



# **Band Saw Specifications**

2/10/2020



# ARMOR™ Specifications

## ARMOR™ CT BLACK

TPI	2.5/3.4	1.8/2.0	1.4/1.6	.9/1.1 Deep Gullet Form
<i>Set - Ground</i>	Multi-Chip	Multi-Chip	Multi-Chip	Multi-Chip
<i>Tooth Face Rake Angle</i>	6°	6°	6°	6°
<i>Back Relief Angle</i>	12°	12°	12°	12°
1-1/4 x .042	.078	.078		
1-1/2 x .050	.086	.086	.086	
2 x .063	.099	.099	.099	.099
2-5/8 x .063		.099	.099	.099
3 x .063				.099

## ARMOR Rx® +

TPI	4/6		3/4		2/3	
	(V-S)		(V-S)		(V-S)	
	8° Standard	8° EHS	8° Standard	8° EHS	10° Standard	EHS
1-1/4 x .042	.068	.090	.070	.090	.070	
1-1/2 x .050	.080	.100	.080	.100	.080	
2 x .063			.099	.120	.095	

## ARMOR VP

TPI	0.9/1.1	1.0/1.4	1.4/2.0	2/3	3/4
<i>Set - Ground</i>	Multi-Chip	Multi-Chip	Multi-Chip	Multi-Chip	Multi-Chip
<i>Tooth Face Rake Angle</i>	8°	8°	8°	8°	8°
<i>Back Relief Angle</i>	20°	20°	20°	20°	20°
1-1/4 x .042				.078	.078
1-1/2 x .050			.086	.086	.086
2 x .050				.086	
2 x .063			.095	.095	.095
2-5/8 x .063	.095	.095	.095		
3 x .063	.095				



# ARMOR™ Specifications (mm)

## ARMOR™ CT BLACK

TPI	2.5/3.4	1.8/2.0	1.4/1.6	.9/1.1 Deep Gullet Form
Set - Ground	Multi-Chip	Multi-Chip	Multi-Chip	Multi-Chip
Tooth Face Rake Angle	6°	6°	6°	6°
Back Relief Angle	12°	12°	12°	12°
34 x 1.07	1.98	1.98		
41 x 1.27	2.18	2.18	2.18	
54 x 1.60	2.51	2.51	2.51	2.51
67 x 1.60		2.51	2.51	2.51
80 x 1.60				2.51

## ARMOR Rx® +

TPI	4/6		3/4		2/3	
Set Rake Angle	(V-S)		(V-S)		(V-S)	
	8° Standard	8° EHS	8° Standard	8° EHS	10° Standard	EHS
34 x 1.07	1.73	2.29	1.78	2.29	1.78	
41 x 1.27	2.03	2.54	2.03	2.54	2.03	
54 x 1.60			2.51	3.05	2.41	

Red is discontinued

## ARMOR VP

TPI	0.9/1.1	1.0/1.4	1.4/2.0	2/3	3/4
Set - Ground	Multi-Chip	Multi-Chip	Multi-Chip	Multi-Chip	Multi-Chip
Tooth Face Rake Angle	8°	8°	8°	8°	8°
Back Relief Angle	20°	20°	20°	20°	20°
34 x 1.07				1.98	1.98
41 x 1.27			2.18	2.18	2.18
54 x 1.27				2.18	
54 x 1.60			2.41	2.41	2.41
67 x 1.60	2.41	2.41	2.41		
80 x 1.60	2.41				



## Bi-Metal Specifications

### DIEMASTER 2<sup>®</sup>

		Specifications											
TPI	14/18	10/14	8/12	6/10	24	18		14		10	6 H	4 H	3 H
Set	(W)	(V-R)	(V-R)	(V-R)	(R)	(R)	(W)	(MR)	(W)	(MR)	(MR)	(MR)	(MR)
Rake Angle	0°	0°	0°	0°	0°	0°	0°	0°	0°	0°	0°	0°	0°
1/4 x .025	.043	.043									.043		
1/4 x .035		.058									.058		
3/8 x .025	.043	.043											
3/8 x .035										.058	.058	.060	
1/2 x .020	.037	.037			.037		.037		.037				
1/2 x .025	.043	.043	.043	.043		.043		.043			.043	.043	
1/2 x .035		.058						.058	.058	.058	.060	.060	

### CLASSIC<sup>™</sup>

		Specifications											
TPI	18W	14W	10/14	8/12	6/10	5/8	6/8	4/6	3/4		2/3		3 H
Set	(W)	(W)	(V-R)	(V-R)	(V-R)	(V-R)	(V-R)	(V-R)	(V-R)		(V-R)		(MR)
Rake Angle	0°	0°	0°	0°	0°	0°	5°	5°	10° STD	10° EHS	10° STD	10° EHS	10°
3/4 x .035	.058	.058	.058	.058	.058	.058	.058	.058	.060		.060		.060
1 x .035	.058		.058	.058	.058	.058	.058	.058	.070		.070		.080
1-1/4 x .042				.068	.068	.068	.068	.068	.080	.080	.100		
1-1/2 x .050						.080		.080	.080	.082	.082		
2 x .050								.080	.082	.095	.095	.120	
2 x .063								.095	.099	.120	.095	.120	

