LENOX®

BAND SAW BLADES

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

ACAT
TEL. 81 8354 8910
www.acatmexicana.com

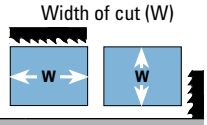
BI-METAL PRODUCT SELECTION

	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
PRODUCTION SAWINMG	***QXP™***			***QXP*** Long Life. Fast Cutting						
						CONTESTOR GT® Long Life. Straight Cuts				
		ARMOR® Rx®+ Long Life. Structurals/Bundles								
		LENOX *Rx®+* Structurals/ Bundles								
	CLASSIC PRO™ Long Life. Extremely Versatile						***CLASSIC PRO***			
GEN. PURPOSE	**LENOX *CLASSIC®*** 3/4" and Wider Blades						**LENOX *CLASSIC***			
	DIEMASTER 2® 1/2" and Narrower Blades						***DIEMASTER 2***			

BI-METAL TOOTH SELECTION

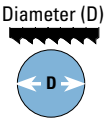
1. Determine the size and shape of the material to be cut
2. Identify the chart to be used (square solids, round solids, or tubing/structurals)
3. Read teeth per inch (TPI) next to material size

SQUARE/RECTANGLE SOLID Locate width of cut (W)



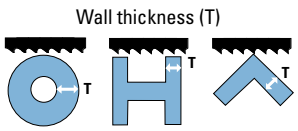
WIDTH OF CUT																							
IN	.1	.2	.3	.4	.5	.6	.7	.8	.9	1	2	5	10	15	20	25	30	35	40	45	50		
MM	2.5	5	7.5	10	12.5	15	17.5	20	22.5	25	50	125	250	375	500	625	750	875	1000	1125	1250		
TPI	14/18	10/14	8/12	6/10	6/8 5/8				4/6	3/4	2/3	1.5/2.0 1.4/2.0		1.0/1.3			.7/1.0						

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			.7/1.0					

TUBING/PIPE/ STRUCTURALS Locate wall thickness (T)



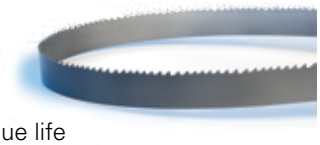
WALL THICKNESS																							
IN	.05	.10	.15	.20	.25	.30	.40	.50	.60	.70	.80	.90	1	1.5	2								
MM	1.25	2.5	3.75	5	6.25	7.5	10	12.5	15	17.5	20	22.5	25	37.5	50								
TPI	14/18	10/14	8/12	6/10	6/8 5/8		4/6			3/4				2/3									

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

QXP™

Long Blade Life at High Cutting Rates



LONG LIFE. FAST CUTTING
Solids of mild to moderate machinability
Proprietary backing steel preparation provides increased fatigue life

PENETRATES WITH LESS FEED FORCE
Extreme positive rake tooth form

INCREASED CUTTING RATES
Deep gullet design

WIDTH x THICKNESS IN	WIDTH x THICKNESS MM	TPI 1.0/1.3	1.5/2.0	2/3	3/4	4/6	5/8
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	◆					

◆ LENOX *LXP®* spec

MERCURIZED

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 IN	WIDTH x THICKNESS MM	TPI 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

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 IN	WIDTH x THICKNESS MM	TPI 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 ■ Available with M-51 edge

MERCURIZED

LENOX *Rx®+*

Engineered to Cut Structurals, 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 IN	WIDTH x THICKNESS MM	TPI 2/3	3/4	4/6	5/8	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

CLASSIC PRO™

The Ultimate Multi-Purpose Blade for Production Cutting

NEW

EXCEPTIONAL BLADE LIFE

Proprietary backing steel preparation increases fatigue life

Robust M42 high speed steel edge provides superior heat and wear resistance

EXTREMELY VERSATILE

Cuts a wide range of metals from low carbon steels to higher strength alloys

Advanced design enables production cutting of solids and structurals

Positive rake angle improves tooth penetration on saws with limited feed force

CONSISTENT PERFORMANCE CUT AFTER CUT

Unique tooth geometry and set minimizes noise and vibration from the first cut

WIDTH x THICKNESS		TPI				
IN	MM	1.4/2.0	2/3	3/4	4/6	5/8
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	◆	◆†	◆†		

