

TOOTH SELECTION

Band saw tooth pitch (teeth per inch) 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 right. Find material dimension on chart and move right for appropriate teeth per inch.

For angle, tubing, and pipe - multiply wall thickness by 2-1/2 to determine average width.

Cutting Speed – Structural

Rule of Thumb: When cutting structurals use a cutting speed of: 350 S.F.P.M. Wet
200-250 S.F.P.M. Dry

Minimum Radius per Blade Width

Blade Width	Minimum Radius	Materials Thickness 1" / 25mm
1" / 25mm	7-1/4" / 184mm	
3/4" / 19mm	5-7/16" / 138mm	
5/8" / 16mm	3-3/4" / 95mm	
1/2" / 13mm	2-1/2" / 63mm	
3/8" / 10mm	1-1/4" / 32mm	
1/4" / 6mm	5/8" / 16mm	
3/16" / 5mm	3/8" / 10mm	
1/8" / 3mm	7/32" / 5.5mm	

