Sydney: (02) 9890 9111
Brisbane: (07) 3715 2200
Melbourne: (03) 9212 4422
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Product Brochure For B469A

# Metal Band Saw Blade - 3-4TPI Bi-Metal, Blade - 3505 x 34 x 1.1mm

Suits Stainless Steel

SUITS AH-250H Metal Cutting Band Saw Current Model




| | |
|---|---|
| ORDER CODE: | B469A |
| Suits Band Saw Models: | AH-250H |
| Blade Size (L x W x T) (mm): | 3505 x 34 x 1.1 |
| Number of teeth per inch (TPI): | 3-4 |
| Blade Type: | BI-METAL |
| Blade Suitable for - Material Type: | Mild & Stainless Steel |
| Suits Section Size (mm): | 81-120 |

## Description

Please Note:
Starrett Blades are distributed in Sydney, Adelaide & Brisbane, Auckland & Christchurch
Excision Blades are distributed in Melbourne & Perth

IMPORTANT RUN-IN INSTRUCTIONS FOR BI-METAL BLADES
- Avoid excessive feed pressure on run-in
- Run-in at 3/4 normal feed pressure for first 25 square inches on tough material
- After run-in, gradually increase feed to maximum cutting rate

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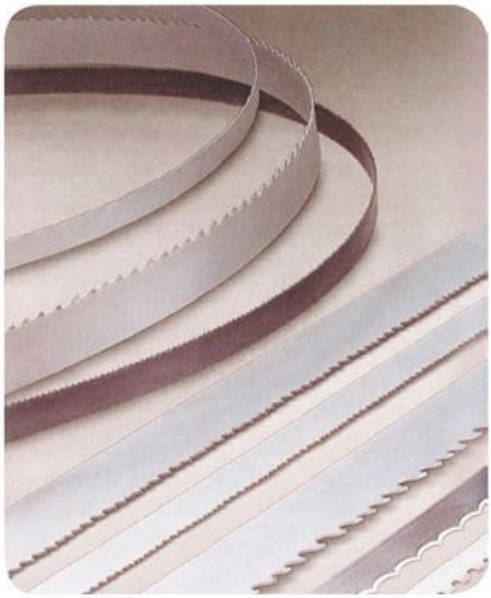
# BLADE SELECTION CHARTS

Band saw tooth size is determined by the size of the cross section to be cut. In general cutting thinner sections requires more teeth per inch, thicker sections require coarser pitches, or less teeth per inch.

To select an appropriate tooth size please refer to the table immediately below unless material to be cut is a tube, in which case refer to the larger table below. For general purpose cutting use a constant pitch blade, for more aggressive production cutting of harder to cut materials use a variable pitch blade.

## SOLID SECTION

| Section Size (mm) | Constant Pitch (TPI) | Variable Pitch (TPI) |
|---|---|---|
| **Up to 10** | 24 or 18 | 14/18 or 10/14 |
| **10-15** | 14 | 8-12 |
| **16-30** | 10 | 6-10 |
| **31-50** | 8 | 5-8 |
| **51-80** | 6 | 4-6 |
| **81-120** | 4 | 3-4 |
| **121-200** | 3 | 2-3 |
| **Over 200** | 2 or 1.25 | 1.4-2 or 0.8-1.3 |



## TUBE SECTION

| Wall Thickness (mm) | Outside diameter of tube or maximum profile section length (mm) | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 20 | 40 | 60 | 80 | 100 | 120 | 150 | 200 | 300 | 500 | 600 | 700 | 800 |
| **2** | 14 | 14 | 14 | 14 | 14 | 14 | 10-14 | 10-14 | 8-12 | 8-12 | 6-10 | 5-8 | 5-8 |
| **3** | 14 | 14 | 10-14 | 10-14 | 10-14 | 10-14 | 8-12 | 8-12 | 6-10 | 6-10 | 5-8 | 5-8 | 5-8 |
| **4** | 14 | 14 | 10-14 | 10-14 | 8-12 | 8-12 | 6-10 | 6-10 | 5-8 | 5-8 | 4-6 | 4-6 | 4-6 |
| **5** | 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 |
| **6** | 14 | 10-14 | 10-14 | 8-12 | 8-12 | 6-10 | 6-10 | 5-8 | 5-8 | 4-6 | 4-6 | 3-4 | 3-4 |
| **8** | 14 | 10-14 | 8-12 | 8-12 | 6-10 | 6-10 | 5-8 | 5-8 | 4-6 | 4-6 | 3-4 | 3-4 | 3-4 |
| **10** | | 8-12 | 8-12 | 6-10 | 6-10 | 5-8 | 5-8 | 4-6 | 4-6 | 3-4 | 3-4 | 3-4 | 3-4 |
| **12** | | 8-12 | 6-10 | 6-10 | 5-8 | 5-8 | 4-6 | 4-6 | 3-4 | 3-4 | 3-4 | 3-4 | 2-3 |
| **15** | | | 6-10 | 5-8 | 5-8 | 4-6 | 4-6 | 4-6 | 3-4 | 3-4 | 3-4 | 2-3 | 2-3 |
| **20** | | | | 5-8 | 4-6 | 4-6 | 4-6 | 3-4 | 3-4 | 2-3 | 2-3 | 2-3 | 2-3 |
| **30** | | | | | 4-6 | 4-6 | 3-4 | 3-4 | 3-4 | 2-3 | 2-3 | 2-3 | 2-3 |
| **50** | | | | | | 3-4 | 3-4 | 3-4 | 2-3 | 2-3 | 2-3 | 2-3 | 2-3 |
| **75** | | | | | | | 2-3 | 2-3 | 2-3 | 2-3 | 2-3 | 1.4-2 | 1.4-2 |