Red is discontinued

### CLASSIC PRO<sup>™</sup>

		Specifications				
TPI	5/8	4/6	3/4	2/3	1.4/2.0	
Set	5/5	5/5	5/5	5/5	3/5	
Rake Angle	3°	7°	9°	10°	10°	
Relief Angle	30°	30°	30°	28°	28°	
1 x .035	.055	.057	.057	.060		
1-1/4 x .042	.066	.067	.067	.070	.070	
1-1/2 x .050	.078	.079	.079	.082	.082	
1-1/2 x .050			.100			
2 x .050		.079	.082	.082		
2 x .063		.092	.095	.095	.095	
2 x .063			.12	.12		
2-5/8 x .063			.095	.095	.099	
2-5/8 x .063			.12	.12		

EXTRA Heavy Set

5/5 = single level set pattern

### HRX<sup>™</sup>

		Specifications				
TPI	5/7	4/6	3/4	2/3	1.4/2.0	
Set	5T-VL	5T-VL	5T-VL	13T-VL	8T-VL	
Rake Angle	8°	10°	10°	10°	12°	
Relief Angle	18°	20°	20°	20°	20°	
1-1/4 x .042	.065	.065	.090	.090		
1-1/2 x .050		.100	.100	.100		
2 x .063		.115	.115	.120	.120	
2 x .063 (EHS)			.130	.130		
2-5/8 x .063			.115	.125	.125	
2-5/8 x .063 (EHS)			.130	.140		

EXTRA Heavy Set

### Rx<sup>®</sup> +

		Specifications									
TPI	10/14	6/10	5/8	5/7	4/6		3/4		2/3		
Set	5/5 VL	5/5 VL	(V-R)	5/5 VL	(V-S)	(V-S)	(V-S)	(V-S)	(V-S)	(V-S)	
Rake Angle	0°	8°	5°	8°	8°	8°	8°	8°	10°	10°	
Relief Angle	STD	STD	STD	STD	STD	EHS	STD	EHS	STD	EHS	
5/8 x .032	.055 (Mtx)										
3/4 x .035	.054	.054	.058		.058						
1 x .035	.054	.054	.058	.054	.058		.060		.060		
1-1/4 x .042			.058		.068	.090	.070	.090	.070	.090	
1-1/2 x .050			.058		.080	.100	.080	.100	.080	.100	
2 x .050			.058		.080	.105	.080	.105	.095	.105	
2 x .063					.095	.099	.120	.095	.120		
2-5/8 x .063					.095	.099	.120	.095	.120		

Red is discontinued

### LXP<sup>®</sup>

Specifications	
TPI	4/6
Set	(V-R)
Rake Angle	10°
	Milled
3/4 x .035	.058

### CONTESTOR

		Specifications		
TPI	4/6	3/4	2/3	
Set	(V-S)	(V-S)	(V-S)	
Rake Angle	10°	10°	10°	
	Milled	Milled	Milled	
1 x .035	.058	.060	.060	

### CONTESTOR GT<sup>®</sup>

		Specifications					
TPI	4/6	3/4	2/3	1.4/2.0	1.0/1.3	.7/1.0	
Set	(V-S)	(V-S)	(V-S)	(V-S)	(V-S)	(V-S)	
Rake Angle	10°	10°	10°	10°	10°	10°	
	Ground	Ground	Ground	Ground	Ground	Ground	
1-1/4 x .042	.068	.070	.070	.076			
1-1/2 x .050	.080	.082	.082	.088	.095		
2 x .050	.092	.092	.082	.088	.095		
2 x .063	.093	.095	.095	.101	.105	.105	
2-5/8 x .063	.093	.095	.095	.101	.105	.105	
3 x .063				.105	.111	.111	

Red is discontinued

### CONTESTOR XL<sup>®</sup>

		Specifications					
TPI	4/6	3/4	2/3	1.4/2.0	1.0/1.3	.7/1.0	
Set	5T VL	5T VL	5T VL	5T VL	5T VL	5T VL	
Rake Angle	12°	14°	16°	15°	13°	13°	
	Milled	Milled	Milled	Milled	Milled	Milled	
1-1/4 x .042	.068	.070	.070				
1-1/2 x .050		.082	.082	.088			
2 x .050		.095	.095	.101	.105		
2-5/8 x .063				.101	.105	.105	
3 x .063					.111	.111	

### QXP<sup>®</sup>

		Specifications					
TPI	5/8	4/6	3/4	2/3	1.5/2.0	1.0/1.3	
Set	(V-R)	(V-R)	(V-R)	(V-R)	(V-R)	(V-R)	
Rake Angle	5°	10°	12°	12°	12°	12°	
	Milled	Milled	Ground	Ground	Ground	Ground	
1 x .035	.058	.058	.060	.060			
1-1/4 x .042	.068	.068	.070	.070	.070		
1-1/2 x .050		.080	.082	.082	.082		
2 x .063		.093	.095	.095	.099	.105	
2-5/8 x .063			.095	.095	.099	.105	
3 x .063						.111	

DEWALT BAND SAW									
Rake / Relief Angle									
Width X Thickness	TPI								
IN	2/3	3/4	4/6	5/8	6	6/10	8/12	10/14	
1/2 x .025					10/30	0/35	0/35	0/35	
3/4 x .035			5/30	0/35		0/35	0/35	0/35	
1 x .035	10/30	10/30	8/30	0/35		0/35	0/35	0/35	
1-1/4 x .042	10/30	10/30	8/30	0/35		0/35	0/35		
1-1/2 x .050	10/30	10/30	8/30						
					Tuff Tooth	Hook Tooth	Conventional Tooth		

