



*CARBIDE*

***BANDSAW***

*BLADES*





## CARBIDE PRODUCT SELECTION

| HIGH PERFORMANCE                      |                  |   |                             |                   |  |                     |                |                                    |                                   |   |  |
|---------------------------------------|------------------|---|-----------------------------|-------------------|--|---------------------|----------------|------------------------------------|-----------------------------------|---|--|
| ALUMINUM/<br>NON-FERROUS              | CARBON<br>STEELS | STRUCTURAL<br>STEELS  | ALLOY<br>STEELS             | BEARING<br>STEELS | MOLD<br>STEELS   | STAINLESS<br>STEELS | TOOL<br>STEELS | TITANIUM<br>ALLOYS                 | NICKEL-BASED<br>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<br>(INCLUDING ALUM. CASTINGS)                                |                             |                   | CASE HARDENED MATERIALS<br>(INCLUDING IHCP CYLINDER SHAFTS)                      |                     |                | OTHER<br>(COMPOSITES, TIRES, ETC.) |                                   |   |  |
| EASY ←                                |                  |   |                             |                   | MACHINABILITY  |                     |                |                                    |                                   | → DIFFICULT   |  |
| CAST MASTER™<br>CAST MASTER™ XL / XLE |                  |   |                             |                   | Superior Performance<br>When Sawing Castings                                     |                     |                |                                    |                                   | LENOX HRc® Carbide Tipped Blade for Case and Through-Hardened Materials |  |
| 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.

### 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 |                     |        |                |                   |
|-------------------|-------------|-----------------------|---------------------|--------|----------------|-------------------|
| IN                | MM          | MED                   | GULLETED MED COARSE | COARSE | CONTINUOUS MED | CONTINUOUS 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

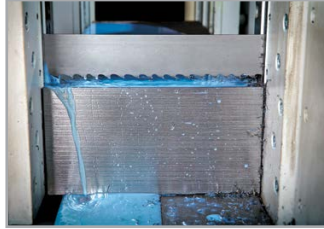
Proprietary grade of tungsten carbide with increased toughness retain a sharp cutting edge

##### 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\*

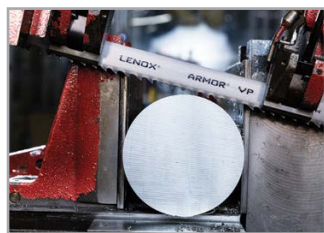
##### CONSISTENTLY LONGER BLADE LIFE

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

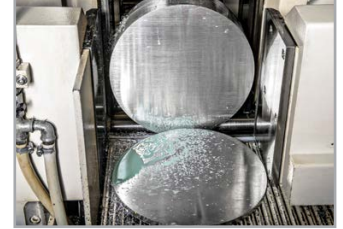
Multi-chip tooth pattern balances the chip load and reduces cutting forces

##### 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.

### 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

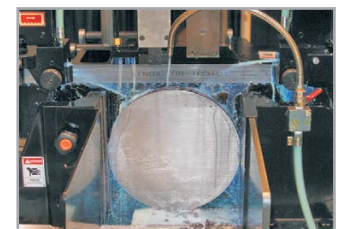
##### PROLONGED BLADE LIFE

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



## LENOX GEN-TECH™

COMING SOON

Entry Level Price Point, Set-Style Carbide Tipped Band Saw Blade For General Purpose Cutting

### AFFORDABLE PRICE POINT

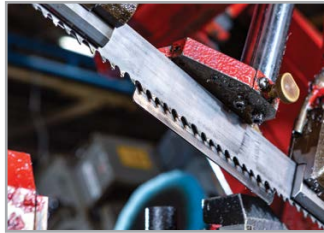
Low cost per cut

### 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 | ●       | ●       |   |     |

## 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

## 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



### **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 SPEED CHART

FPM = Feet Per Minute | MPM = Meters Per Minute \*For metal cutting saws run between 275 and 350 FPM. \*\*Typically for hardened and case hardened carbon steels up to 61 Rc.

