



CARBIDE BAND SAW 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											
ARMOR® CT BLACK Extreme Cutting Rates											
LENOX MAX CT™											
TRI-TECH CT™											
TRI-MASTER®											

SPECIAL APPLICATION									
WOOD	COMPOSITES	ALUMINUM (INCLUDING ALUM. CASTINGS)	CASE HARDENED MATERIALS (INCLUDING IHCP CYLINDER SHAFTS)	OTHER (COMPOSITES, TIRES, ETC.)					
EASY ←		MACHINABILITY			→ DIFFICULT				
CAST MASTER™ CAST MASTER™ XL / XLE			LENOX HRC Carbide Tipped Blade for Case and Through-Hardened Materials						
		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														
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										

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	14	16	18	20+
MM	25	50	75	100	125	150	175	200	250	275	350	400	450	500+
											1.2/1.8			
											1.5/2.3			
											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.



SAWING FLUIDS & LUBRICANTS

BAND-ADE®
Semi-synthetic Sawing Fluid

Extends Blade Life
Exceptional Cooling
Increases Productivity
Environmentally Friendly
Surfaces Can Be Welded and Painted Over



LENOX CF100®
Chlorine Free Water Soluble Oil for Heavy Duty Machine Applications

Extremely Versatile
High Lubricity
Excellent Sump Life
Chlorine Free
Surfaces Can Be Welded and Painted Over



LENOX LUBE®
Synthetic Lubricant for Spray Applications

Extends Tool Life
Clean and Environmentally Friendly
Reduces Cost
Optimum Performance on Ferrous Metals
Surfaces Can Be Welded and Painted Over
Use with MICRONIZER® or MICRONIZER, JR.



WE OFFER MORE THAN
JUST A BLADE



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.

SEMINARS INCREASE PRODUCTIVITY

Seminars offered at your facility to increase the efficiency of your operators and minimize downtime.

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

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

SAW MASTER™
Synthetic Sawing Fluid

Longer Blade Life. Faster Cutting.
Rejects Most Tramp Oils
Excellent Sump Life
Can Be Used in Most Hard Water Applications
Surfaces Can Be Welded and Painted Over
Low to Non-Foaming



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 not recommended for use as a spray lubricant. Mix with water as recommended.



C/AI LUBE®
High Lubricity Formulation for Spray Applications

Works Effectively on All Types of Materials
Increased Productivity
Extends Tool Life
Control Costs
Use with MICRONIZER or MICRONIZER, JR.



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

CUSTOMIZED, ACCURATE RECOMMENDATIONS TO OPTIMIZE BLADE LIFE

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 is updated regularly to include the latest machines, metals, and LENOX products.

