LENOX ADVANTAGE

YOU CUT STEEL. WE CUT COSTS.

LENOX SITE SURVEY
Identify Facility Goals, Metrics, Challenge and Bottlenecks

COMPREHENSIVE OPERATOR TRAINING
Lenox Team Designed and Led Course

MACHINE DIAGNOSTICS: LENOX 13 POINT INSPECTION
Critical Sawing Parameters Emphasis

PRODUCTIVITY & COST SAVINGS
Detailed Recommendations to Improve Productivity

MACHINE UTILIZATION OPTIMIZATION
Minimize Unplanned Downtime

SOLUTIONS & RESOURCES
Offer Sustainability to Realize Cost Savings and Improved Performance

SAWCALC® SOFTWARE
Cut Smarter. Web-Enabled Solution for Your Cutting Challenges

CUSTOMIZED, ACCURATE RECOMMENDATIONS
Identify the right LENOX blade for the job
Determine the correct parameters to satisfy your cutting goals

HIGHLY TECHNICAL, ENGINEERED SOLUTIONS
Built-in intelligence based on years of engineering experience
Over 35,000 metals and 9,000 band saws inside the program

FREE, EASY TO USE AND ALWAYS UPDATED
SAWCALC® Software is updated regularly to include the latest machines, metals, and LENOX products

VISIT SAWCALC.COM
FOR CUSTOMIZED BAND SAW RECOMMENDATIONS

Customer Service: 800-628-8810
Technical Support: 800-642-0010
lenoxtools.com

WE OFFER MORE THAN JUST A BLADE

GUARANTEED GTO TRIAL ORDER

GUARANTEED TRIAL ORDER
The recommended blade will outperform your present blade or your money back – that's the LENOX Guaranteed Trial Order (GTO).

MACHINE TUNE-UP FOR THE BEST SAWING PERFORMANCE
A Factory Trained LENOX Technical Representative will perform a 13-point tune-up to optimize blade and machine performance.

TECHNICAL SUPPORT BY PHONE
Answers to sawing questions are just a toll-free call away. LENOX Technical Service professionals will tell you the most appropriate blade for a job. Get tips on sawing and learn ways to make the job easier. The answers will save money and effort.
Call 800-642-0010, E-mail: info@lenoxtools.com

ONLINE LEARNING PLATFORM TO OPTIMIZE BAND SAW OPERATION
LENOX INSTITUTE OF TECHNOLOGY

The LENOX Institute of Technology provides 24/7 online educational support. Learn more about LENOX LITe BITES educational content at **www.vimeo.com/learnlenox**

LENOX eLearning modules can be found on the BlueVolt eLearning Platform: **https://go.bluevolt.com/stanleyblackanddecker**

BAND-ADE®
Semi-Synthetic Sawing Fluid

- ***Extends Blade Life***
- ***Exceptional Cooling***
- ***Increases Productivity***

CONTAINER SIZE

PROD NO	GALLON	LITER	CONTAINERS PER CASE
68004	1	3.8	4
68005	2-1/2	9.5	2
68003	5	18.9	-
68001	55	208.2 drum	-
68007	275	1,040.9 tote	-

LENOX *100CF™*
Chlorine Free Water Soluble Oil for Heavy Duty Machine Applications

- ***Extremely Versatile***
- ***High Lubricity***
- ***Excellent Sump Life***
- ***Chlorine Free***

CONTAINER SIZE

PROD NO	GALLON	LITER	CONTAINERS PER CASE
1920851	1	3.8	4
1920852	5	18.9	-
1920853	55	208.2 drum	-
1920854	275	1,040 tote	-

LENOX LUBE®
Synthetic Lubricant for Spray Applications

- ***Extends Tool Life***
- ***Reduces Cost***
- ***Optimum Performance on Ferrous Metals***

CONTAINER SIZE

PROD NO	GALLON	LITER	CONTAINERS PER CASE
68014	1	3.8	4
68018	5	18.9	-
68017	55	208.2 drum	-
68016	275	1,040 tote	-

SAW MASTER™
Synthetic Sawing Fluid

- ***Longer Blade Life. Faster Cutting.***
- ***Rejects Most Tramp Oils***
- ***Excellent Sump Life***

CONTAINER SIZE

PROD NO	GALLON	LITER	CONTAINERS PER CASE
68064	1	3.8	4
68061	5	18.9	-
68062	55	208.2 drum	-
68063	275	1,040.9 tote	-

Not recommended for use as a spray lubricant. Mix this product with water as recommended.

