
14	44-7/8 x 1/2 x .023	1140 x 12.7 x .6	Matrix	8011538EW14	9404B38EW14	3/16"– 3/8," most metals
14/18	44-7/8 x 1/2 x .023	1140 x 12.7 x .6	Matrix	8011238EW1418	9407B38EW1418	1/8"– 5/16," most metals
18	44-7/8 x 1/2 x .023	1140 x 12.7 x .6	Matrix	8011638EW18	9405B38EW18	3/32"– 1/4," most metals
24	44-7/8 x 1/2 x .023	1140 x 12.7 x .6	Matrix	8011738EW24	9406B38EW24	up to 1/8," most metals
8/12	44-7/8 x 1/2 x .025	1140 x 12.7 x .6	M42	80143385EW812	9398B385EW812	3/8"– 1/2," metals, including stainless steel
10/14	44-7/8 x 1/2 x .025	1140 x 12.7 x .6	M42	80144385EW1014	9399B385EW1014	1/4" & larger, metals, including stainless steel
14	44-7/8 x 1/2 x .025	1140 x 12.7 x .6	M42	80145385EW14	9400B385EW14	3/16"– 3/8," metals, including stainless steel
14/18	44-7/8 x 1/2 x .025	1140 x 12.7 x .6	M42	80142385EW1418	9401B385EW1418	1/8"– 5/16," metals, including stainless steel
18	44-7/8 x 1/2 x .025	1140 x 12.7 x .6	M42	82310385EW18	9402B385EW18	3/32"– 1/4," metals, including stainless steel

WOLF-BAND® BLADES

Professional Performance and Exceptional Value

LONG LASTING
High speed steel teeth provide a strong, long lasting cutting edge

SHATTER RESISTANT
Bi-metal blades bend and resist breaking and extend blade life

EXCEPTIONAL VALUE
Professional performance and competitive pricing provide extraordinary cost-per-cut value

TPI	LENGTH X WIDTH X THICKNESS IN	LENGTH X WIDTH X THICKNESS MM	1-PACK PROD NO	5-PACK PROD NO	25-PACK PROD NO	APPLICATION
10/14	44-7/8 x 1/2 x .020	1140 x 12.7 x .5	3842838PW10141	8009838PW10145	3842338PW1014	1/4" & larger
14	44-7/8 x 1/2 x .020	1140 x 12.7 x .5	3842938PW141	8010738PW145	3842438PW14	3/16"– 3/8"
14/18	44-7/8 x 1/2 x .020	1140 x 12.7 x .5	3843038PW14181	8009938PW14185	3842738PW1418	1/8"– 5/16"
18	44-7/8 x 1/2 x .020	1140 x 12.7 x .5	3843138PW181	8010838PW185	3842538PW18	3/32"– 1/4"
24	44-7/8 x 1/2 x .020	1140 x 12.7 x .5	3843238PW241	8010938PW245	3842638PW24	up to 1/8"
			COMPACT PORTABLE BAND SAW BLADES			
10/14	35-3/8 x 1/2 x .020	900 x 13 x .50	1786692	1786673	1786678	1/4" (6mm) & larger
14	35-3/8 x 1/2 x .020	900 x 13 x .50	1786693	1786674	1786679	3/16" (5mm)– 3/8" (10mm)
18	35-3/8 x 1/2 x .020	900 x 13 x .50	1786695	1786675	1786680	3/32" (2mm)– 1/4" (6mm)
24	35-3/8 x 1/2 x .020	900 x 13 x .50	1786660	1786676	1786761	up to 1/8" (3,2mm)

JIG SAW BLADES

BI-METAL JIG SAW BLADES

Ideal for Woodworking and Metal Cutting

PRECISION CUTTING
Super sharp to cut fast without deflection

SMOOTH FINISH
Ground to precision sharpness for straight cuts and a smooth finish

IDEAL FOR WOODWORKING
Designed for optimal performance in wood cutting, including hardwoods

SHATTER RESISTANT
Bi-metal technology flexes and resists breaking and extends blade life

	TPI	LENGTH IN	LENGTH MM	T-SHANK	PROCESS	2-PACK PROD NO	5-PACK PROD NO	25-PACK PROD NO	APPLICATION	COMPETITIVE CROSS REFERENCE BOSCH®
WOOD CUTTING	6	4	102		Milled	20305BT406S	—	20812B406S	Fast, rough cut	T144DF
	6	4	102		Ground	20315BT456S	20850F456S	20781B456S	Very fast, clean cut	
	6	6	102		Milled	20309BT686S			Fast cut	
	10	4	102		Milled	20306BT410S	20851F410S	20813B410S	Fast, nail-embedded wood	T127DF
	10	4	102		Ground	20313BT450S	20842F450S	20814B450S	Clean, smooth cut	T101BF
	10D	4	102		Ground	20314BT450SR	20843F450SR	20782B450SR	Down cut	T101BRF
	20	3-1/4	82.5		Ground	20311BT320SC	—	—	Scroll cut, laminates	T101AOF
METAL CUTTING	14	3-5/8	92.1		Milled	20301BT314S	20832F314S	20815B314S	Thick metal	T188BF/T118B
	18	3-5/8	92.1		Milled	20302BT318S	20834F318S	20816B318S	Medium metal	T118EF
	18	5-1/4	133.4		Milled	20308BT518S	20854F518S	—	Medium metal	T318B
	24	3-5/8	92.1		Milled	20303BT324S	20835F324S	20817B324S	Thin metal	T118A/T118AF
	32	3-5/8	92.1		Milled	20803BT332S	—	—	Very thin metal	T118G