DEWALT BAND SAW									
Set / Set Type									
Width X Thickness	TPI								
IN	2/3	3/4	4/6	5/8	6	6/10	8/12	10/14	
1/2 x .025					.043" - 5 SL	.043" - 17 SL	.043" - 15 SL	.043" - 17 SL	
3/4 x .035			.058" - 7 SL	.058" - 9 SL		.058" - 11 SL	.058" - 15 SL	.058" - 17 SL	
1 x .035	.057" - 5/5 SL	.057" - 5/5 SL	.057" - 5/5 SL	.058" - 9 SL		.058" - 11 SL	.058" - 15 SL	.058" - 17 SL	
1-1/4 x .042	.067" - 5/5 SL	.067" - 5/5 SL	.067" - 5/5 SL	.068" - 9 SL		.068" - 11 SL	.068" - 15 SL		
1-1/2 x .050	.079" - 5/5 SL	.079" - 5/5 SL	.079" - 5/5 SL						



## Bi-Metal Specifications (mm)

### DIEMASTER 2®

		Specifications												
TPI		14/18	10/14	8/12	6/10	24	18		14		10	6 H	4 H	3 H
Set	Rake Angle	(W) 0°	(V-R) 0°	(V-R) 0°	(V-R) 0°	(R) 0°	(R) 0°	(W) 0°	(MR) 0°	(W) 0°	(MR) 0°	(MR) 10°	(MR) 10°	(MR) 10°
6.4 x 0.64		1.09	1.09									1.09		
6.4 x 0.90			1.47									1.47		
9.5 x 0.64		1.09	1.09											
9.5 x 0.90											1.47	1.47	1.52	
12.7 x 0.50		0.94	0.94			0.94		0.94		0.94				
12.7 x 0.64		1.09	1.09	1.09	1.09		1.09		1.09			1.09	1.09	
12.7 x 0.90			1.47							1.47	1.47	1.47	1.52	1.52

### CLASSIC™

		Specifications												
TPI		18W	14W	10/14	8/12	6/10	5/8	6/8	4/6	3/4		2/3		3 H
Set	Rake Angle	(W) 0°	(W) 0°	(V-R) 0°	(V-R) 0°	(V-R) 0°	(V-R) 0°	(V-R) 5°	(V-R) 5°	(V-R) 10° STD		(V-R) 10° EHS		(MR) 10°
19 x 0.90		1.47	1.47	1.47	1.47	1.47	1.47	1.47	1.47	1.47	1.52	1.52		1.52
27 x 0.90		1.47		1.47	1.47	1.47	1.47	1.47	1.47	1.47	1.78	1.78		1.78
34 x 1.07					1.73	1.73	1.73	1.73	1.73	1.73	2.03	2.03		2.03
41 x 1.27								2.03	2.03	2.03	2.54	2.54		2.08
54 x 1.27								2.03	2.03	2.03	2.08	2.08		2.08
54 x 1.60								2.41	2.41	2.41	3.05	3.05		3.05

Red is discontinued

### CLASSIC PRO™

		Specifications				
TPI		5/8	4/6	3/4	2/3	1.4/2.0
Set	Rake Angle	5/5	5/5	5/5	5/5	3/5
Back Relief		3°	7°	9°	10°	10°
		30°	30°	30°	28°	28°
27 x 0.90		1.40	1.45	1.45	1.52	
34 x 1.07		1.68	1.70	1.70	1.78	1.78
41 x 1.27		1.98	2.01	2.01	2.08	2.08
41 x 1.27				2.54		
54 x 1.27 5			2.01	2.08	2.08	
54 x 1.60			2.34	2.41	2.41	2.41
54 x 1.60				3.05	3.05	
67 x 1.60				2.41	2.41	2.51
67 x 1.60 (EHS)				3.05	3.05	

5/5 = single level set pattern

EXTRA Heavy Set

### HRX®

		Specifications				
TPI		5/7	4/6	3/4	2/3	1.4/2.0
Set	Rake Angle	5T-VL	5T-VL	5T-VL	13T-VL	8T-VL
Relief Angle		8°	10°	10°	10°	12°
		18°	20°	20°	20°	20°
34 x 1.07		1.65		2.27		
41 x 1.27			2.54	2.54	2.54	
54 x 1.60			2.92	2.92	3.05	3.05
54 x 1.60 (EHS)				3.30	3.30	
67 x 1.60				2.92	3.16	3.16
67 x 1.60 (EHS)				3.30	3.56	

EXTRA Heavy Set

### Rx® +

		Specifications									
TPI		10/14	6/10	5/8	5/7	4/6		3/4		2/3	
Set	Rake Angle	(V-R) 0°	5/5 VL 8° STD	(V-R) 5° STD	5/5 VL 8° STD	(V-S) 8° STD	(V-S) 8° EHS	(V-S) 8° STD	(V-S) 8° EHS	(V-S) 10° STD	(V-S) 10° EHS
16 x 0.80		1.40 (Mtx)									
19 x 0.90		1.37	1.37	1.47		1.47					
27 x 0.90		1.37	1.37	1.47	1.37	1.47		1.52		1.52	
34 x 1.07				1.47		1.73	2.29	1.78	2.29	1.78	2.29
41 x 1.27				1.47		2.03	2.54	2.03	2.54	2.03	2.54
54 x 1.27				1.47		2.03	2.67	2.03	2.67	2.41	2.67
54 x 1.60						2.41		2.51	3.05	2.41	3.05
67 x 1.60						2.41		2.51	3.05	2.41	3.05