† = Extra heavy set available to prevent blade pinching

LENOX CLASSIC®

The Ultimate Multi-Purpose Blade

DESIGNED FOR LONG LIFE IN GENERAL PURPOSE CUTTING APPLICATIONS

Patented *TUFF TOOTH*™ design reduces tooth strippage

M-42 high speed steel edge for excellent heat and wear resistance

TOOTH FORM WIDTH x THICKNESS		*TUFF TOOTH*™ TPI		*VARI-TOOTH*® TPI			
IN	MM	4/6	6/8	5/8	6/10	8/12	10/14
3/4 x .035	19 x 0.90	◆	◆	◆	◆	◆	◆
1 x .035	27 x 0.90	◆	◆	◆	◆	◆	◆
1-1/4 x .042	34 x 1.07	◆	◆	◆	◆	◆	

TOOTH FORM WIDTH x THICKNESS		WAVY TPI		HOOK TPI
IN	MM	14	18	3
3/4 x .035	19 x 0.90	◆	◆	◆
1 x .035	27 x 0.90		◆	◆
1-1/4 x .042	34 x 1.07			

DIEMASTER 2®

Engineered for Contour Cutting

FASTER CUTTING WITH M-42 HIGH SPEED STEEL TOOTH EDGE

Runs at twice the speed of carbon blades for faster, easier cutting

LONGER BLADE LIFE

Lasts 10 times longer than carbon blades

FOR GENERAL PURPOSE HAND-FED APPLICATIONS

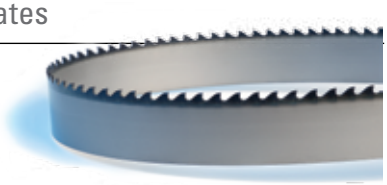
Tool and die shops, machine shops, maintenance facilities

TOOTH FORM WIDTH x THICKNESS		*VARI-TOOTH*® TPI				STANDARD TPI				HOOK TPI		
IN	MM	6/10	8/12	10/14	14/18	10	14	18	24	3	4	6
1/4 x .025	6.4 x 0.64			◆	◆							◆
1/4 x .035	6.4 x 0.90			◆								◆
3/8 x .025	9.5 x 0.64			◆	◆							
3/8 x .035	9.5 x 0.90					◆					◆	◆
1/2 x .020	12.7 x 0.50			*	*		*	*	*			
1/2 x .025	12.7 x 0.64	◆	◆	◆	◆		◆	◆			◆	◆
1/2 x .035	12.7 x 0.90					◆	◆			◆	◆	◆

*= Matrix edge

ARMOR® CT BLACK

For Extreme Cutting Rates



AlTiN *ARMOR* FOR SPEED AND PRODUCTIVITY
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

***ARMOR* ALLOWS FOR LOW THERMAL CONDUCTIVITY**
Forces heat into the chips rather than the blade or workpiece

HIGH QUALITY, MICRO-GRAINED CARBIDE
Tailored to cut a wide range of materials

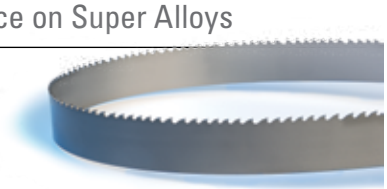
HIGH PERFORMANCE BACKING STEEL
Excellent fatigue life

WIDTH x THICKNESS IN	WIDTH x THICKNESS MM	TPI 0.6/0.8	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		•			

MERCURIZED

TNT CT®

Extreme Performance on Super Alloys



HIGH PERFORMANCE CARBIDE AND SPECIAL GROUND TOOTH FORM
Superior wear resistance when sawing difficult to cut materials

HIGH PERFORMANCE BACKING STEEL
Excellent fatigue life

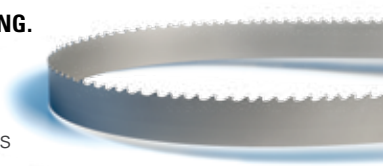
WIDTH x THICKNESS IN	WIDTH x THICKNESS MM	TPI 0.6/0.8	0.9/1.1	1.4/1.8	1.8/2.0	2.5/3.4
1-1/4 x .042	34 x 1.07				•	•
1-1/2 x .050	41 x 1.27		•	•	•	•
2 x .063	54 x 1.60		•	•	•	•
2-5/8 x .063	67 x 1.60	•	•		•	•
3 x .063	80 x 1.60	•	•			

MERCURIZED

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

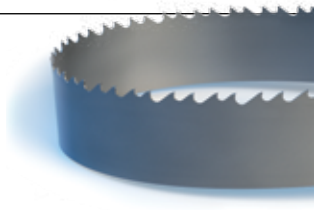
WIDTH x THICKNESS IN	WIDTH x THICKNESS MM	TPI 0.6/0.8	0.9/1.1	1.4/1.8	1.8/2.0	2.5/3.4
1-1/4 x .042	34 x 1.07				•	•
1-1/2 x .050	41 x 1.27			•	•	•
2 x .063	54 x 1.60		•	•	•	•
2-5/8 x .063	67 x 1.60	•	•	•		
3 x .063	80 x 1.60	•	•			

