

## CHOOSE THE CORRECT TOOTH STYLE AND SET WHEN SELECTING BAND SAW BLADES



### REGULAR TOOTH

The most commonly used tooth shape. Ideally suited for both cut-off and contour sawing of most materials. For cutting thin materials where a fine cut is required.



### HOOK TOOTH

Positive  $10^\circ$  rake angle helps to "dig-in", resulting in a higher cutting rate. Recommended for long cuts into thicker wood, plastic and metal.



### SKIP TOOTH

Widely spaced teeth with a  $0^\circ$  rake angle to prevent clogging when cutting soft, non-ferrous metals, plastics and wood.



### RAKER SET TOOTH

Consists of one to the left, one to the right and one tooth (raked) is unset. This set is used for cutting thick, solid metal sections on horizontal cut-off machines. It is also used for contour cutting and resawing on vertical band machines.

## CHOOSE THE CORRECT NUMBER OF TEETH PER INCH (TPI)

The number of teeth per inch (TPI) is important in obtaining the finish desired and the proper feed rate. A coarse tooth blade (2, 3 TPI) should be used for resawing wood and cutting thicker stock up to 8". A fine toothed blade (18 to 32 TPI) should be used for thinner metals and plastics under  $1/4"$ . For general cutting of  $3/4"$  wood, 4 TPI will provide a fast cut and 14 TPI will cut slow but leave a smoother finish.

### WHEN SELECTING A TPI REMEMBER:

- More TPI give a smoother but slower cut
- Fewer TPI allow a faster cut with a slightly rougher finish
- At least three teeth must be in the workpiece - the chart above will help you decide