MACHINE CLEANER
Prepares Your Sump for the use of LENOX Sawing Fluids

- ***Cleans the Machine Between Changes***
- ***Extends the Life of the Sawing Fluid***
- ***Prevents Contamination When Converting Fluids***

BAND-ADE® and *SAW MASTER™* lubricants not recommended for use as spray lubricants. Mix with water as recommended.

CONTAINER SIZE

PROD NO	GALLON	LITER	CONTAINERS PER CASE
68006	1	3.8	4

For industrial use only. Mix this product with water as recommended.

C/AI™ LUBRICANT
High Lubricity Formulation for Spray Applications

- ***Works Effectively on All Types of Materials***
- ***Increased Productivity***
- ***Extends Tool Life***
- ***Control Costs***

CONTAINER SIZE

PROD NO	GALLON	LITER	CONTAINERS PER CASE
68024	1	3.8	4
68026	5	18.9	-
68025	55	208.2 drum	-
68028	275	1,040 tote	-

Use this product as it comes from the container. Do not mix with water.

CARBIDE BANDSAW BLADES

CARBIDE PRODUCT SELECTION

HIGH PERFORMANCE

ALUMINUM/ NON-FERROUS	CARBON STEELS	STRUCTURAL STEELS	ALLOY STEELS	BEARING STEELS	MOLD STEELS	STAINLESS STEELS	TOOL STEELS	TITANIUM ALLOYS	NICKEL-BASED ALLOYS (INCONEL®)
EASY ←		MACHINABILITY							→ DIFFICULT
	ABLK & AVP				*ARMOR CT™* BLACK & *ARMOR VP™*				
						LENOX MAX CT® Maximum Performance on Aerospace Alloys			
TRI-TECH CT™					*TRI-TECH CT™* Set Style Blade for Difficult to Cut Metals				
VERSA PRO™					*VERSA PRO™* Versatile Carbide Tipped Blade for General Purpose Cutting				
TRI-MASTER®					*TRI-MASTER® & GEN-TECH™*				

SPECIAL APPLICATION

WOOD	COMPOSITES	ALUMINUM (INCLUDING ALUM. CASTINGS)	CASE HARDENED MATERIALS (INCLUDING IHCP CYLINDER SHAFTS)	OTHER (COMPOSITES, TIRES, ETC.)
EASY ←		MACHINABILITY		→ DIFFICULT
			LENOX HRc® Carbide Tipped Blade for Case and Through-Hardened Materials	
CAST MASTER™ / *CAST MASTER™ XL / XLE*		Superior Performance When Sawing Castings		
		TRI-MASTER®		
MASTER-GRIT®			*MASTER-GRIT®* Carbide Grit Edge Blade for Cutting Abrasive and Hardened Materials	

Note: We can provide solutions for many cutting applications not listed here. Please call LENOX *Technical Support at 800-642-0010, or go to sawcalc.com.*

CARBIDE TOOTH SELECTION

LENOX MAX CT® • LENOX *CAST MASTER™* XL • LENOX *CAST MASTER™* XLE • LENOX *VERSA PRO™*
LENOX *ARMOR VP™* • LENOX *GEN-TECH™*

	WIDTH OR DIAMETER OF CUT													
INCHES	1	2	3	4	5	6	7	8	10	11	14	16	18	20+
MM	25	50	75	100	125	150	175	200	250	275	350	400	450	500+
0.6/0.8														
0.9/1.1														
1.0/1.4														
1.4/2.0														
2/3														
3/4														

***ARMOR CT™* BLACK**

	WIDTH OR DIAMETER OF CUT													
INCHES	1	2	3	4	5	6	7	8	10	11	14	16	18	20+
MM	25	50	75	100	125	150	175	200	250	275	350	400	450	500+
0.9/1.1														
1.4/1.6														
1.8/2.0														
2.5/3.4														