Red is discontinued

### LXP®

Specification	
TPI	4/6
Set	(V-R)
Rake Angle	10°
	Milled
19 x 0.90	1.47

### CONTESTOR

		Specifications		
TPI		4/6	3/4	2/3
Set	Rake Angle	(V-S) 10°	(V-S) 10°	(V-S) 10°
		Milled	Milled	Milled
27 x 0.90		1.47	1.52	1.52

### CONTESTOR GT®

		Specifications					
TPI		4/6	3/4	2/3	1.4/2.0	1.0/1.3	.7/1.0
Set	Rake Angle	(V-S) 10°	(V-S) 10°	(V-S) 10°	(V-S) 10°	(V-S) 10°	(V-S) 10°
		Ground	Ground	Ground	Ground	Ground	Ground
34 x 1.07		1.73	1.78	1.78	.076		
41 x 1.27		2.03	2.08	2.08	2.24	2.41	
54 x 1.27			2.08	2.08	2.24	2.41	
54 x 1.60		2.36	2.41	2.41	2.57	2.67	2.67
67 x 1.60		2.36	2.41	2.41	2.57	2.67	2.67
80 x 1.60					2.67	2.82	2.82

Red is discontinued

**CONTESTOR XL<sup>®</sup>**

	Specifications					
<i>TPI</i>	4/6	3/4	2/3	1.4/2.0	1.0/1.3	.7/1.0
<i>Set</i>	5T VL	5T VL	5T VL	5T VL	5T VL	5T VL
<i>Rake Angle</i>	12°	14°	16°	15°	13°	13°
	Milled	Milled	Milled	Milled	Milled	Milled
1-1/4 x .042	1.73	1.78	1.78			
1-1/2 x .050		2.08	2.08	2.24		
2 x .063		2.41	2.41	2.57	2.67	
2-5/8 x .063				2.58	2.67	2.67
3 x .063					2.82	2.82

**QXP<sup>®</sup>**

	Specifications					
<i>TPI</i>	5/8	4/6	3/4	2/3	1.5/2.0	1.0/1.3
<i>Set</i>	(V-R)	(V-R)	(V-R)	(V-R)	(V-R)	(V-R)
<i>Rake Angle</i>	5°	10°	12°	12°	12°	12°
	Milled	Milled	Ground	Ground	Ground	Ground
1 x .035	1.47	1.47	1.52	1.52		
1-1/4 x .042	1.73	1.73	1.78	1.78	1.78	
1-1/2 x .050		2.03	2.08	2.08	2.08	
2 x .063		2.36	2.41	2.41	2.51	2.67
2-5/8 x .063			2.41	2.41	2.51	2.67
3 x .063						2.82

**DEWALT BAND SAW**

**Rake / Relief Angle**

Width X Thickness		TPI						
MM	2/3	3/4	4/6	5/8	6	6/10	8/12	10/14
12.7 x 0.64					10/30	0/35	0/35	0/35
19 x 0.90			5/30	0/35		0/35	0/35	0/35
27 x 0.90	10/30	10/30	8/30	0/35		0/35	0/35	0/35
34 x 1.07	10/30	10/30	8/30	0/35		0/35	0/35	
41 x 1.27	10/30	10/30	8/30					

Tuff Tooth Hook Tooth Conventional Tooth

**DEWALT BAND SAW**

**Set / Set Type**

Width X Thickness		TPI						
IN	2/3	3/4	4/6	5/8	6	6/10	8/12	10/14
12.7 x 0.64					1.09mm - 5 SL	1.09mm - 17 SL	1.09mm - 15 SL	1.09mm - 17 SL
19 x 0.90			1.47mm - 7 SL	1.47mm - 9 SL		1.47mm - 11 SL	1.47mm - 15 SL	1.47mm - 17 SL
27 x 0.90	1.45mm - 5/5 SL	1.45mm - 5/5 SL	1.45mm - 5/5 SL	1.47mm - 9 SL		1.47mm - 11 SL	1.47mm - 15 SL	1.47mm - 17 SL
34 x 1.07	1.70mm - 5/5 SL	1.70mm - 5/5 SL	1.70mm - 5/5 SL	1.73mm - 9 SL		1.73mm - 11 SL	1.73mm - 15 SL	
41 x 1.27	2.01mm - 5/5 SL	2.01mm - 5/5 SL	2.01mm - 5/5 SL					





## Carbon Specifications

### FLEX BACK Specifications

TPI	14	10	6	6	4	1.3	1	6	4	3	2			
Set	(R)	(R)	(R)	(R)	(R)	(R)	(R)	(R)	(R)	(MR)	(R)	(A)	(R)	(A)
Tooth	STD	STD	STD	Skip	Skip	Skip	Skip	Hook	Hook	Hook	Hook	Hook	Hook	Hook
Rake Angle	0°	0°	0°	0°	0°	12°	12°	10°	10°	10°	10°	10°	10°	10°
1/4 x .025	.043	.045		.049	.055			.045	.055					
3/8 x .025	.043	.045						.045	.055		.057	.049		
1/2 x .025	.043	.045	.049					.045	.055	.045	.057			
3/4 x .032	FRICTION ↓ ↓							.052	.062		.064		.072	
1 x .035		.065									.067		.075	
2 x .035						.060	.060							.072