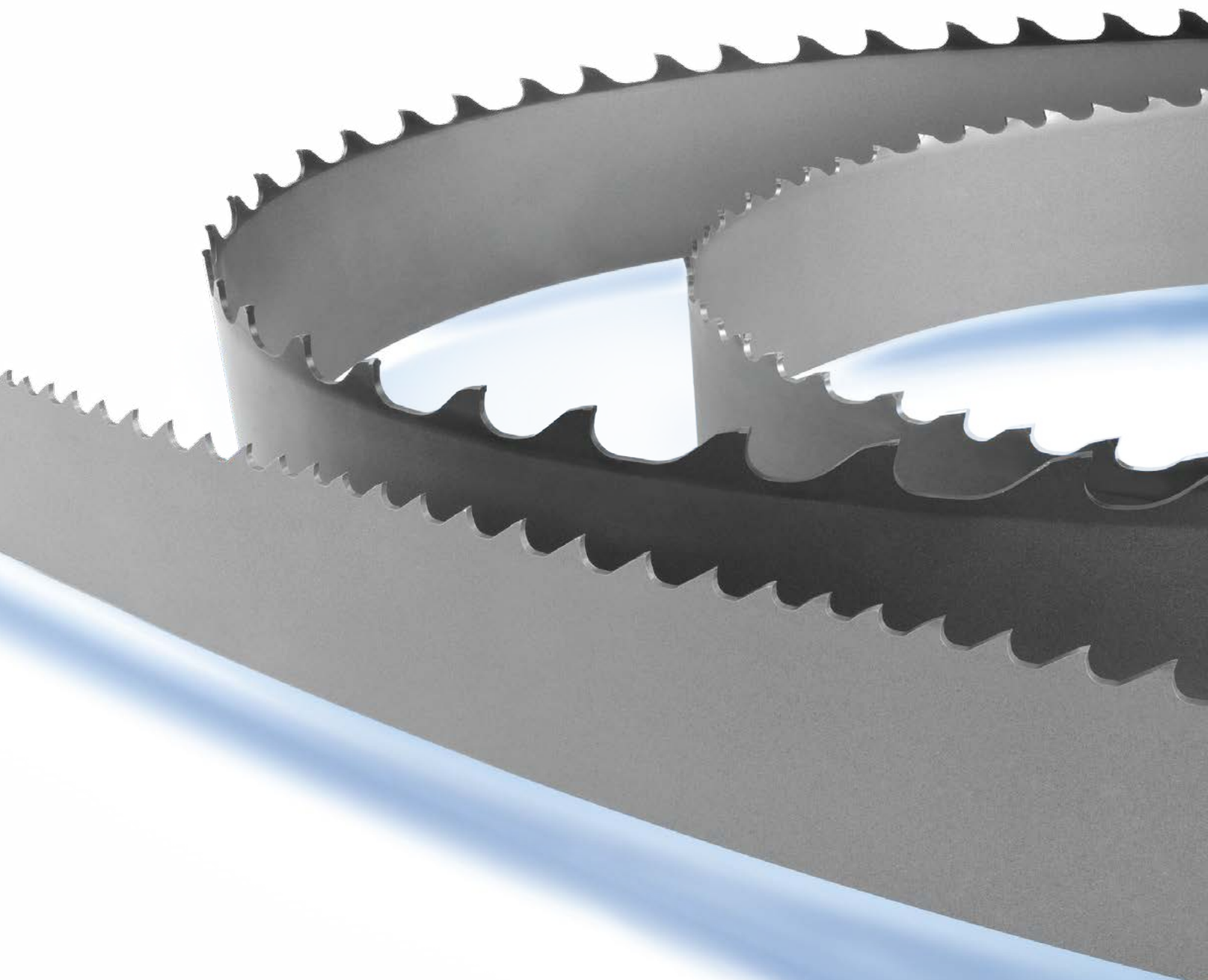
VISIT SAWCALC.COM
FOR CUSTOMIZED BAND SAW RECOMMENDATIONS

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BAND SAW BLADES

Carbide Blades | Bi-metal Blades | Sawing Fluids & Lubricants



BI-METAL BAND SAW BLADES

BI-METAL PRODUCT SELECTION

PRODUCTION SAWING											
ALUMINUM NON-FERROUS	CARBON STEELS	STRUCTURAL STEELS	ALLOY STEELS	BEARING STEELS	MOLD STEELS	TOOL STEELS	STAINLESS STEELS	TITANIUM ALLOYS	NICKEL-BASED ALLOYS (INCONEL)		
EASY ← MACHINABILITY → DIFFICULT											
Qxp™										Qxp Long Life. Fast Cutting	
										CONTESTOR GT® & CONTESTOR XL™ Long Life. Straight Cuts	
										ARMOR® Rx®* Long Life. Structurals/Bundles	
										LENOX Rx®* Structurals/Bundles	
										CLASSIC PRO™ Long Life. Extremely Versatile	
										CLASSIC PRO	



GENERAL PURPOSE											
LENOX CLASSIC® 3/4" and Wider Blades										LENOX CLASSIC	
DIEMASTER 2® 1/2" and Narrower Blades										DIEMASTER 2	

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.