| MATERIALS                                |   | ARMOR CT™<br>BLACK &<br>ARMOR VP™ |                             | LENOX VERSA<br>PRO™ & MAX CT                         |  | TRI-TECH™ &<br>GEN-TECH™                             |  | TRI-MASTER®  |  | CAST MASTER™ &<br>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                            | CDA 220<br>CDA 360<br>Cu Ni (30%)<br>Be Cu  |                                   |                             | 240<br>300<br>220<br>180                             | 75<br>90<br>65<br>55                         | 240<br>300<br>220<br>180                             | 73<br>91<br>67<br>55                         | 210<br>295<br>200<br>160                             | 65<br>90<br>60<br>50                         | 210<br>295<br>200<br>160                             | 65<br>90<br>60<br>50                         | 280                             | 85                         |
| Bronze Alloys                            | AMPCO 18<br>AMPCO 21<br>AMPCO 25<br>Leaded Tin Bronze<br>Al Bronze 865<br>Mn Bronze<br>932<br>937                                       |                                   |                             | 205<br>180<br>115<br>300<br>200<br>220<br>300<br>300 | 60<br>55<br>35<br>90<br>60<br>65<br>90<br>90 | 205<br>180<br>115<br>300<br>180<br>220<br>300<br>300 | 62<br>55<br>35<br>91<br>55<br>67<br>91<br>91 | 180<br>160<br>110<br>290<br>150<br>215<br>280<br>250 | 55<br>50<br>35<br>90<br>45<br>65<br>85<br>75 | 180<br>160<br>110<br>290<br>150<br>215<br>280<br>250 | 55<br>50<br>35<br>90<br>45<br>65<br>85<br>75 |                                 |                            |
| Brass Alloys                             | Cartridge Brass<br>Red Brass (85%)<br>Naval Brass   |                                   |                             | 260<br>230   | 80<br>70                                     | 240<br>230   | 73<br>70                                     | 220<br>200   | 65<br>60                                     |  |  | 220<br>200                      | 65<br>60                   |
| Leaded, Free Machining Low Carbon Steels | 1145<br>1215<br>12L14   | 370<br>425<br>450                 | 115<br>130<br>135           | 290<br>325<br>350                                    | 88<br>99<br>107                              | 290<br>325<br>350                                    | 88<br>99<br>107                              | 290<br>325<br>350                                    | 90<br>100<br>105                             |  |  |                                 |                            |
| Structural Steel                         | A36   | 350                               | 105                         | 240  | 73   |  |  |  |  |  |  |                                 |                            |
| Low Carbon Steels                        | 1008, 1018<br>1030  | 310<br>290                        | 95<br>90                    | 300<br>260   | 90<br>80                                     | 250<br>240   | 76<br>73                                     | 250<br>240   | 75<br>75                                     |  |  | 270**<br>250**                  | 80<br>75                   |
| Medium Carbon Steels                     | 1035<br>1045  | 285<br>275                        | 85<br>85                    | 240<br>240   | 73<br>73                                     | 230<br>220   | 70<br>67                                     | 230<br>220   | 70<br>65                                     |  |  | 240**<br>230**                  | 75<br>70                   |
| High Carbon Steels                       | 1060<br>1080<br>1095  | 260<br>250<br>240                 | 80<br>75<br>75              |  |  |  |  |  |  |  |  | 200**<br>195**<br>185**         | 60<br>60<br>55             |
| Mn Steels                                | 1541<br>1524  | 260<br>240                        | 80<br>75                    |  |  |  |  |  |  |  |  |                                 |                            |
| Cr-Mo Steels                             | 4140<br>41L50<br>4150H  | 300<br>310<br>290                 | 95<br>95<br>90              | 230<br>230<br>230                                    | 70<br>70<br>70                               | 220<br>250   | 67<br>76                                     |  |  |  |  |                                 |                            |
| Cr Alloy Steels                          | 6150<br>52100<br>5160   | 315<br>300<br>315                 | 95<br>90<br>95              | 230<br>290<br>230                                    | 70<br>88<br>70                               | 190<br>190   | 58<br>58                                     |  |  |  |  |                                 |                            |
| Ni-Cr-Mo Steels                          | 4340<br>8620<br>8640<br>E9310   | 300<br>310<br>305<br>315          | 90<br>95<br>95<br>95        | 230<br>280<br>240<br>190                             | 70<br>85<br>73<br>60                         | 190<br>190   | 58<br>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<br>A-6<br>A-10  | 270<br>240<br>190                 | 80<br>75<br>60              | 230<br>220<br>160                                    | 70<br>65<br>50                               | 230<br>220<br>160                                    | 70<br>67<br>49                               | 185<br>175<br>130                                    | 55<br>55<br>40                               |  |  |                                 |                            |