TRI-TECH CT™

	WIDTH OR DIAMETER OF CUT													
INCHES	1	2	3	4	5	6	7	8	10	11	14	16	18	20+
MM	25	50	75	100	125	150	175	200	250	275	350	400	450	500+
0.6/0.8														
0.9/1.1														
1.4/2.0														
1.8/2.0														
2.5/3.4														

TRI-MASTER® • LENOX HRc® • CAST MASTER™

	WIDTH OR DIAMETER OF CUT									
INCHES	1	2	3	4	5	6	7	8	10	11
MM	25	50	75	100	125	150	175	200	250	275
2/3										
3										
3/4										

Note: Aluminum and other soft materials cut on machines with extremely high band speed may change your tooth selection. Please call LENOX *Technical Support at 800-642-0010 for more information or go to sawcalc.com.*

CARBIDE SPEED CHART

MATERIALS		ARMOR CT™ BLACK & ARMOR VP™		LENOX VERSA PRO™ & MAX CT		TRI-TECH™ & GEN-TECH™		TRI-MASTER		CAST MASTER™ & CAST MASTER™ XL		LENOX HRc®	
TYPE	GRADE	FPM	MPM	FPM	MPM	FPM	MPM	FPM	MPM	FPM	MPM	FPM	MPM
Aluminum Alloys	2024, 5052, 6061, 7075			200–8,500*	60–2600	200–8,500	60–2,600	200–8,500*	60–2600	200–8,500*	60–2600		
Copper Alloys	C0A 220 C0A 360 Cu Ni (30%) Be-Cu			240 300 220 180	75 90 65 55	240 300 220 180	73 91 67 55	210 295 200 160	65 90 60 50	210 295 200 160	65 90 60 50	280	85
Bronze Alloys	AMPCO 18 AMPCO 21 AMPCO 25 Leaded Tin Bronze Phosphor Bronze 865 Mn Bronze 932 937			205 180 115 250 360 220 300 300	60 55 35 75 90 65 90 90	205 180 115 250 360 220 300 300	62 55 35 75 90 67 91 91	180 160 110 150 165 215 280 250	55 50 35 45 50 65 85 75	180 160 110 150 165 215 280 250	55 50 35 45 50 65 85 75		
Brass Alloys	Cartridge Brass Red Brass (85%) Naval Brass			260 230	80 70	240 230	73 70	220 200	65 60			220 200	65 60
Leaded, Free Machining Low Carbon Steels	1145 1215 12L14	370 425 450	115 130 135	330 325 350	88 99 107	290 325 350	88 99 107	290 325 350	90 100 105				
Structural Steel	A36	350	105	240	73								
Low Carbon Steels	1008, 1018 1030	310 290	95 90	300 260	90 80	250 240	76 73	250 240	75 73			270** 250**	80 75
Medium Carbon Steels	1035 1045	285 275	85 85	240 240	73 73	230 220	70 67	220 220	70 65			240** 230**	75 70
High Carbon Steels	1060 1080 1095	260 250 240	80 75 75									200** 195** 185**	60 60 55
Mn Steels	1541 1524	260 240	80 75										
Cr-Mo Steels	4140 4130 4150H	300 310 290	90 95 90	230 230 230	70 70 70	220 250	67 76						
Cr Alloy Steels	6150 52100 5160	315 300 300	95 90 95	230 290 230	70 88 70	190 190	58 58						
Ni-Cr-Mo Steels	4340 8620 8640 E9310	300 310 305 315	90 95 95 95	230 280 240 190	70 85 73 60	190 190	58 58						
Low Alloy Tool Steel	L-6	300	90	240	75	240	73	190	60				
Water-Hardening Tool Steel	W-1	300	90	240	65	220	67	175	55				
Cold-Work Tool Steel	D-2	240	75	210	65	210	64	170	50				
Air-Hardening Tool Steels	A-2 A-6 A-10	270 240 190	80 75 60	230 220 160	70 65 50	230 220 160	70 67 49	185 175 130	55 55 40				
Hot Work Tool Steels	H-13 H-25	280 180	85 55	220 150	70 45	220 150	67 46	175 120	55 35				
Oil-Hardening Tool Steels	O-1 O-2	260 240	80 75	240 220	75 68	240 220	73 67	190 175	60 55				
High Speed Tool Steels	M-2, M-10 M-4, M-42 T-1 T-15	140 120 120 100	45 35 35 30	110 90 100 80	35 30 30 25	110 90 100 80	34 28 30 24	90 75 80 65	25 25 25 20				
Mold Steels	P-3 P-20	300 280	90 85	200 160	60 50	200 160	61 49	160 130	50 40				
Shock Resistant Tool Steels	S-1 S-5, S-7	220 200	65 60	190 160	60 50								
Stainless Steels	304 316 410, 420 440C	260 240 290 240	80 75 90 75	220 180 250 200	65 55 75 60	190 180 250 200	58 55 76 61	155 125 175 140	45 40 55 45			220 180 250 200	65 55 75 60
Precipitation Hardening Stainless Steels	17-4 PH 15-5 PH	300 300	90 90	160 140	50 45	160 160	49 49	110 100	35 30			160 140	50 45
Free Machining Stainless Steels	420F 301	240 220	105 100	270 230	80 70	270 230	92 70	190 160	60 50			270 230	80 70
Nickel Alloys	Monel® K-500 Duranickel® 301			90 80	25 25	90 80	27 24	90 80	25 25				
Iron-Based Super Alloys	A286, Incoloy® 825 Incoloy 600 Pyromet® X-15			80 75 90	25 25 25	105 85 90	32 26 27	80 75 90	25 25 25				
Nickel-Based Alloys	Inconel® 600, Inconel 718 Nimonic® 90 NI-SPAN-C® 902, RENE® 41 Inconel® 625 Hastelloy B, Waspalloy Nimonic® 75, RENE® 88			85 85 115 75 75	25 25 35 25 25	105 100 105 105 105 100	32 30 32 32 32 32	85 115 75 75	25 25 35 25 25				
Titanium Alloys	CP Titanium Ti-6Al-4V	230 230	70 70	180 180	55 55	180 180	55 55	150 150	45 45				
Cast Irons	A536 (60-40-18) A536 (120-90-02) A48 (Class 25) A48 (Class 40) A48 (Class 60)	360 175 250 160 115	110 55 75 50 35									300 150 220 160 160	90 45 65 50 50