MERCURIZED

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

TOOTH FORM WIDTH x THICKNESS IN	WIDTH x THICKNESS MM	*VARI-TOOTH*® TPI 1.2/1.8	1.5/2.3	2/3	3/4	STANDARD TPI 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	•				

MERCURIZED

CAST MASTER™

Superior Performance When Sawing Castings

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

Precision grind on the rake face prevents material build up on 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
3/4 x .035	19 x 0.90			•*	•
1 x .035	27 x 0.90		•	•*	•
1-1/4 x .042	34 x 1.07	•	•	•	•

* = Set Style • = Multi-chip design

LENOX *HRc*®

Carbide Tipped Blade for Case and Through-Hardened Material

HIGH QUALITY, MICRO-GRAINED CARBIDE
Outstanding durability

STRONG TOOTH DESIGN
Superior edge strength and strip resistance

HIGH PERFORMANCE BACKING STEEL
Excellent fatigue life

REPLACES ABRASIVE CUT-OFF OPERATIONS

TOOTH FORM		*VARI-TOOTH*		STANDARD
WIDTH x THICKNESS		TPI		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	•		

ALUMINUM MASTER™ CT

Triple Chip Tooth Design

HIGH QUALITY SUB MICRO-GRAINED CARBIDE
Extreme wear resistance

TRIPLE CHIP TOOTH GEOMETRY
Fast cutting, ease of feed, great finish

HIGH PERFORMANCE BACKING STEEL
Excellent fatigue life

AGGRESSIVE RAKE ANGLE AND THIN KERF
Feeds with less force in hand-fed applications

TOOTH FORM		*VARI-TOOTH*
WIDTH x THICKNESS		TPI
IN	MM	2/3
1-1/2 x .050	41 x 1.27	•

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

GRIT EDGE PREPARATION WIDTH x THICKNESS		GULLETED			CONTINUOUS	
IN	MM	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			•		

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 *TNT CT*®						**LENOX *TNT CT*** Extreme Performance on Super Alloys			
***TRI-TECH CT*™**				***TRI-TECH CT*** Set Style Blade for Difficult to Cut Metals					
***TRI-MASTER*®**				***TRI-MASTER*** Versatile Carbide Tipped Blade					

SPECIAL APPLICATION

WOOD	COMPOSITES	ALUMINUM (Including Alum. Castings)	CASE HARDENED MATERIALS (Including IHCP Cylinder Shafts)	OTHER (Composites, Tires, etc.)
EASY ← MACHINABILITY → DIFFICULT				
***CAST MASTER*™** Superior Performance When Sawing Castings				
***ALUMINUM MASTER*™ CT** Triple Chip Tooth Design			**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	

CARBIDE TOOTH SELECTION

ARMOR CT BLACK

WIDTH OR DIAMETER OF CUT														
INCHES	1	2.5	3	4	5	6	7	8	10	12	13	15	17	20+
MM	25	60	70	100	120	150	170	200	250	300	330	380	430	500+
													0.6/0.8 TPI	
										0.9/1.1 TPI				
								1.4/1.6 TPI						
					1.8/2.0 TPI									
		2.5/3.4 TPI												

LENOX *TNT CT*

WIDTH OR DIAMETER OF CUT																	
INCHES	1	2.5	3	4	5	6	7	8	10	12	13	15	16	17	18	20	34+
MM	25	60	70	100	120	150	170	200	250	300	330	380	410	430	460	500	865
															0.6/0.8		
										0.9/1.1 TPI							
								1.4/1.8 TPI									
						1.8/2.0 TPI											
		2.5/3.4 TPI															

TRI-TECH CT

WIDTH OR DIAMETER OF CUT														
INCHES	1	2.5	3	4	5	6	7	8	10	12	13	15	17	20+
MM	25	60	70	100	120	150	170	200	250	300	330	380	430	500+
													0.6/0.8 TPI	
												0.9/1.1 TPI		
										1.4/1.8 TPI				
								1.8/2.0 TPI						
						2.5/3.4 TPI								

TRI-MASTER • LENOX *HRc* • *ALUMINUM MASTER* CT • *CAST MASTER*

WIDTH OR DIAMETER OF CUT														
INCHES	1	2.5	3	4	5	6	7	8	10	12	13	15	17	20
MM	25	60	70	100	120	150	170	200	250	300	330	380	430	500
													1.2/1.8 TPI	
										1.5/2.3 TPI				
									2/3 TPI					
								3 TPI						
							3/4 TPI							

LENOX®

ACAT

SOCIO COMERCIAL EN MÉXICO

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