Red is discontinued

### NEO-TYPE® Specifications

TPI	24	18	14	10	8	6	6	4	3
Set	(W)	(R)	(R)	(R)	(R)	(R)	(R)	(R)	(R)
Tooth	STD	STD	STD	STD	STD	STD	Hook	Hook	Hook
Rake Angle	0°	0°	0°	0°	0°	0°	10°	10°	10°
1/4 x .025	.041	.043	.043	.045			.045	.055	
3/8 x .025		.043	.043	.045	.047		.045	.055	.057
1/2 x .025	.041	.043	.043	.045	.047	.049		.055	
5/8 x .032			.050	.052					
3/4 x .032		.050	.050	.052	.054	.056		.062	.064
1 x .035			.053	.055	.057	.059			.067

### #32 WOOD Specifications

TPI	4		3		2	
Set	(R)	(A)	(R)	(A)	(R)	(A)
Tooth	Hook	Hook	Hook	Hook	Hook	Hook
Rake Angle	10°	10°	10°	10°	10°	10°
1/4 x .032	.062	.062				
3/8 x .032	.062	.062	.064	.062		.062
1/2 x .032			.064	.062	.072	



## Carbon Specifications (mm)

### FLEX BACK Specifications

TPI	14	10	6	6	4	1.3	1	6	4	3	2			
Set	(R)	(R)	(R)	(R)	(R)	(R)	(R)	(R)	(R)	(MR)	(R)	(A)	(R)	(A)
Tooth	STD	STD	STD	Skip	Skip	Skip	Skip	Hook	Hook	Hook	Hook	Hook	Hook	Hook
Rake Angle	0°	0°	0°	0°	0°	12°	12°	10°	10°	10°	10°	10°	10°	10°
6.4 x 0.64	1.09	1.14		1.24	1.40			1.14	1.40					
9.5 x 0.64	1.09	1.14						1.14	1.40		1.45	1.24		
12.7 x 0.64	1.09	1.14	1.24					1.14	1.40	1.14	1.45			
19 x 0.80	FRICTION							1.32	1.57		1.63		1.83	
27 x 0.90		1.65									1.70		1.91	
50.8 x 0.90						1.52	1.52							1.83

Red is discontinued

### NEO-TYPE® Specifications

TPI	24	18	14	10	8	6	6	4	3
Set	(W)	(R)	(R)	(R)	(R)	(R)	(R)	(R)	(R)
Tooth	STD	STD	STD	STD	STD	STD	Hook	Hook	Hook
Rake Angle	0°	0°	0°	0°	0°	0°	10°	10°	10°
6.4 x 0.64	1.04	1.09	1.09	1.14			1.14	1.40	
9.5 x 0.64		1.09	1.09	1.14	1.19		1.14	1.40	1.45
12.7 x 0.64	1.04	1.09	1.09	1.14	1.19	1.24		1.40	
16 x 0.80			1.27	1.32					
19 x 0.80		1.27	1.27	1.32	1.37	1.42		1.57	1.63
27 x 0.90			1.35	1.40	1.45	1.50			1.70

### #32 WOOD Specifications

TPI	4		3		2	
Set	(R)	(A)	(R)	(A)	(R)	(A)
Tooth	Hook	Hook	Hook	Hook	Hook	Hook
Rake Angle	10°	10°	10°	10°	10°	10°
6.4 x 0.80	1.57	1.57				
9.5 x 0.80	1.57	1.57	1.63	1.57		1.57
12.7 x 0.80			1.63	1.57	1.83	

## TRI-TECH™

TPI	.6/.8	.9/1.1	1.4/2.0	1.8/2.0	2.5/3.4
Set - Ground	3 Tooth Set Pattern				
Tooth Face Rake Angle	8°				
Back Relief Angle	20°				
1 1/4 x .042				.076	.076
1 1/2 x .050			.090	.090	.090
2 x .063		.111	.111 / .120	.111	.111
2 5/8 x .063	.111	.111 / .120	.111 / .120		
3 x .063	.111	.111			

Discontinued in Red

2" & 2-5/8" EHS Specs available with .120 kerf

## TNT CT®

TPI	2.5/3.4	1.8/2.0	.9/1.1 <small>Shallow Outlet Form</small>
Set - Ground	Triple Chip		
Tooth Face Rake Angle	10°		
Back Relief Angle	17°		
1-1/4 x .042	.078		
1-1/2 x .050	.086	.086	.086
2 x .063	.093	.099	.099
2-5/8 x .063		.099	.099
3 x .063			.099

Discontinued in Red

## Versa Pro

TPI	0.9/1.1	1.0/1.4	1.4/2.0	2/3	3/4
Set - Ground	Triple Chip				
Tooth Face Rake Angle	8°				
Back Relief Angle	20°				
1-1/4 x .042			.078	.078	.078
1-1/2 x .050			.086	.086	.086
2 x .050			.086	.086	
2 x .063	.095	.095	.095	.095	
2-5/8 x .063	.095	.095	.095	.095	
3 x .063	.095				

## TRI-MASTER®

TPI	3	3/4	2/3	1.5/2.3	1.2/1.8
Set - Ground	Triple Chip				
Tooth Face Rake Angle	6°				
Back Relief Angle	20°				
3/8 x .032	.058	.058			
1/2 x .025	.055				
3/4 x .035	.065				
1 x .035	.065	.065	.065		
1-1/4 x .042	.072	.072	.072	.072	
1-1/2 x .050	.080	.080	.080		.080
2 x .063			.093		.093
2-5/8 x .063					.093
3 x .063					.093