*For metal cutting saws run between 70 and 350 FPM. **Typically for hardened and case hardened carbon steels up to 61 Rc.

FPM = Feet Per Minute | MPM = Meters Per Minute

TRI-MASTER®
Versatile Carbide Tipped Blade

PRECISION TRIPLE CHIP GRIND
Smooth cuts, excellent finish

HIGH PERFORMANCE BACKING STEEL
For long blade life

GENERAL PURPOSE BLADE
Perfect for cutting of a wide variety of materials

WIDTH X THICKNESS		TPI		
IN	MM	2/3	3	3/4
3/8 x .032	9.5 x 0.80		•	
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	•		•

LENOX HRc®
Carbide Tipped Blade for Case and Through-Hardened Materials

HIGH QUALITY, MICRO-GRAINED CARBIDE
Outstanding durability

STRONG TOOTH DESIGN
Superior edge strength and strip resistance

NEW HIGH PERFORMANCE BACKING STEEL
Excellent fatigue life

REPLACES ABRASIVE CUT OFF OPERATIONS

WIDTH X THICKNESS		VARI-TOOTH® TPI		STANDARD TPI
IN	MM	2/3	3/4	3
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		•	
2 x .063	54 x 1.60	•		

MASTER GRIT®
Carbide Grit Edge Blade for Cutting Abrasive and Hardened Materials

TUNGSTEN CARBIDE PARTICLE GRIT
Metallurgically bonded edge

GULLETED
For applications greater than 1/4" (6.4mm) in cross-section

CONTINUOUS
For applications less than 1/4" (6.4mm) in cross-section

WIDTH X THICKNESS		GRIT EDGE PREPARATION					
		GULLETED			CONTINUOUS		
IN	MM	MED	MED COARSE	COARSE	MED	COARSE	
1/4 x .020	6.4 x 0.50				•		
3/8 x .025	9.5 x 0.64	•	•				
1/2 x .025	12.7 x 0.64	•	•		•		
3/4 x .032	19 x 0.80		•	•			
1 x .035	27 x 0.90		•	•	•	•	
1-1/4 x .042	34 x 1.07			•			

CAST MASTER™ & CAST MASTER XL/XLE SERIES
Superior Performance in Aluminum Cutting Applications

LONG BLADE LIFE IN FOUNDRY APPLICATIONS
Special grade of carbide is designed to wear slowly when cutting aluminum

CUTS FREELY AT INCREASED CUTTING RATES
Multi-chip tooth design reduces cutting forces limiting vibration. Precision grind prevents material build up on tooth edge.

