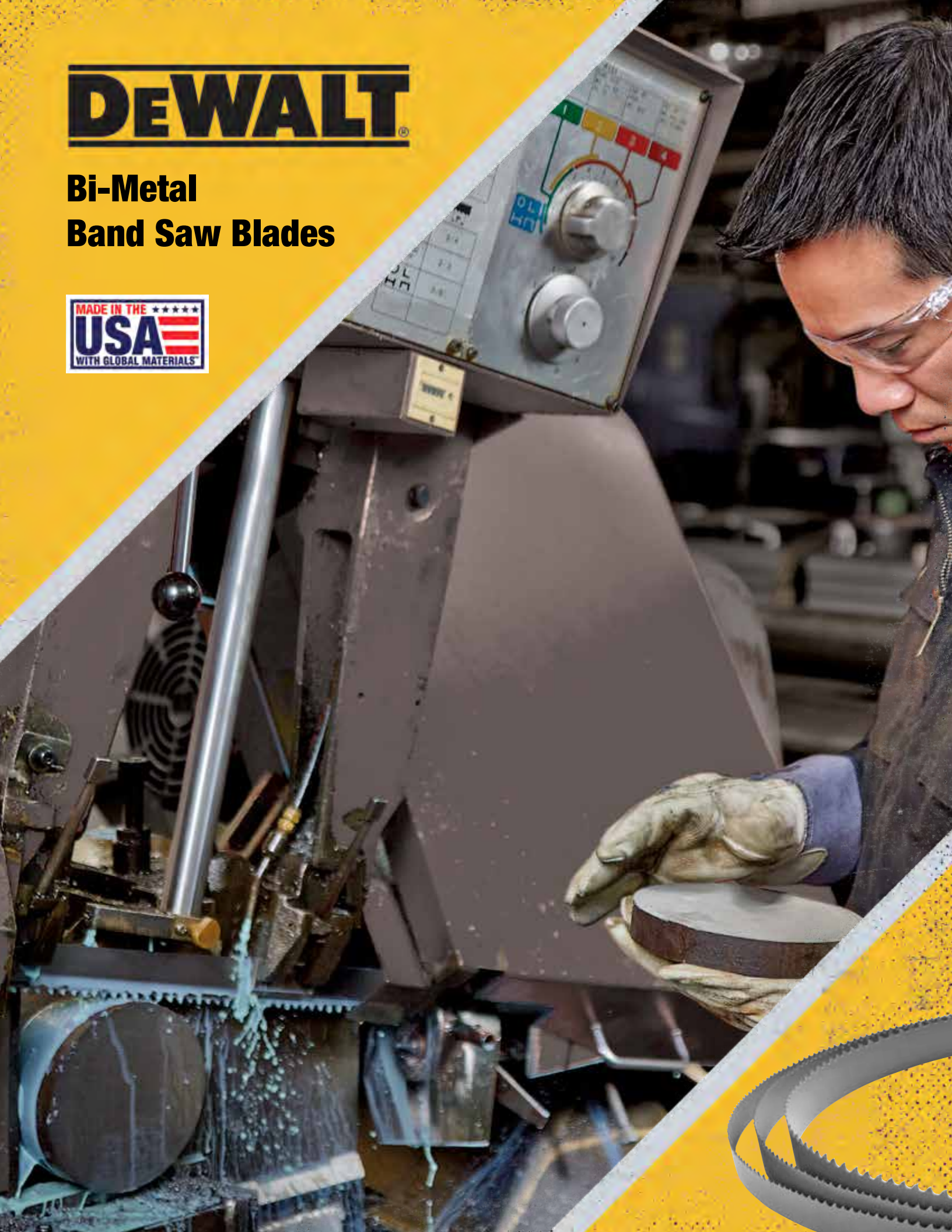
DEWALT

Bi-Metal Band Saw Blades

MADE IN THE USA WITH GLOBAL MATERIALS



DEWALT

Bi-Metal Band Saw Blades

Exceptional Value and Performance in General Purpose Cutting Applications

LONG BLADE LIFE IN MRO AND PRODUCTION SETTINGS

- *M42 high speed steel tooth edge provides superior heat and wear resistance*
- *Optimized tooth geometry and set pattern reduces stripped teeth*

EXCELLENT VERSATILITY

- *Effectively cuts a wide range of metals from carbon steel to tool steel*
- *Easily switches between solid and structural metals*

BLADE SPECIFICATIONS

WIDTH X THICKNESS		TPI							
IN	MM	2/3	3/4	4/6	5/8	6	6/10	8/12	10/14
1/2 x .025	12.7 X 0.64					√	√	√	√
3/4 x .035	19 x 0.90			√	√		√	√	√
1 x .035	27 x 0.90	√	√	√	√		√	√	√
1-1/4 x .042	34 x 1.07	√	√	√	√		√	√	
1-1/2 x .050	41 x 1.27	√	√	√					