Discontinued in Red

## MAX CT

TPI	0.9/1.1	1.0/1.4	1.4/2.0	2/3
Set - Ground	Triple Chip			
Tooth Face Rake Angle	12°			
Back Relief Angle	20°			
1-1/4 x .042				.078
1-1/2 x .050			.086	.086
2 x .050			.086	.086
2 x .063	.099	.099	.099 / .115	.099
2-5/8 x .063	.099	.099	.099	
3 x .063	.099			

2" EHS Specs available with .115 kerf

## HRC™

TPI	3	3/4	2/3
Set - Ground	Triple Chip		
Tooth Face Rake Angle	0°		
Back Relief Angle	12°		
1 x .035	.055		
1-1/4 x .042	.062	.062	
1-1/2 x .050		.070	
2 x .063			.083

## CAST MASTER™

TPI	2	2/3	3	3	3/4
Set - Ground	5 Multi-Chip	5 Multi-Chip	5 Multi-Chip	3 Set Style	5 Multi-Chip
Tooth Face Rake Angle	8°				
Back Relief Angle	20°				
1/2 x .025			.046		
3/4 x .035			.056	.056	.056
1 x .035		.056	.056	.056	.056
1-1/4 x .042	.063	.063	.063		.063
1-1/2 x .050		.086			

Tooth sequence creates 5 chip lowering feed force & noise

## CASTMASTER XL & XLE

TPI	0.6/0.8	0.9/1.1	1.4/2.0	2/3
Set - Ground	Triple Chip			
Tooth Face Rake Angle	XL - 10° & XLE - 12°			
Back Relief Angle	20°			
1-1/4 x .042			.078	
1-1/2 x .050			.086	.086
2 x .063		.099	.099	
2-5/8 x .063		.099	.099	
3 x .063	.099	.099		



## Carbide Specifications (mm)

### TRI-TECH™

TPI	.6/.8	.9/1.1	1.4/2.0	1.8/2.0	2.5/3.4
Set - Ground	3 Tooth Set Pattern				
Tooth Face Rake Angle	8°				
Back Relief Angle	20°				
34 x 1.07				1.93	1.93
41 x 1.27			2.29	2.29	2.29
54 x 1.60		2.82	2.82 / 3.05	2.82	2.82
67 x 1.60	2.82	2.82 / 3.05	2.82 / 3.05		
80 x 1.60	2.82	2.82			

Discontinued in Red 2" & 2-5/8" EHS Specs available with 3.048 kerf

### TNT CT®

TPI	2.5/3.4	1.8/2.0	.9/1.1 <small>Shallow Gullet Form</small>
Set - Ground	Triple Chip		
Tooth Face Rake Angle	10°		
Back Relief Angle	17°		
34 x 1.07	1.98		
41 x 1.27	2.18	2.18	2.18
54 x 1.60	2.36	2.51	2.51
67 x 1.60		2.51	2.51
80 x 1.60			2.51

Discontinued in Red

### MAX CT

TPI	0.9/1.1	1.0/1.4	1.4/2.0	2/3
Set - Ground	Triple Chip			
Tooth Face Rake Angle	12°			
Back Relief Angle	20°			
34 x 1.07				1.98
41 x 1.27			2.18	2.18
54 x 1.60			2.18	2.18
67 x 1.60	2.51	2.51	2.51 / 2.92	2.51
80 x 1.60	2.51	2.51	2.51	

2" EHS Specs available with 2.92 kerf

### TRI-MASTER®

TPI	3	3/4	2/3	1.5/2.3	1.2/1.8
Set - Ground	Triple Chip				
Tooth Face Rake Angle	6°				
Back Relief Angle	20°				
9.5 x 0.80	1.47	1.47			
12.7 x 0.64	1.40				
19 x 0.90	1.65				
27 x 0.90	1.65	1.65	1.65		
34 x 1.07	1.83	1.83	1.83	1.83	
41 x 1.27	2.03	2.03	2.03		2.03
54 x 1.60			2.36		2.36
67 x 1.60					2.36
80 x 1.60					2.36

Discontinued in Red

### Versa Pro

TPI	0.9/1.1	1.0/1.4	1.4/2.0	2/3	3/4
Set - Ground	Triple Chip				
Tooth Face Rake Angle	8°				
Back Relief Angle	20°				
34 x 1.07			1.98	1.98	1.98
41 x 1.27			2.18	2.18	
54 x 1.60	2.41	2.41	2.41	2.41	
67 x 1.60	2.41	2.41	2.41		
80 x 1.60	2.41				

### CAST MASTER™

TPI	2	2/3	3	3	3/4
Set - Ground	Multi-Chip				
Tooth Face Rake Angle	8°				
Back Relief Angle	20°				
12.7 x 0.64			1.40		
19 x 0.90			1.50	1.50	1.50
27 x 0.90		1.50	1.50	1.50	1.50
34 x 1.07	1.68	1.68	1.68		1.68
41 x 1.27		2.18			

Discontinued in Red

### CASTMASTER XL & XLE

TPI	0.6/0.8	0.9/1.1	1.4/2.0	2/3
Set - Ground	Triple Chip			
Tooth Face Rake Angle	XL - 10° & XLE - 12°			
Back Relief Angle	20°			
34 x 1.07			1.98	
41 x 1.27			2.18	2.18
54 x 1.60		2.51	2.51	
67 x 1.60		2.51	2.51	
80 x 1.60	2.51	2.51		