WIDTH X THICKNESS		TPI						
IN	MM	0.6/0.8	0.9/1.1	1.4/2.0	2/3	3	3/4
1/2 x 025	12.7 x 0.64					•	
3/4 x 035	19 x 0.90					•	•
1 x .035	27 x 0.90				•	• Δ	
1-1/4 x 042	34 x 1.07			*	•	•	•
1-1/2 x 050	41 x 1.27			* †	•		
2 x 063	54 x 1.60		*				
2-5/8 x 063	67 x 1.60			*			
3 x 063	80 x 1.60	*	*				

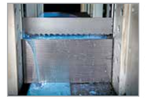
● = Cast Master Design
* = Cast Master XL Design
† = Cast Master XLE Design
Δ = Set-Style Design

VERSA PRO™
Versatile Carbide Tipped Blade for General Purpose Cutting

LONG BLADE LIFE IN A VARIETY OF METALS
Proprietory grade of tungsten carbide tips with increased toughness retain a sharp cutting edge

EASY TO RUN WITH NO BREAK IN®
Pre-honed cutting edge minimizes tooth chipping and eliminates the need to break-in the blade

OUTSTANDING PART FINISH
Precision ground carbide tips have clean, sharp edges that deliver smoother parts



* Break-in recommended for pieces larger than 6" (152mm)

WIDTH X THICKNESS		TPI				
IN	MM	0.9/1.1	1.0/1.4	1.4/2.0	2/3	3/4
1-1/4 x .042	34 x 1.07			•	•	•
1-1/2 x .050	41 x 1.27			•	•	•
2 x .050	54 x 1.60			•	•	
2 x .063	54 x 1.60	•	•	•	•	
2-5/8 x .063	67 x 1.60	•	•	•	•	
3 x .063	80 x 1.60	•				

LENOX ARMOR VP™
Extreme Cutting Rates in a Wide Range of Materials

FASTER CUTTING INCREASES PRODUCTIVITY
AlTiN coating protects the teeth from heat build up to enable faster cutting*

CONSISTENTLY LONGER BLADE LIFE
ARMOR coating increases surface hardness and toughness, slowing tooth wear and extending life*

QUICKLY CUTS A WIDE RANGE OF MATERIALS
Advanced tooth design easily cuts a range of carbon steels, alloy steels, tool steels, stainless steels, and titanium alloys

* vs. non-coated carbide blades

WIDTH X THICKNESS		TPI				
IN	MM	0.9/1.1	1.0/1.4	1.4/2.0	2/3	3/4
1-1/4 x .042	34 x 1.07			•	•	•
1-1/2 x .050	41 x 1.27			•	•	•
2 x .050	54 x 1.27			•	•	
2 x .063	54 x 1.60			•	•	
2 -5/8 x .063	67 x 1.60	•	•	•		
3 x .063	80 x 1.60	•				

LENOX MAX CT®
Maximum Cutting Performance on Aerospace Alloys

EXCEPTIONAL BLADE LIFE
Multi-chip tooth pattern balances the chip load and reduces cutting forces

FASTER, STRAIGHTER CUTS
Optimized gullet geometry increases beam strength for straighter cuts

SUPERIOR PART FINISH
Precision ground carbides create razor sharp teeth for a mirror-like finish on cut parts

WIDTH X THICKNESS		TPI			
IN	MM	0.9/1.1	1.0/1.4	1.4/2.0	2/3
1-1/4 x .042	34 x 1.07				•
1-1/2 x .050	41 x 1.27			•	•
2 x .063	54 x 1.60	•	•	•†	•
2-5/8 x .063	67 x 1.60	•	•	•	
3 x .063	80 x 1.60	•			

† = Extra wide kerf available to prevent blade pinching.