APPLICATIONS

- Aluminum
- Non-Ferrous
- Carbon Steels
- Structural Steels
- Alloy Steels
- Stainless Steel

Versatility **Value** **Performance**

Enhanced chamfer on the back edge reduces band breaks

High speed blasting strengthens the blade to increase durability and blade life

M42 High Speed Steel Edge increases heat and wear resistance

Advanced tooth design with positive rake angle reduces stripped teeth

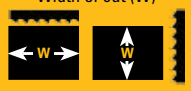
Bi-Metal Band Saw Blades

SQUARE/RECTANGLE SOLID Locate width of cut (W)

WIDTH OF CUT

IN	2	.3	.4	.5	.6	.7	.8	.9	1	2	5	7	
MM	5	7.5	10	12.5	15	17.5	20	22.5	25	50	125		
TPI	10/14		8/12		6/10		6/8 5/8			4/6	3/4	2/3	

Width of cut (W)



ROUND SOLID Locate diameter of cut (D)

DIAMETER OF CUT

IN	.3	.4	.5	.6	.7	.8	.9	1	2	5	10
MM	7.5	10	12.5	15	17.5	20	22.5	25	50	125	250
TPI	10/14		8/12		6/10		6/8 5/8		4/6	3/4	2/3

Diameter (D)

TUBING/PIPE/ STRUCTURALS Locate wall thickness (T)

WALL THICKNESS

IN	.05	.10	.15	.20	.25	.30	.40	.50	.60	.70	.80	.90	1	1.5
MM	1.25	2.5	3.75	5	6.25	7.5	10	12.5	15	17.5	20	22.5	25	37.5
TPI	10/14	8/12	6/10	6/8 5/8	4/6				3/4				2/3	

Wall thickness (T)

Bi-Metal Band Saw Blade Speed Chart

	MATERIALS		BAND SPEED	
	TYPE	GRADE	FPM	MPM
CARBON STEELS	Leaded, Free Machining Low Carbon Steels	1145 1215 12L14	270 325 350	80 100 105
	Low Carbon Steels	1008, 1018 1030	270 250	80 75
	Medium Carbon Steels	1035 1045	240 230	75 70
	High Carbon Steels	1060 1080 1095	200 195 185	60 60 55
STRUCTURAL STEEL	Structural Steel	A36	250	75
ALLOY STEEL	Mn Steels	1541 1524	200 170	60 50
	Cr-Mo Steels	4140 41L50 4150H	225 235 200	70 70 60
	Cr Alloy Steels	6150 5160	190 195	60 60
	Ni-Cr-Mo Steels	4340 8620 8640 E9310	195 215 185 160	60 65 55 50
BEARING STEEL	Cr Alloy Steels	52100	160	50
MOLD STEEL	Mold Steels	P-3 P-20	180 165	55 50
ALUMINUM / NON-FERROUS	Aluminum Alloys	2024, 5052, 6061, 7075	300+	85+
	Copper Alloys	CDA 220 CDA 360 Cu Ni (30%) Be Cu	210 295 200 160	65 90 60 50
	Bronze Alloys	AMPCO 18 AMPCO 21 AMPCO 25 Leaded Tin Bronze Al Bronze 865 Mn Bronze 932 937	180 160 110 290 150 215 280 250	55 50 35 90 45 65 85 75
	Brass Alloys	Cartridge Brass, Red Brass (85%) Naval Brass	220 200	65 60
STAINLESS STEEL	Stainless Steels	304	115	35
		316	90	25
		410,420	135	40
		440A	80	25
		440C	70	20
	Precipitation hardening	17-4 PH, 15-5 PH	70	20
	Free Machining	420F	150	45
		301	125	40

HOW TO BREAK IN A BLADE

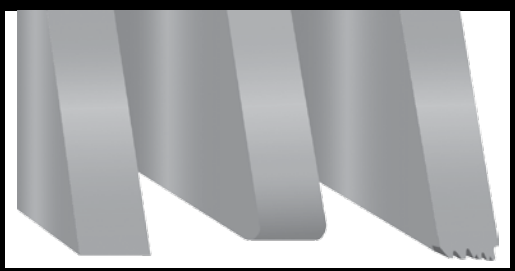
Select the proper band speed for the material to be cut (see chart on left).

Reduce the feed force/rate to achieve a cutting rate 20% to 50% of normal (soft materials require a larger feed rate reduction than harder materials).

Begin the first cut at the reduced rate. Make sure the teeth are forming a chip. Small adjustments to the band speed may be made in the event of excessive noise/vibration.

During the first cut, increase feed rate/force slightly once the blade fully enters the workpiece.

With each following cut, gradually increase feed rate/force until normal cutting rate is reached.



NEW BLADE | WITH BREAK-IN | WITHOUT BREAK-IN