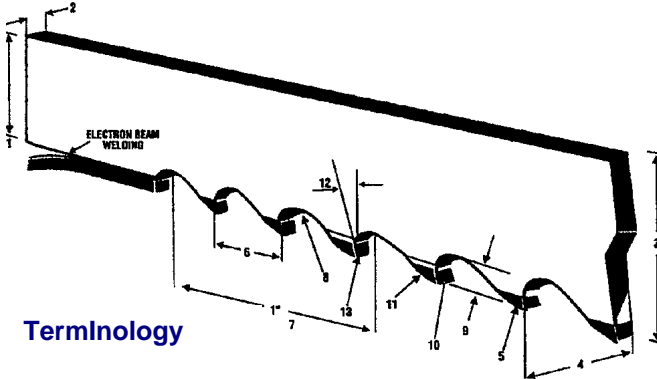


BAND SAW BLADES

CROSS REFERENCE FOR BAND SAW BLADES



Terminology

- 1 Blade Back The body of the blade not including tooth portion.
- 2 Gage The thickness of the blade.
- 3 Width The tip of tooth to back of blade.
- 4 Set The bending of teeth right or left.
- 5 Tooth The cutting portion of saw blade.
- 6 Tooth Pitch The distance from one tooth tip to the next.
- 7 T.P.I. The number of teeth per inch measured gullet to gullet.
- 8 Gullet The curved area between the tooth points.
- 9 Gullet Depth The distance from the tooth tip to the bottom of the gullet.
- 10 Tooth Face The surface of the tooth on which the chip is formed.
- 11 Tooth Back The surface of the tooth opposite the tooth face.
- 12 Tooth Rake Angle The angle of the tooth face measured with respect to a line perpendicular to the cutting direction of the saw.
- 13 Tooth Tip The cutting edge of the saw tooth.

	CARBON		BI-METAL				
	Hard Edge Flex Back	Hard Edge Hard Back	Matrix II Straight Pitch	Matrix II Variable Pitch	M42 Straight Pitch	M42 Variable Pitch	M42 Special Application
MORSE	Flex Back	Hard Back	Straight Pitch	Variable Pitch	Straight Pitch	Variable Pitch	
Lenox "American Saw"	Flex Back	Neo Type	Matrix Electron Weld	Matrix Electron Weld and Matrix II	Super	Contestor Production Band	GT Diemaster-2 Mercury Billet Master RX
Do-All	Metal Masters	Dart	Imperial 102 Imperial 103 Imperial 100	Decimal Pitch Silencer	Imperial "101" Penetrator	Decimal Pitch Penetrator	Invader
Starrett	Flexible Back	Premium	Power Band Bearcat	Power Band Varicat	Powerband II Bearcat	Powerband II Varicat Durango GPM-M4	Pulsator
Amada	Flexible Back A	Premium BB	GLB MGLB	VGLB MVGLB	SGLB	SVGLB	Hi-Lo Aurora
Sandvik/Milford	Flexible Back	TT-44 High Hard	Gold Dragon Bi-Band	Gold Dragon Combo	King Cobra Bi-Band	King Cobra Combo	
Marvel/Spartan	Flexible Back	Hard Back	M-2 High Speed	Eaglebeak and Matrix Mix Teeth	M-42 Cobalt	Eaglebeak Plus M-42 Cobalt	
Simonds	Hard Edge	SiMet	Centaur	Centaur "Maximiser"	Centaur 42 Epic	Centaur 42 Epic	SiNamic Block Buster
Nicholson	Hard Edge (Magi-Cut)	Hard Back	Bi-Metalloy	Bi-Met. I-VP5 Super Matrix Matrix	Bi-Metalloy III	Bi-Metalloy III V.R.5	Predator
Diamond (Sterling)	Carbon	Tri-Temp	Super Weld	Super Weld Broach Tooth or Posi Tooth	Blue Diamond	Blue Diamond Broach	
Wikus	Flex Back	Hard Back	525 Bi-Flex M-2	527 Vario M-2	526 Bi-Flex Kobalt M-42	528 Varic "529" Marathon	Marathon M51
Rule Capewell	Carbon King	Hercu-band Hard Back	Sav-Edge	Sav-Edge Vari-Tooth	Super T 2000	Super T 4000 Aggressor	

STANDARD TOOTH TYPE

- FEATURES**
- Equally Spaced Teeth
 - 01 Rake Angle
- ADVANTAGES**
- Excellent Chip Carrying Capacity
- BENEFITS**
- Wide Range of Applications
 - General Purpose

SKIP

- FEATURES**
- Wide Gullets
 - 0° Rake Angle
 - Equally Spaced Teeth
- ADVANTAGES**
- Excellent Chip Carrying Capacity
 - Provide Coarse Pitch on Narrow Bands
- BENEFITS**
- Excellent Cutting for NonMetallic Applications, (Wood, Plastic, Composition Materials)

VARIABLE PITCH

- FEATURES**
- Varying Gullet Depth
 - 0° Rake Angle
 - Variable Tooth Spacing
- ADVANTAGES**
- Excellent Chip Carrying Capacity
 - Reduces Harmonic Vibration
- BENEFITS**
- Improves Blade Life
 - Reduces Noise
 - Cuts Smoother & More Efficiently
 - Wider Range of Applications

HOOK

- FEATURES**
- Wide Gullets
 - Equally Spaced Teeth
 - Positive Rake Angle
- ADVANTAGES**
- Provide Coarse Pitch on Narrow Bands
 - Excellent Chip Carrying in Non-Metallic Applications
- BENEFITS**
- Good Surface Finish on Non-Metals
 - Good Cutting Performance in Discontinuous Chip Forming Materials (Cast Iron)
 - Fast Cutting

VARIABLE PITCH POSITIVE RAKE

- FEATURES**
- Varying Gullet Depth
 - Variable Tooth Spacing
 - Positive Rake Angle
- ADVANTAGES**
- Better Chip Formation
 - Excellent Chip Carrying Capacity
 - Reduces Harmonic Vibration
 - More Aggressive Cutting
- BENEFITS**
- Cuts Smoother, Cuts Faster
 - Reduces Noise
 - Improves Blade Life
 - Easier Chip Generation

TOOTH FORM



RAKER SET

- Recurring Sequence Of Teeth – One Set Left, And One Not Set.

MODIFIED RAKER SET

- Standard Tooth With A Left, Right, Left, Right, Straight Etc. Tooth Pattern.

VARIABLE PITCH RAKER SET

- Set Sequence Depends On The Variable Pitch Tooth Pattern.

WAVY SET

- Groups Of Teeth Set To Each Side In A Controlled Pattern.

ALTERNATIVE SET

- Every Tooth Set Alternately To The Left And Right.