

Bandsaw Tooth Selection Guide

For Excision Metal Cutting Bandsaw Blades



Excision Normal Tooth

Excision Profile Tooth



Solids

Vari-Pitch Tothing		TCT toothing (Materials over 50 HRc)	
Material Diameter (D) mm	Teeth Per Inch	Material Diameter (D) mm	Teeth Per Inch
0-5	18	50-120	3/4
4-8	14	100-250	2/3
2-15	10/14	150-400	1.5/2
8-20	8/12	350-600	1.1/1.6
16-30	6/10	500+	0.85/1.15
25-40	5/8		
35-70	4/6		
60-120	3/4		
80-200	2/3		
120-400	1.5/2		
250+	1.1/1.6		
400+	0.75/1.25		

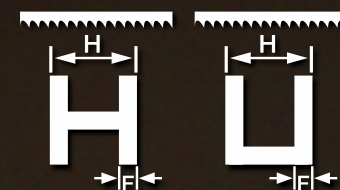


Tubes and RHS

Tube Width (W) mm	Wall Thickness (T)															
	1	1.6	2	2.5	3	4	5	6	7	8	9	10	12	15	20	50
10	14	10/14	10/14													
20	14	10/14	10/14	10/14	8/12											
25	14	10/14	10/14	10/14	8/12	8/12										
30	14	10/14	10/14	10/14	8/12	8/12	6/10									
40	14	10/14	10/14	10/14	8/12	8/12	6/10	5/8	5/8	5/8						
50	14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	5/8						
60-120	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	3/4	3/4	
130-150		10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4	3/4
150-180			10/14	8/12	6/10	6/10	5/8	4/6	4/6	4/6	4/6	4/6	4/6	3/4	3/4	2/3
190-300				6/10	6/10	5/8	4/6	4/6	4/6	4/6	4/6	4/6	4/6	3/4	3/4	2/3
350-400					6/10	6/10	5/8	4/6	4/6	4/6	4/6	4/6	4/6	3/4	3/4	2/3
450-500								4/6	4/6	3/4	3/4	3/4	3/4	3/4	3/4	2/3

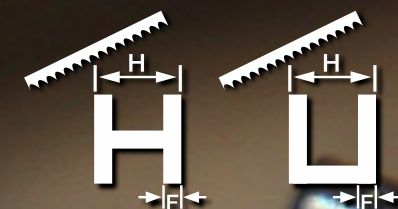
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More info overleaf...



Universal Beam - 0° Saw Angle

Beam Size (H)	Wall Thickness (F)						
	7	8	9	10	12	14	16 20
150	5/8	4/6	4/6				
180		4/6	4/6	4/6			
200		3/4	3/4	3/4			
250			3/4	3/4	3/4		
310			2/3	2/3	2/3		
360				2/3	2/3	2/3	
410				2/3	2/3	2/3	
460					2/3	2/3	2/3
530					2/3	2/3	2/3
610					1.5/2	1.5/2	1.5/2



Universal Beam - 5° Saw Angle

Beam Size (H)	Wall Thickness (F)						
	7	8	9	10	12	14	16 20
150	6/10	6/10	6/10				
180		6/10	6/10	6/10			
200		4/6	4/6	4/6			
250			4/6	4/6	4/6		
310			4/6	4/6	4/6		
360				4/6	4/6	4/6	
410				4/6	4/6	4/6	
460					4/6	4/6	4/6
530					4/6	4/6	4/6
610						3/4	3/4 3/4



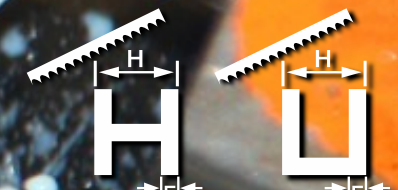
Bundle Cut Tubes and RHS

Tube Width (W) mm	Wall Thickness (T)															
	1	1.6	2	2.5	3	4	5	6	7	8	9	10	12	15	20	50
10	14	8/11	8/11													
20	14	8/11	8/11	8/11	8/11											
25	14	8/11	8/11	8/11	8/11	8/11										
30	14	8/11	8/11	8/11	8/11	8/11	5/7	5/7								
40	10/14	8/11	8/11	8/11	8/11	8/11	5/7	5/7	5/7	4/6	4/6					
50	10/14	8/11	8/11	8/11	8/11	8/11	5/7	5/7	5/7	4/6	4/6	4/6				
60-120	10/14	8/11	8/11	8/11	8/11	8/11	5/7	5/7	5/7	4/6	4/6	4/6	3/4	3/4	3/4	3/4
130-150		8/11	8/11	8/11	8/11	8/11	5/7	5/7	4/6	4/6	4/6	4/6	3/4	3/4	3/4	2/3
150-180			8/11	8/11	8/11	8/11	5/7	5/7	4/6	4/6	4/6	4/6	3/4	3/4	3/4	2/3
190-300				8/11	8/11	8/11	5/7	5/7	4/6	4/6	4/6	4/6	3/4	3/4	3/4	2/3
350-400					8/11	8/11	5/7	5/7	4/6	4/6	4/6	4/6	3/4	3/4	3/4	2/3
450-500									4/6	4/6	4/6	4/6	3/4	3/4	3/4	2/3



Universal Beam - 0° Saw Angle

Beam Size (H)	Wall Thickness (F)						
	7	8	9	10	12	14	16 20
150	4/6	4/6	4/6				
180		3/4	3/4	3/4			
200		3/4	3/4	3/4			
250			2/3	2/3	2/3		
310			2/3	2/3	2/3		
360				2/3	2/3	2/3	
410				2/3	2/3	2/3	
460					2/3	2/3	2/3
530					1.5/2	1.5/2	1.5/2
610					1.5/2	1.5/2	1.5/2



Universal Beam - 5° Saw Angle

Beam Size (H)	Wall Thickness (F)						
	7	8	9	10	12	14	16 20
150	5/7	5/7	5/7				
180		5/7	5/7	5/7			
200		4/6	4/6	4/6			
250			4/6	4/6	4/6		
310			4/6	4/6	4/6		
360				4/6	4/6	4/6	
410				4/6	4/6	4/6	
460					4/6	4/6	4/6
530					4/6	4/6	4/6
610						3/4	3/4 3/4



Excision Metal Bandsaw Blades are distributed by



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