	TPI	LENGTH IN	LENGTH MM	U-SHANK	PROCESS	2-PACK PROD NO	5-PACK PROD NO	25-PACK PROD NO	APPLICATION	COMPETITIVE CROSS REFERENCE BOSCH®
WOOD CUTTING	6	4	102		Milled	20329BT486J	20652F486J	—	Fast, rough cut	U111DF
	6	4	102		Ground	20337BT456J	—	20784B456J	Very fast, clean cut	U101DF
	6	6	102		Milled	20331BT686J	—	—	Fast cut	—
	10	4	102		Milled	20328BT480J	20654F480J	—	Fast, nail-embedded wood	—
	10	4	102		Ground	20335BT450J	20648F450J	20702B450J	Clean, smooth cut	U101BF
	10D	4	102		Ground	20336BT450JR	—	20791B450JR	Down cut	—
	20	2-3/4	69.9		Ground	20333BT320JC	—	—	Scroll cut, laminates	U1AOF
METAL CUTTING	14	3-5/8	92.1		Milled	20321BT314J	20641F314J	20705B314J	Thick metal	U118B/U118BF
	18	3-5/8	92.1		Milled	20322BT318J	20643F318J	20706B318J	Medium metal	U118E/U118EF
	18	5-1/4	133.4		Milled	20330BT518J	—	—	Medium metal	—
	24	3-5/8	92.1		Milled	20323BT324J	20644F324J	20707B324J	Thin metal	U118A/U118AF
	32	3-5/8	92.1		Milled	20609BT332J	—	—	Very thin metal	U118G/U118GF

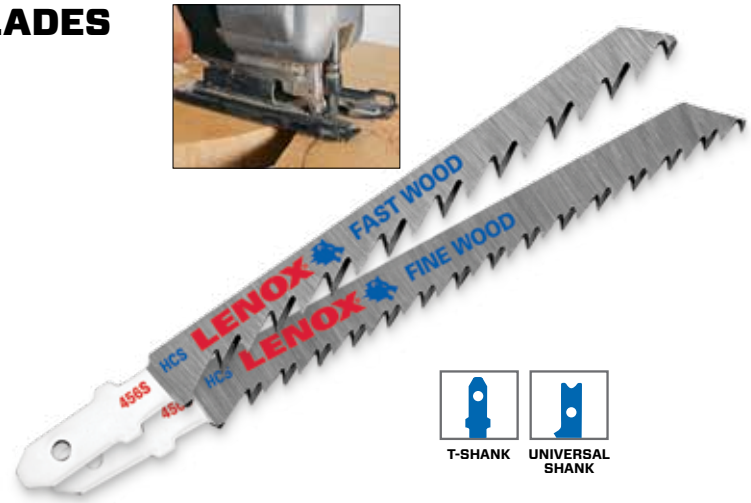
HIGH CARBON STEEL JIG SAW BLADES

Ideal for Woodworking

PRECISION CUTTING
Super sharp to cut fast without deflection

SMOOTH FINISH
Ground to precision sharpness for straight cuts and a smooth finish

IDEAL FOR WOODWORKING
Designed for optimal performance in wood cutting, including hardwoods



TPI	LENGTH IN	LENGTH MM	T-SHANK	PROCESS	2-PACK PROD NO	5-PACK PROD NO	25-PACK PROD NO	APPLICATION	COMPETITIVE CROSS REFERENCE BOSCH®
6	4	102		Milled	20750CTS406S	20298CFS406S	—	Fast, rough cut	T111C
6	4	102		Ground	20751CT456S	20297CF456S	20292BC456S	Very fast, clean	T101D
6	3-5/8	92.1		Ground	20312CT416SC	—	—	Scroll cut	T244D
10	4	102		Ground	20752CT450S	20296CF450S	20291BC450S	Clean, smooth cut	T101B
10D	4	102		Ground	20753CT450SR	20295CF450SR	20290BC450SR	Down cut	T101BR
20	3-1/4	82.5		Ground	20754CT320SC	20299CF320SC	20294BC320SC	Scroll cut, laminates	T101AO

