Auckland: (09) 2717 234
Christchurch: (03) 741 6241

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Product Brochure For B419

Metal Band Saw Blade - 4-6TPI Bi-Metal, Blade - 3035 x 27 x 0.90mm

Suits Stainless Steel
SUITS BS-916 Metal Cutting Band Saw



ORDER CODE:	B419
Suits Band Saw Models:	BS-916
Blade Size (L x W x T) (mm):	3035 x 27 x 0.90
Number of teeth per inch (TPI):	4-6
Blade Type:	BI-METAL
Blade Suitable for - Material Type:	Mild & Stainless Steel
Suits Section Size (mm):	51-80

Description

Please Note:
Starrett Blades are distributed in Sydney, Adelaide & Brisbane, Auckland & Christchurch
Excision Blades are distributed in Melbourne & Perth

IMPORTANT RUN-IN INSTRUCTIONS FOR BI-METAL BLADES
- Avoid excessive feed pressure on run-in
- Run-in at 3/4 normal feed pressure for first 25 square inches on tough material
- After run-in, gradually increase feed to maximum cutting rate

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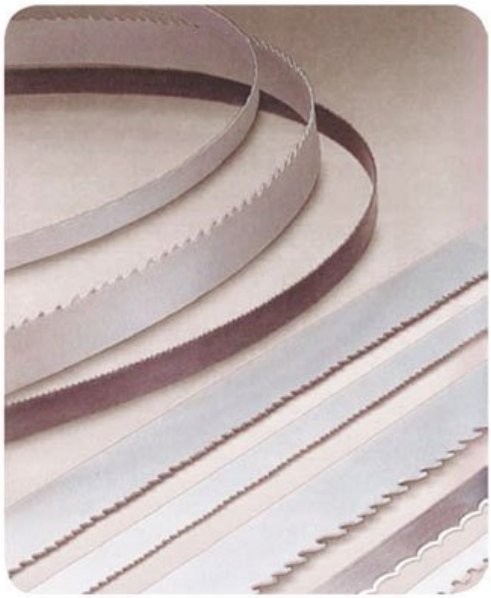
BLADE SELECTION CHARTS

Band saw tooth size is determined by the size of the cross section to be cut. In general cutting thinner sections requires more teeth per inch, thicker sections require coarser pitches, or less teeth per inch.

To select an appropriate tooth size please refer to the table immediately below unless material to be cut is a tube, in which case refer to the larger table below. For general purpose cutting use a constant pitch blade, for more aggressive production cutting of harder to cut materials use a variable pitch blade.

SOLID SECTION

Section Size (mm)	Constant Pitch (TPI)	Variable Pitch (TPI)
Up to 10	24 or 18	14/18 or 10/14
10-15	14	8-12
16-30	10	6-10
31-50	8	5-8
51-80	6	4-6
81-120	4	3-4
121-200	3	2-3
Over 200	2 or 1.25	1.4-2 or 0.8-1.3



TUBE SECTION

Wall Thickness (mm)	Outside diameter of tube or maximum profile section length (mm)												
	20	40	60	80	100	120	150	200	300	500	600	700	800
2	14	14	14	14	14	14	10-14	10-14	8-12	8-12	6-10	5-8	5-8
3	14	14	10-14	10-14	10-14	10-14	8-12	8-12	6-10	6-10	5-8	5-8	5-8
4	14	14	10-14	10-14	8-12	8-12	6-10	6-10	5-8	5-8	4-6	4-6	4-6
5	14	10-14	10-14	8-12	8-12	6-10	6-10	5-8	5-8	4-6	4-6	4-6	4-6
6	14	10-14	10-14	8-12	8-12	6-10	6-10	5-8	5-8	4-6	4-6	3-4	3-4
8	14	10-14	8-12	8-12	6-10	6-10	5-8	5-8	4-6	4-6	3-4	3-4	3-4
10		8-12	8-12	6-10	6-10	5-8	5-8	4-6	4-6	3-4	3-4	3-4	3-4
12		8-12	6-10	6-10	5-8	5-8	4-6	4-6	3-4	3-4	3-4	3-4	2-3
15			6-10	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3
20				5-8	4-6	4-6	4-6	3-4	3-4	2-3	2-3	2-3	2-3
30					4-6	4-6	3-4	3-4	3-4	2-3	2-3	2-3	2-3
50						3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3
75							2-3	2-3	2-3	2-3	2-3	1.4-2	1.4-2