ARMOR CT™ BLACK
For Extreme Cutting Rates

ARMOR COATING PROVIDES FASTER CUTTING AND HIGHER PRODUCTIVITY
Aluminum, Titanium and Nitrogen (AlTiN) combine to form a tough coating that protects each tooth from heat and wear with an armor-like barrier

EXTENDS BLADE LIFE BY PREVENTING HEAT BUILD UP
Improved, thicker coating now forces even more heat into the chips, instead of the blade or workpiece

HIGH PERFORMANCE BACKING STEEL WITH EXCELLENT FATIGUE LIFE
Optimized heat treat and backing steel preparation minimizes premature band breaks

TAILORED TO CUT A WIDE RANGE OF METALS
High quality, micro grained carbide

WIDTH X THICKNESS		TPI				
IN	MM	0.9/1.1	1.4/1.6	1.8/2.0	2.5/3.4	
1-1/4 x .042	34 x 1.07			•	•	
1-1/2 x .050	41 x 1.27		•	•	•	
2 x .063	54 x 1.60	•	•	•	•	
2-5/8 x .063	67 x 1.60	•	•			
3 x .063	80 x 1.60	•				

LENOX GEN-TECH™
Set-Style Carbide Tipped Bandsaw Blade For General Purpose Cutting

COMING SOON

AFFORDABLE PRICE POINT
Low cost per cut

VERSATILE, EASY TO USE
Versatile, set-style tooth design for use on a wide range of materials and saws

LONG BLADE LIFE
Honex Technology™ limits chipping enabling long blade life and productivity

WIDTH X THICKNESS		TPI			
INCH	MM	0.9/1.1	1.4/2.0	2	2/3
1-1/4 x .042	34 x 1.07				•
1-1/2 x .050	41 x 1.27		•	•	•
2 x .063	54 x 1.60		•	•	•
2-5/8 x .063	67 x 1.60	•	•		

WAVE TECH®
Blade Enhancement for Cutting Work Hardening Metals

ENHANCED CUTTING ABILITY
Engineered back edge enhancement creates a unique cutting action that increases tooth penetration without additional machine feed pressure

INCREASED BLADE LIFE*
Proprietary design balances the depth of penetration with cutting force to optimize chip load and reduce frictional wear

Precision chamfer on the back edge of the blade reduces stress risers and minimizes band breaks

FASTER CUTTING RATES*
Design-induced rocking motion improves cutting efficiency and speed by breaking through the work hardening layer

*Vs. Standard LENOX band saw blades

WAVE TECH®

TRI-TECH CT™
Set Style Carbide Blade for Difficult to Cut Metals

STRAIGHT CUTS. NO PINCHING.
Set style tooth pattern eliminates pinching in high stress metals

Wide kerf clearance enables plunge cutting

PROLONGED BLADE LIFE
High grade carbide tips are precision ground for efficient cutting

High performance backing steel minimizes body breakage

EXTREME VERSATILITY
Cuts a range of materials from high strength steels to Nickel-based alloys

WIDTH X THICKNESS		TPI			
IN	MM	0.9/1.1	1.4/2.0	1.8/2.0	2.5/3.4
1-1/4 x .042	34 x 1.07			•	•
1-1/2 x .050	41 x 1.27		•	•	•
2 x .063	54 x 1.60	•	•†	•	•
2-5/8 x .063	67 x 1.60	•†	•†		
3 x .063	80 x 1.60	•			

† = Extra heavy set available to prevent blade pinching

PRODUCT SELECTION DECISION TREE

	VERSA PRO™	MAX CT®	ARMOR BLACK / ARMOR VP™	GEN-TECH™	TRI-TECH™
High Production Rates	B	B	E	G	G
Pinching Concerns	G	G	G	E	B
Surface Finish Req.	B	B	E	G	G
Wide Mix of Materials	E	G	B	B	B
Older / Less Maintained Saws	B	G	G	E	E
Ease of Use / Easy to Run	B	G	G	E	E
Softer Materials	E	G	E	B	B
Thick Wall Tubing	NR	NR	NR	E	E

G = GOOD
B = BETTER
E = EXCELLENT
NR = NOT RECOMMENDED