



INCHES	TEETH PER INCH	TEETH PER INCH	WALL THICKNESS	TEETH PER INCH	WALL THICKNESS
0			1/16		0.06
.1	14/18	14/18	1/8	10/14	0.13
.2	10/14	10/14	3/16	8/12	0.19
.3	8/12	8/12	1/4	6/10	0.25
.4	6/10	6/10	5/16	5/8	0.31
.5	5/8	5/8	3/8	4/6	0.38
.6	4/6	4/6	7/16	3/4	0.44
.7	3/4	3/4	1/2	2/3	0.50
.8	2/3	2/3	9/16	1/2	0.56
.9	1/2	1/2	5/8	3/4	0.63
1	1/2	1/2	11/16	3/4	0.69
1-1/4	1/2	1/2	3/4	3/4	0.75
1-1/2	1/2	1/2	13/16	3/4	0.81
1-3/4	1/2	1/2	7/8	3/4	0.88
2	1/2	1/2	15/16	3/4	0.94
2-1/4	1/2	1/2	1	3/4	1.00
2-1/2	1/2	1/2	1-1/8	3/4	1.13
2-3/4	1/2	1/2	1-1/4	3/4	1.25
3	1/2	1/2	1-3/8	3/4	1.38
3-1/4	1/2	1/2	1-1/2	3/4	1.50
3-1/2	1/2	1/2			
3-3/4	1/2	1/2			
4	1/2	1/2			
5	1/2	1/2			
6	1/2	1/2			
7	1/2	1/2			
8	1/2	1/2			
9	1/2	1/2			
10	1/2	1/2			

RECTANGULAR SOLIDS: (USE WIDTH)

ROUND SOLIDS: (USE DIAMETER)

PIPE TUBING STRUCTURALS (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 to the left. Find material dimension on chart and move right for appropriate teeth per inch.

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

Call Us For Technical Assistance Any Time at 633-6603 Or Toll Free At 1-800-694-4021

Cutting speed - Structurals
Rule of thumb:

When cutting structurals use a cutting speed of
250-325 S.F.M. Wet
200-250 S.F.M. Dry

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BLADE BREAK-IN
EXTREMELY IMPORTANT!

The extremely sharp tooth points and edges of new, unused 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.