BI-METAL TOOTH SELECTION

- Determine the size and shape of the material to be cut
- Identify the chart to be used (square solids, round solids, or tubing/structurals)
- Read teeth per inch (TPI) next to material size

SQUARE/RECTANGLE SOLID																						Locate width of cut (W)									
																						WIDTH OF CUT									
IN	.1	.2	.3	.4	.5	.6	.7	.8	.9	1	2	5	10	15	20	25	30	35	40	45	50										
MM	2.5	5	7.5	10	12.5	15	17.5	20	22.5	25	50	125	250	375	500	625	750	875	1000	1125	1250										
TPI	14/18	10/14	8/12	6/10	6/8 5/8			4/6	3/4	2/3	1.5/2.0 1.4/2.0			1.0/1.3			0.7/1.0														

																						
Diameter (D)																						
ROUND SOLID Locate diameter of cut (D)																						
DIAMETER OF CUT																						
IN	.1	.2	.3	.4	.5	.6	.7	.8	.9	1	2	5	10	15	20	25	30	35	40	45	50	
MM	2.5	5	7.5	10	12.5	15	17.5	20	22.5	25	50	125	250	375	500	625	750	875	1000	1125	1250	
TPI	14/18	10/14	8/12	6/10	6/8	5/8	4/6	3/4	2/3	1.5/2.0	1.4/2.0	1.0/1.3					0.7/1.0					

Wall thickness (T)

TUBING/PIPE/STRUCTURALS Locate wall thickness (T)

WALL THICKNESS															
IN	.05	.10	.15	.20	.25	.30	.40	.50	.60	.70	.80	.90	1	1.5	2
MM	1.25	2.5	3.75	5	6.25	7.5	10	12.5	15	17.5	20	22.5	25	37.5	50
TPI	14/18	10/14	8/12	6/10	6/8 5/8	4/6			3/4			2/3			

BUNDLED/STACKED MATERIALS:

To select the proper number of teeth per inch (TPI) for bundled or stacked materials, find the recommended TPI for a single piece and choose one pitch coarser to cut the bundle



CARBIDE BAND SAW BLADES

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	•				



CAST MASTER™

Superior Performance When Sawing Castings

EXCEPTIONAL BLADE LIFE IN HAND FED FOUNDRY APPLICATIONS
Sub-micron grade carbide designed for cutting aluminum and non-ferrous parts

Precision grind on the rake face prevents material build up on the tooth edge

CUTS PARTS FREELY WITH LIMITED FEED PRESSURE
Optimized rake angle and narrow kerf enable high speed cutting without pulling the part

Multi-chip tooth design reduces cutting forces and limits vibration

HIGH ALLOY BACKING STEEL INCREASES FATIGUE LIFE
Advanced backing steel preparation minimizes band breaks

WIDTH X THICKNESS		TPI			
IN	MM	2	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		•	•*	•
1-1/4 x .042	34 x 1.07	•	•	•	
1-1/2 x .050	41 x 1.27		•		

• Multi-chip Design

* Set Style (Cast Master SST)



CARBIDE BAND SAW BLADES

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	0.6/0.8	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 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		•	•		
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 1.27			•	•	
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



CAST MASTER™ XL

Superior Performance in High Speed Aluminum Cutting Applications

LONG BLADE LIFE AT HIGH BAND SPEEDS

Special grade of carbide is designed to wear slowly when cutting aluminum

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

Next generation welding technology reduces premature tooth loss

Exceptional Part Finish at Increased

CUTTING RATES

Precision grind prevents material build up on the tooth edge

Teeth have sharp edges and high rake angles to penetrate easily and leave a smooth finish

STRAIGHT CUTS IN LARGE BLOCK APPLICATIONS

High alloy backing steel and fatigue resistant gullet geometry minimize the impact of wide guide spacing

WIDTH X THICKNESS		TPI				
IN	MM	0.6/0.8	0.9/1.1	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	•	•			