| Hot Work Tool Steels                     | H-13<br>H-25  | 240<br>180                        | 75<br>55                    | 220<br>150   | 55<br>45                                     | 220<br>150   | 67<br>46                                     | 175<br>120   | 55<br>35                                     |  |  |                                 |                            |
| Oil-Hardening Tool Steels                | O-1<br>O-2  | 260<br>240                        | 80<br>75                    | 240<br>220   | 75<br>65                                     | 240<br>220   | 73<br>67                                     | 190<br>175   | 60<br>55                                     |  |  |                                 |                            |
| High Speed Tool Steels                   | M-2, M-10<br>M-4, M-42<br>T-1<br>T-15   | 140<br>130<br>120<br>100          | 45<br>40<br>35<br>30        | 110<br>105<br>100<br>80                              | 35<br>30<br>30<br>25                         | 110<br>105<br>100<br>80                              | 34<br>32<br>30<br>24                         | 90<br>85<br>80<br>65                                 | 25<br>25<br>25<br>20                         |  |  |                                 |                            |
| Mold Steels                              | P-3<br>P-20   | 300<br>280                        | 90<br>85                    | 200<br>160   | 60<br>50                                     | 200<br>160   | 61<br>49                                     | 160<br>130   | 50<br>40                                     |  |  |                                 |                            |
| Shock Resistant Tool Steels              | S-1<br>S-5, S-7   | 220<br>200                        | 65<br>60                    | 190<br>190   | 60<br>60                                     |  |  |  |  |  |  |                                 |                            |
| Stainless Steels                         | 304<br>316<br>410, 420<br>440A<br>440C  | 260<br>240<br>290<br>250<br>240   | 80<br>75<br>90<br>75<br>75  | 220<br>180<br>250<br>200<br>200                      | 65<br>55<br>75<br>60<br>60                   | 190<br>180<br>250<br>200<br>200                      | 58<br>55<br>76<br>61<br>61                   | 155<br>125<br>175<br>140<br>140                      | 45<br>40<br>55<br>45<br>45                   |  |  | 220<br>180<br>250<br>200<br>200 | 65<br>55<br>75<br>60<br>60 |
| Precipitation Hardening Stainless Steels | 17-4 PH<br>15-5 PH  | 300<br>300                        | 90<br>90                    | 160<br>140   | 50<br>45                                     | 160<br>160   | 49<br>49                                     | 110<br>100   | 35<br>30                                     |  |  | 160<br>140                      | 50<br>45                   |
| Free Machining Stainless Steels          | 420F<br>301   | 340<br>320                        | 105<br>100                  | 270<br>230   | 80<br>70                                     | 270<br>230   | 82<br>70                                     | 190<br>160   | 60<br>50                                     |  |  | 270<br>230                      | 80<br>70                   |
| Nickel Alloys                            | Monel® K-500<br>Duranickel® 301   |                                   |                             | 90<br>80   | 25<br>25                                     | 90<br>80   | 27<br>24                                     | 90<br>80   | 25<br>25                                     |  |  |                                 |                            |
| Iron-Based Super Alloys                  | A286, Incoloy® 825<br>Incoloy 600<br>Pyromet® X-15  |                                   |                             | 80<br>75<br>90                                       | 25<br>25<br>25                               | 105<br>85<br>90                                      | 32<br>26<br>27                               | 80<br>75<br>90                                       | 25<br>25<br>25                               |  |  |                                 |                            |
| Nickel-Based Alloys                      | Inconel® 600, Inconel 718<br>Nimonic® 90<br>NI-SPAN-C® 902, RENE® 41<br>Inconel® 625<br>Hastalloy B, Waspalloy<br>Nimonic® 75, RENE® 88 |                                   |                             | 85<br>85<br>115<br>75<br>75                          | 25<br>25<br>35<br>25<br>25                   | 105<br>100<br>105<br>105<br>105                      | 32<br>30<br>32<br>32<br>30<br>32             | 85<br>85<br>115<br>75<br>75                          | 25<br>25<br>36<br>25<br>25                   |  |  |                                 |                            |
| Titanium Alloys                          | CP Titanium<br>Ti-6Al-4V  | 230<br>230                        | 70<br>70                    | 180<br>180   | 55<br>55                                     | 180<br>180   | 55<br>55                                     | 150<br>150   | 45<br>45                                     |  |  |                                 |                            |
| Cast Irons                               | A536 (60-40-18)<br>A536 (120-90-02)<br>A48 (Class 20)<br>A48 (Class 40)<br>A48 (Class 60)   | 360<br>175<br>250<br>160<br>115   | 110<br>55<br>75<br>50<br>35 |  |  |  |  |  |  |  |  | 300<br>150<br>220<br>160<br>160 | 90<br>45<br>65<br>50<br>50 |



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