### HRC™

TPI	3	3/4	2/3
Set - Ground	Triple Chip		
Tooth Face Rake Angle	0°		
Back Relief Angle	12°		
27 x 0.90	1.40		
34 x 1.07	1.57	1.57	
41 x 1.27		1.78	
54 x 1.60			2.11

### MASTER-GRIT™

	Continuous		Gulleted		
	Medium	Coarse	Medium	Med-Coarse	
6.4 x 0.50	1.02 - 1.55				
9.5 x 0.64			1.14 - 1.68	1.24 - 1.83	
12.7 x 0.64	1.14 - 1.68		1.14 - 1.68	1.24 - 1.83	
19 x 0.80				1.42 - 2.10	1.70 - 2.62
27 x 0.90	1.40 - 1.93	1.78 - 2.69		1.50 - 2.08	1.78 - 2.69
34 x 1.07					1.96 - 2.87

- \* KERF falls into a width range rather than a specific width because of variances in grit size,
- \* Use CONTINUOUS on materials that are LESS than 1/4" in thickness, interrupted cuts, or reinforced with fiber or steel cords
- \* Use GULLETED on materials that are GREATER than 1/4" in thickness



## WOODMASTER® Specifications

### WOODMASTER® C Specifications

TPI	1	1.1	1.3	2
Set	(R)	(R)	(R)	(R)
Tooth	Hook	Hook	Hook	Hook
Rake Angle	10°	10°	10°	10°
Tooth Space	1"	7/8"	3/4"	1/2"
1.080 x .035			.072	.072
1.080 x .035			.078	.078
1.360 x .035	.080	.080	.080	
1.360 x .042	.085	.085	.085	.085
1.625 x .042	.085	.085	.085	
2.125 x .035	.090		.090	
2.125 x .045	.091	.091	.091	

Red is discontinued

### WOODMASTER® CT Specifications

TPI	.7/1.0	1.3	2
Set-Ground	Flat Top	Triple Chip	Triple Chip
Back Relief Angle	20°	20°	20°
Tooth Space	1" - 1-1/2"	3/4"	1/2"
1.080 x .035			.051 (6')
1.080 x .035		.051 (6')	
2.125 x .035		.051 (12')	
2.125 x .035	.065 (6')		
2.125 x .035	.065 (6')		
2.125 x .035	.072 (6')		
2.125 x .042	.085 (6')		

\* Not a standard product at this time - available as a special ONLY.

### WOODMASTER® B Specifications

TPI	.78	1	1.0/1.3	1.1	1.3	2
Set	(R)	(R)	(R)	(R)	(R)	(R)
Tooth	Hook	Hook	Hook	Hook	Hook	Hook
Rake Angle	10°	10°	10°	10°	10°	10°
Tooth Space	1-1/4"	1"		7/8"	3/4"	1/2"
1.080 x .035					.072	.072
1.360 x .035		.072		.072	.072	
1.360 x .042		.080		.080	.080	
1.625 x .050				.092		
2.125 x .042		.085				
2.125 x .050	.090		.092			
3.165 x .050	.100					

Red is discontinued

### CHIPSWEEP™ Specifications

TPI	1.3
Set	(MR)
Tooth	CHIP SWEEP
Rake Angle	10°
Tooth Space	3/4"
1.080 x .035	.072
1.360 x .042	.082

### PALLETMASTER™ C Specifications

TPI	5/8
Set	(R)
Tooth	
Rake Angle	5°
Tooth Space	
1.360 x .042	.068

### FURNMASTER B Specifications

TPI	2	3
Set	(R)	(A)
Tooth	Hook	Hook
Rake Angle	10°	10°
Tooth Space	1/2"	
3/8 x .035		.060
3/4 x .035	.100	

### PALLETMASTER™ B Specifications

TPI	5/8
Set	(R)
Tooth	
Rake Angle	0°
Tooth Space	
1.360 x .042	.068

### WOODMASTER GT Specifications

TPI	2	1.3	1.1	1
Set	(R)	(R)	(R)	(R)
Tooth	Hook	Hook	Hook	Hook
Rake Angle	10°	10°	10°	10°
Tooth Space	1/2"	3/4"	7/8"	1"
1" x .035	Kerf Side Set	Kerf Side Set	Kerf Side Set	Kerf Side Set
	0.067 .016			
1" x .035	0.079 .022			
1" x .035		.071 .018		
1" x .035		.079 .022		
1-1/4" x .042			.086 .022	
1-1/4" x .042		.086 .022		
1-1/2" x .045			.097 .026	
1-1/2" x .045			.097 .026	
1-1/2" x .055			.107 .026	
1-1/2" x .055			.107 .026	

Green Needs to be Included



## WOODMASTER<sup>®</sup> Specifications (mm)

### WOODMASTER<sup>®</sup> C Specifications

TPI	1	1.1	1.3	2
Set	(R)	(R)	(R)	(R)
Tooth	Hook	Hook	Hook	Hook
Rake Angle	10°	10°	10°	10°
Tooth Space	1"	7/8"	3/4"	1/2"
27 x 0.90			1.83	1.83
34 x 0.90	2.03	2.03	2.03	1.98
34 x 1.07	2.16	2.16	2.16	
41 x 1.07	2.16	2.16	2.16	2.16
54 x 0.90	2.29		2.29	
54 x 1.1	2.31	2.31	2.31	

Red is discontinued

### WOODMASTER<sup>®</sup> CT Specifications

TPI	.7/1.0	1.3	2
Set-Ground	Flat Top	Triple Chip	Triple Chip
Back Relief Angle	20°	20°	20°
Tooth Space	1" - 1-1/2"	3/4"	1/2"
27 x 0.90			1.30 (6°)
54 x 0.90		1.30 (6°)	
54 x 0.90		1.30 (12°)	
54 x 0.90	1.30 (6°)		
54 x 0.90	1.65 (6°)		
54 x 0.90	1.83 (6°)		
54 x 1.07	2.16 (6°)		

\* To be launched Q4, 2008

\* Not a standard product at this time - available as a special ONLY.

