

1

BLADE TYPE

Use this guide to choose the blade that will work best for the material to be cut, or provide an acceptable result, as necessary.

EXOTIC & NICKEL-BASED ALLOYS

Intenss™ PRO or Intenss™ VTH

TOOL & STAINLESS STEEL

Intenss™ PRO or Intenss™ VTH

ALLOY & HIGH CARBON STEEL

Intenss™ PRO

GENERAL PURPOSE

Intenss™ PRO

CARBON STEEL

Intenss™ PRO-DIE

STRUCTURAL STEEL

Intenss™ PRO-ST or Versatix™ MP

ALUMINUM

Intenss™ PRO or Intenss™ PRO-DIE or Duratec™ FB

CAST ALUMINUM

Advanz™ FS

THIN FERROUS SECTIONS

Duratec™ FC

COMPOSITES, FIBERGLASS, GRAPHITE & CERAMICS

Advanz™ CG or Advanz™ DG

WOOD & PLASTIC

Woodpecker™ Premium or Woodpecker XF™

FOAM, PAPER PRODUCTS & RUBBER

Band Knives

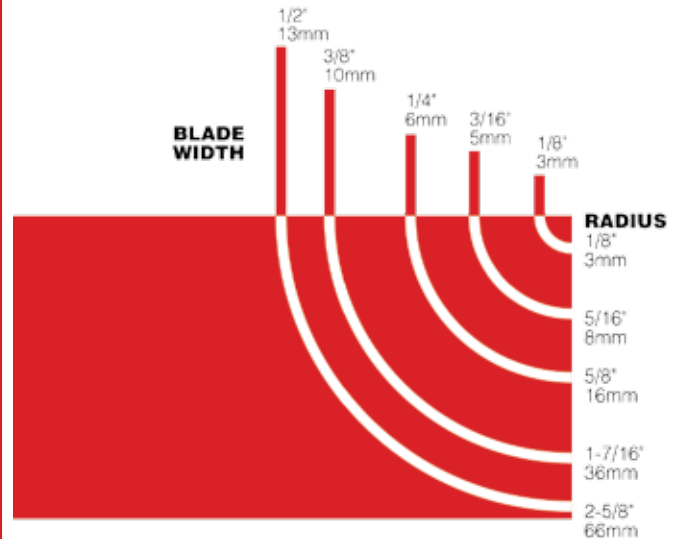
FRESH OR FROZEN MEAT OR FISH (WITH OR WITHOUT BONES)

Meatkutter™ Premium or Meatkutter™ Stainless

2

BLADE WIDTH

Use the widest blade your machine will take except for contour cutting. Use this chart for cutting radii:



3

TOOTH SHAPE

Regular - A conventional tooth used for general purpose sawing, straight or zero rake.

Intenss™ PRO - Large teeth, up to 12° positive rake angle, for optimum production cutting of steels up to HRc 45, stainless, nickel based and nonferrous alloys.

Hook - A positive rake for fast cutting of nonferrous metals and non-metallics.

Skip - Zero rake and shallow gullets for cutting large sections of soft, nonferrous material.

BLADE SELECTION IN FIVE STEPS

4 PITCH

Pitch is the number of teeth per inch or 25mm. Cutting thinner sections requires a finer pitch (more teeth per inch/25mm). Thick sections require coarser pitches (fewer teeth per inch/25mm).

The charts are good guidelines. Because the cross section limits in the chart are broad and overlap, choose a coarser pitch if the speed of cut is most important. Choose a finer pitch if finish is most important.

Section Size (Inch)	Constant Pitch (TPI)	Variable Pitch (TPI)
5/32" - 3/8"	32 or 24	14-18
1/4" - 1/2"	18 or 14	10-14
1/2" - 3/4"	14 or 10	8-12
3/4" - 1"	10 or 8	6-10
1" - 1-1/2"	8 or 6	5-8
1-1/2" - 3-1/2"	6 or 4	4-6
3-1/2" - 7"	4 or 3	3-4
7" - 10"	3	2-3
10" - 16"		1.4-2
14" - 20"		1-2
16" - 32"		1-1.2
Over 30"		.8-1.3

5 BLADE LENGTH

The blade length varies according to the band saw machine type and specifications. Please find the correct blade length on your band saw machine user manual.



Wall Thickness (Inch)	Outside diameter of tube or maximum profile section length (Inch)												
	3/8"	3/4"	1-5/8"	2-3/8"	3-1/4"	4"	4-3/4"	6"	8"	12"	16"	20"	24"
3/32"	14-18	14-18	10-14	10-14	10-14	10-14	8-12	8-12	8-12	8-12	6-10	6-10	5-8
1/8"	10-14	10-14	10-14	10-14	10-14	8-12	8-12	8-12	6-10	6-10	6-10	5-8	5-8
5/32"		8-12	8-12	8-12	8-12	6-10	6-10	6-10	5-8	5-8	4-6	4-6	4-6
3/16"		6-10	6-10	6-10	6-10	5-8	5-8	5-8	5-8	4-6	4-6	4-6	4-6
1/4"		5-8	5-8	5-8	5-8	5-8	5-8	5-8	4-6	4-6	4-6	4-6	3-4
5/16"			4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	3-4	3-4	3-4
3/8"			4-6	4-6	3-4	3-4	3-4	3-4	3-4	3-4	3-4	2-3	2-3
1/2"				4-6	3-4	3-4	3-4	3-4	3-4	3-4	2-3	2-3	2-3
5/8"				4-6	3-4	3-4	3-4	3-4	3-4	2-3	2-3	2-3	2-3
3/4"				4-6	3-4	3-4	3-4	3-4	3-4	2-3	2-3	2-3	2-3
1"					3-4	3-4	3-4	3-4	2-3	2-3	2-3	1.4-2	1.4-2
1-1/4"					3-4	3-4	3-4	3-4	2-3	2-3	2-3	1.4-2	1.4-2
1-5/8"						3-4	3-4	3-4	2-3	2-3	2-3	1.4-2	1.4-2
2"							3-4	3-4	2-3	2-3	1.4-2	1.4-2	1-2
2-3/8"									2-3	2-3	1.4-2	1.4-2	1-2