TPI	LENGTH IN	LENGTH MM	U-SHANK	PROCESS	2-PACK PROD NO	5-PACK PROD NO	25-PACK PROD NO	APPLICATION	COMPETITIVE CROSS REFERENCE BOSCH®
6	4	102		Milled	20755CTS406J	—	—	Fast, rough cut	U111D
6	4	102		Ground	20756CT456J	—	20794BC456J	Very fast, clean cut	U101D
6	3-5/8	92.1		Ground	20334CT416JC	—	—	Scroll cut	U244D
10	4	102		Ground	20757CT450J	—	20795BC450J	Clean, smooth cut	U101B
10D	4	102		Ground	20758CT450JR	—	—	Down cut	U101BR
20	2-3/4	69.9		Ground	20759CT320JC	—	20797BC320JC	Scroll cut, laminates	U101A0

LENOX *DIAMOND*™ GRIT JIG SAW BLADE

TPI	LENGTH IN	LENGTH MM	T-SHANK	PROCESS	1-PACK PROD NO	APPLICATION
Grit	3-1/2	88.9		Grit	12149	Ceramic Tile, Fiberglass

CARBIDE GRIT JIG SAW BLADES

TPI	LENGTH IN	LENGTH MM	SHAPE T-SHANK	PROCESS	2-PACK PROD NO	5-PACK PROD NO	APPLICATION	COMPETITIVE CROSS REFERENCE BOSCH®
Grit	3-1/2	88.9		Grit	20300GT300S	20830F300SG	Ceramic Tile	T130RF3
			U-SHANK					
Grit	3-1/2	88.9		Grit	20320GT300J	—	Ceramic Tile	—

BOSCH *is a registered trademark of Robert Bosch Tool Corporation*

JIG SAW BLADE SETS

Bi-Metal Sets

20868U743SA
7 PIECE T-SHANK
BI-METAL SET

456S, 450SR, 450S, 406S, 324S, 318S, 314S

VINYL POUCH

20606U743JA
7 PIECE U-SHANK
BI-METAL SET

456J, 450JR, 450J, 406J, 324J, 318J, 314J

VINYL POUCH

High Carbon Steel Sets

20764C543SA
5 PIECE T-SHANK
MULTI-PURPOSE SET

456S, 450S, 324S, 320SC, 318S

BLISTER PACK

20769C543JA
5 PIECE U-SHANK
MULTI-PURPOSE SET

456J, 450J, 324J, 320JC, 318J

BLISTER PACK

AIR SAW BLADES

Maximum Durability for Pneumatic Machine Cutting

SHATTER RESISTANT
Bi-metal blades bend and resist breaking and extend blade life

LONG LASTING
High speed steel teeth provide a strong, long lasting cutting edge

TPI	LENGTH X WIDTH X THICKNESS IN	LENGTH X WIDTH X THICKNESS MM	5-PACK PROD NO	25-PACK PROD NO	APPLICATION
18	4 x 1/2 x .025	102 x 12.7 x .6	20426418T	20423B418T	For pneumatic machine cutting applications in automotive repair & sheet metal
24	4 x 1/2 x .025	102 x 12.7 x .6	20427424T	20424B424T	
32	4 x 1/2 x .025	102 x 12.7 x .6	20428432T	20425B432T	

METAL CUTTING CIRCULAR SAW BLADES

A Faster Way to Cut Metal™

EXTENDED LIFE
Titanium carbide tipped

Resists material build-up on teeth

CLEAN, COOL CUTS
Less burr than abrasive blades

No need for secondary grinding

Reduced material burning

MODIFIED TRIPLE CHIP GRIND
For added durability

RESHARPENABLE

	DIAMETER		PROD NO	TOOTH COUNT	RPM	ARBOR		APPLICATION
	IN	MM				IN	MM	
STEEL	5-3/8	135	21876ST538030CT	30	3500	—	20	Structurals Thick walled pipe Threaded rod Channel steel Plate Solid steel
	6-3/4	171	21878ST634040CT	40	5800	—	20	
	7	180	21879ST700038CT	38	4300	—	20	
	7-1/4	184	21881ST714040CT	40	5800	5/8	16	
	8	203	21884ST800050CT	50	5800	5/8	16	
	9	230	21885ST900048CT	48	5200	1	25.4	
	10	254	21886ST100052CT	52	5200	5/8	16	
	12	305	21888ST120060CT	60	1500	1	25.4	
	14	355	21891ST140080CT	80	1800	1	25.4	
THIN STEEL	6-1/2	165	21877TS612048CT	48	5800	5/8	16	Sheet metal Thin walled pipe Metal roofing Metal decking
	7	180	21880TS700068CT	68	4300	—	20	
	7-1/4	184	21883TS714068CT	68	5800	5/8	16	
	12	305	21890TS120080CT	80	1500	1	25.4	
	14	355	21893TS140090CT	90	1800	1	25.4	
ALUMINUM	7-1/4	184	21882AL714060CT	60	5800	5/8	16	Aluminum Copper Brass
	10	254	21887AL100080CT	80	5200	5/8	16	
	12	305	21889AL120080CT	80	4000	1	25.4	
	14	355	21892AL140080CT	80	3000	1	25.4	