* CAST MASTER XLE - Spec designed for automated cutting of engine blocks

TRI-MASTER®

Versatile Carbide Tipped Blade

PRECISION TRIPLE CHIP GRIND

Smooth cuts, excellent finish

HIGH PERFORMANCE BACKING STEEL

Excellent fatigue life

GENERAL PURPOSE BLADE

Perfect for cutting of a wide variety of materials

WIDTH X THICKNESS		TPI					STANDARD TPI
IN	MM	1.2/1.8	1.5/2.3	2/3	3/4		3
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	•		•	•	•	•
2 x .063	54 x 1.60	•		•			
2-5/8 x .063	67 x 1.60	•					
3 x .063	80 x 1.60	•					



MASTER-GRIT®

Carbide Grit Edge Blade for Cutting Abrasive and Hardened Materials

TUNGSTEN CARBIDE PARTICLE GRIT
Metallurgically bonded edge

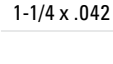
GULLETED

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	GULLETED			CONTINUOUS	
		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			•		



BI-METAL BAND SAW BLADES

CONTESTOR GT®

High Performance Sawing

STRAIGHTER CUTS ON LARGER,

DIFFICULT TO CUT MATERIALS

Unique gullet design for increased beam strength

OPTIMUM CHIP FORMATION IN WORK HARDENING ALLOYS

Precision ground teeth—smoother tooth face and gullet surfaces

Patented special set and tooth profile

IMPROVED LIFE WITH OPTIONAL M-51 EDGE MATERIAL

Increased heat and wear resistance

WIDTH X THICKNESS		TPI						
IN	MM	0.7/1.0	1.0/1.3	1.4/2.0	2/3	3/4	4/6	
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 .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	♦	♦	♦				

•= Milled tooth

♦= Ground tooth



CONTESTOR XL™

High Performance Sawing of Large, Difficult to Cut Metals

INCREASED WEAR RESISTANCE

DELIVERS LONGER BLADE LIFE

New HSS edge wire increases tooth hardness for better abrasive wear resistance

Patent pending chip controlling design reduces heat and wear

IMPROVED CHIP FORMATION HELPS

PENETRATE DIFFICULT TO CUT METALS

Variable tooth heights and multi-level set creates deeper, narrower chips

High rake angles reduce cutting forces

OPTIMIZED DESIGN FOR STRAIGHTER CUTS ON LARGE BLOCKS

Shallow gullet construction increases beam strength

WIDTH X THICKNESS		TPI						
IN	MM	0.7/1.0	1.0/1.3	1.4/2.0	2/3	3/4	4/6	
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	♦	♦					



ARMOR RX®

Engineered for Long Life

AlTiN COATING FOR PRODUCTIVITY

AND LONG BLADE LIFE

Aluminum, Titanium, and Nitrogen combine to form a coating that is hard and tough, protecting each tooth from heat and wear with an armor-like barrier

UNIQUE, PATENTED TOOTH PROFILE

Special, reinforced tooth design for reduced tooth strippage at higher feed rates

Minimized harmonics and vibrations

Quiet cutting

HIGH PERFORMANCE BACKING STEEL

For longer fatigue life

WIDTH X THICKNESS		TPI			
IN	MM	2/3	3/4	4/6	
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	♦	♦	♦	

†= Extra heavy set available to prevent blade pinching

LENOX RX®

Engineered to Cut Structural, Tubing and Bundles

LONG BLADE LIFE AND

EXTREME DURABILITY

Patented tooth profile resists tooth strippage, even at higher feed rates

QUIET CUTTING, REDUCED VIBRATION

Optimized tooth pitch/set sequence

WIDTH X THICKNESS		TPI								
IN	MM	2/3	3/4	4/6	5/7	5/8	6/10	10/14		
5/8 x .032	16 x 0.80								*	
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	♦†	♦†	♦†		♦				
2 x .050	54 x 1.27	♦	♦†	♦		♦				
2 x .063	54 x 1.60	♦†	♦†	♦						
2-5/8 x .063	67 x 1.60	♦†	♦†	♦						

*= Matrix edge

†= Extra heavy set available to prevent blade pinching

♦= NEW Specs designed for pull down, semi-automatic and gravity fed sawing applications



BI-METAL BAND SAW BLADES

QXP™

Long Blade Life At High Cutting Rates

LONG LIFE. FAST CUTTING