

Tooth Selection Guide (teeth per inch)

Band saw tooth size (Teeth Per Inch) is determined by the size and type of material to be cut and the desired finish. To select T.P.I. using this chart, find the colored chart for the type of material you wish to cut. Move up to the correct material size next to the chart. Follow across to the chart for the appropriate T.P.I. for your blade.

Material Size (Inches)	Teeth Per Inch	Material Size (Metric)	Wall Thickness (Inches)	Teeth Per Inch	Wall Thickness (Metric)
0		0	1/16	10/14	1.8
.1	14/18	2.5	1/8	8/12	3.2
.2	10/14	5.1	3/16	6/10	4.8
.3	8/12	7.6	1/4	5/8	6.3
.4	8/12	10.2	5/16	5/8	7.9
.5	6/10	12.7	3/8	4/6	9.5
.6	6/10	15.0	7/16	4/6	11.0
.7	5/8	17.8	1/2	4/6	12.7
.8	5/8	20.0	9/16	3/4	14.3
.9	5/8	22.9	5/8	3/4	15.8
1	5/8	25.4	11/16	3/4	17.5
1-1/4	4/6	31.8	3/4	3/4	19.0
1-1/2	4/6	38.1	13/16	3/4	20.6
1-3/4	4/6	44.5	7/8	3/4	22.0
2	4/6	50.8	15/16	2/3	23.8
2-1/4	4/6	57.2	1	2/3	25.4
2-1/2	4/6	63.5	1-1/8	2/3	28.6
2-3/4	4/6	69.9	1-1/4	2/3	32.0
3	3/4	76.2	1-3/8	2/3	35.0
3-1/4	3/4	82.6	1-1/2	2/3	38.0
3-1/2	3/4	88.9			
3-3/4	3/4	95.3			
4	3/4	101.6			
5	2/3	127.0			
6	2/3	152.4			
7	2/3	177.8			
8	2/3	203.0			
9	2/3	228.6			
10	1.4/2.5	254.0			
15	1/1.5	381.0			
30	1/1.5	762			

 **Rectangular Solids:**
(Use Width)
  **Round Solids:**
(Use Diameter)



Pipe Tubing Structurals
(Use Wall Thickness)

Cutting speed - structurals rule of thumb:

When cutting structurals use a cutting speed of
250-325 S.F.M. Wet • 200-250 S.F.M. Dry