### WOODMASTER<sup>®</sup> B Specifications

TPI	.78	1	1.0/1.3	1.1	1.3	2
Set	(R)	(R)	(R)	(R)	(R)	(R)
Tooth	Hook	Hook	Hook	Hook	Hook	Hook
Rake Angle	10°	10°	10°	10°	10°	10°
Tooth Space	1-1/4"	1"		7/8"	3/4"	1/2"
27 x 0.90					1.83	1.83
34 x 0.90		1.83		1.83	1.83	
34 x 1.07		2.03		2.03	2.03	
41 x 1.27				2.34		
54 x 1.07		2.16				
54 x 1.27	2.29		2.34			
80 x 1.27	2.54					

Red is discontinued

### CHIPSWEEP<sup>™</sup> Specifications

TPI	1.3
Set	(MR)
Tooth	CHIP SWEEP
Rake Angle	10°
Tooth Space	3/4"
27 x 0.90	1.83
34 x 1.07	2.08

### PALLETMASTER<sup>™</sup> C Specifications

TPI	5/8
Set	(R)
Tooth	
Rake Angle	5°
Tooth Space	
34 x 1.07	1.73

### FURNMASTER B Specifications

TPI	2	3
Set	(R)	(A)
Tooth	Hook	Hook
Rake Angle	10°	10°
Tooth Space	1/2"	
9.5 x 0.90		1.52
19 x 0.90	2.54	

### PALLETMASTER<sup>™</sup> B Specifications

TPI	5/8
Set	(R)
Tooth	
Rake Angle	0°
Tooth Space	
34 x 1.07	1.73

### WOODMASTER GT Specifications

TPI	2	1.3	1.1	1
Set	(R)	(R)	(R)	(R)
Tooth	Hook	Hook	Hook	Hook
Rake Angle	10°	10°	10°	10°
Tooth Space	1/2"	3/4"	7/8"	1"
	Kerf	Side Set	Kerf	Side Set
27 x 0.9	1.70	.41		
27 x 0.9	2.01	.56		
27 x 0.9		1.80	.046	
27 x 0.9		2.01	.056	
1-1/4" x 1.07			2.18	.56
1-1/4" x 1.07		2.18	.056	
1-1/2" x 1.14			2.46	.66
1-1/2" x 1.14			2.46	.66
1-1/2" x 1.40			2.72	.66
1-1/2" x 1.40			2.72	.66



## Definitions



**ALTERNATE SET PATTERN (A)**

- Every tooth sequence; left, right, left, right, left
- Uniform set angle



**RAKER SET PATTERN (R)**

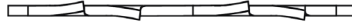
- Three tooth sequence; left, right, straight
- Uniform set angle



**VARI-SET PATTERN (V-S)**

- Multi-level set
- Varying set angles

### **SST CARBIDE™ - SET INFORMATION:**



**RAKER SET PATTERN (R)**

- |                   |                                     |
|-------------------|-------------------------------------|
| Triple Chip Grind | = 2 tooth pattern generates 3 chips |
| Multi-Chip Grind  | = 3 tooth pattern generates 5 chips |
| Flat Top Grind    | No Chamfer                          |



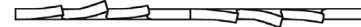
**MODIFIED RAKER SET PATTERN (MR)**

- Five tooth sequence; right, left, right, left, straight
- Uniform set angle



**VARI-RAKER SET PATTERN (V-R)**

- Single level set, extended pattern
- Varying set angles
- 14/18 Vari-tooth has random wavy set

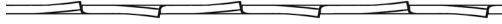


**WAVY SET PATTERN (W)**

- Groups of teeth set to each side
- Teeth have varying amounts of set in a controlled pattern



## Definitions



**ALTERNATE SET PATTERN (A)**

- Every tooth sequence; left, right, left, right, left
- Uniform set angle



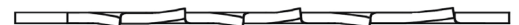
**MODIFIED RAKER SET PATTERN (MR)**

- Five tooth sequence; right, left, right, left, straight
- Uniform set angle



**RAKER SET PATTERN (R)**

- Three tooth sequence; left, right, straight
- Uniform set angle



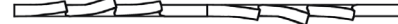
**VARI-RAKER SET PATTERN (V-R)**

- Single level set, extended pattern
- Varying set angles
- 14/18 Vari-tooth has random wavy set



**VARI-SET PATTERN (V-S)**

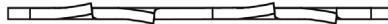
- Multi-level set
- Varying set angles



**WAVY SET PATTERN (W)**

- Groups of teeth set to each side
- Teeth have varying amounts of set in a controlled pattern

### ***SST CARBIDE™ - SET INFORMATION:***



**RAKER SET PATTERN (R)**

Triple Chip Grind = 2 tooth pattern generates 3 chips

Multi-Chip Grind = 3 tooth pattern generates 5 chips