

# Starrett Band Saw Blades

## Cutting Rate in Square Inches Per Minute

Bar																			
Diameter	Area (in <sup>2</sup> )	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18
		<i>Minutes Per Cut:</i>																	
1.00	0.79	.79	.39	.26	.20	.16	.13	.11	.10	.09	.08	.07	.07	.06	.06	.05	.05	.05	.04
1.25	1.23	1.2	.61	.41	.31	.25	.20	.18	.15	.14	.12	.11	.10	.09	.09	.08	.08	.07	.07
1.50	1.77	1.8	.88	.59	.44	.35	.29	.25	.22	.20	.18	.16	.15	.14	.13	.12	.11	.10	.10
1.75	2.41	2.4	1.2	.80	.60	.48	.40	.34	.30	.27	.24	.22	.20	.19	.17	.16	.15	.14	.13
2.00	3.14	3.1	1.6	1.0	.79	.63	.52	.45	.39	.35	.31	.29	.26	.24	.22	.21	.20	.18	.17
2.25	3.98	4.0	2.0	1.3	1.0	.80	.66	.57	.50	.44	.40	.36	.33	.31	.28	.27	.25	.23	.22
2.50	4.91	4.9	2.5	1.6	1.2	1.0	.82	.70	.61	.55	.49	.45	.41	.38	.35	.33	.31	.29	.27
2.75	5.94	5.9	3.0	2.0	1.5	1.2	1.0	.85	.74	.66	.59	.54	.49	.46	.42	.40	.37	.35	.33
3.00	7.07	7.1	3.5	2.4	1.8	1.4	1.2	1.0	.88	.79	.71	.64	.59	.54	.50	.47	.44	.42	.39
3.25	8.30	8.3	4.1	2.8	2.1	1.7	1.4	1.2	1.0	.92	.83	.75	.69	.64	.59	.55	.52	.49	.46
3.50	9.62	9.6	4.8	3.2	2.4	1.9	1.6	1.4	1.2	1.1	1.0	.87	.80	.74	.69	.64	.60	.57	.53
3.75	11.04	11.0	5.5	3.7	2.8	2.2	1.8	1.6	1.4	1.2	1.1	1.0	.92	.85	.79	.74	.69	.65	.61
4.00	12.57	12.6	6.3	4.2	3.1	2.5	2.1	1.8	1.6	1.4	1.3	1.1	1.0	1.0	.90	.84	.79	.74	.70
4.25	14.19	14.2	7.1	4.7	3.5	2.8	2.4	2.0	1.8	1.6	1.4	1.3	1.2	1.1	1.0	.95	.89	.83	.79
4.50	15.90	15.9	8.0	5.3	4.0	3.2	2.7	2.3	2.0	1.8	1.6	1.4	1.3	1.2	1.1	1.1	1.0	.94	.88
4.75	17.72	17.7	8.9	5.9	4.4	3.5	3.0	2.5	2.2	2.0	1.8	1.6	1.5	1.4	1.3	1.2	1.1	1.0	1.0
5.00	19.64	19.6	9.8	6.5	4.9	3.9	3.3	2.8	2.5	2.2	2.0	1.8	1.6	1.5	1.4	1.3	1.2	1.2	1.1
5.25	21.65	21.6	10.8	7.2	5.4	4.3	3.6	3.1	2.7	2.4	2.2	2.0	1.8	1.7	1.5	1.4	1.4	1.3	1.2
5.50	23.76	23.8	11.9	7.9	5.9	4.8	4.0	3.4	3.0	2.6	2.4	2.2	2.0	1.8	1.7	1.6	1.5	1.4	1.3
5.75	25.97	26.0	13.0	8.7	6.5	5.2	4.3	3.7	3.2	2.9	2.6	2.4	2.2	2.0	1.9	1.7	1.6	1.5	1.4
6.00	28.27	28.3	14.1	9.4	7.1	5.7	4.7	4.0	3.5	3.1	2.8	2.6	2.4	2.2	2.0	1.9	1.8	1.7	1.6
6.25	30.68	30.7	15.3	10.2	7.7	6.1	5.1	4.4	3.8	3.4	3.1	2.8	2.6	2.4	2.2	2.0	1.9	1.8	1.7
6.50	33.18	33.2	16.6	11.1	8.3	6.6	5.5	4.7	4.1	3.7	3.3	3.0	2.8	2.6	2.4	2.2	2.1	2.0	1.8
6.75	35.78	35.8	17.9	11.9	8.9	7.2	6.0	5.1	4.5	4.0	3.6	3.3	3.0	2.8	2.6	2.4	2.2	2.1	2.0
7.00	34.48	38.5	19.2	12.8	9.6	7.7	6.4	5.5	4.8	4.3	3.8	3.5	3.2	3.0	2.7	2.6	2.4	2.3	2.1
7.25	41.28	41.3	20.6	13.8	10.3	8.3	6.9	5.9	5.2	4.6	4.1	3.8	3.4	3.2	2.9	2.8	2.6	2.4	2.3
7.50	44.18	44.2	22.1	14.7	11.0	8.8	7.4	6.3	5.5	4.9	4.4	4.0	3.7	3.4	3.2	2.9	2.8	2.6	2.5
7.75	47.17	47.2	23.6	15.7	11.8	9.4	7.9	6.7	5.9	5.2	4.7	4.3	3.9	3.6	3.4	3.1	2.9	2.8	2.6
8.00	50.27	50.3	25.1	16.8	12.6	10.1	8.4	7.2	6.3	5.6	5.0	4.6	4.2	3.9	3.6	3.4	3.1	3.0	2.8
8.25	53.46	53.5	26.7	17.8	13.4	10.7	8.9	7.6	6.7	5.9	5.3	4.9	4.5	4.1	3.8	3.6	3.3	3.1	3.0
8.50	56.75	56.7	28.4	18.9	14.2	11.3	9.5	8.1	7.1	6.3	5.7	5.2	4.7	4.4	4.1	3.8	3.5	3.3	3.2
8.75	60.13	60.1	30.1	20.0	15.0	12.0	10.0	8.6	7.5	6.7	6.0	5.5	5.0	4.6	4.3	4.0	3.8	3.5	3.3
9.00	63.62	63.6	31.8	21.2	15.9	12.7	10.6	9.1	8.0	7.1	6.4	5.8	5.3	4.9	4.5	4.2	4.0	3.7	3.5
9.25	67.20	67.2	33.6	22.4	16.8	13.4	11.2	9.6	8.4	7.5	6.7	6.1	5.6	5.2	4.8	4.5	4.2	4.0	3.7
9.50	70.88	70.9	35.4	23.6	17.7	14.2	11.8	10.1	8.9	7.9	7.1	6.4	5.9	5.5	5.1	4.7	4.4	4.2	3.9
9.75	74.66	74.7	37.3	24.9	18.7	14.9	12.4	10.7	9.3	8.3	7.5	6.8	6.2	5.7	5.3	5.0	4.7	4.4	4.1
10.0	78.54	78.5	39.3	26.2	19.6	15.7	13.1	11.2	9.8	8.7	7.9	7.1	6.5	6.0	5.6	5.2	4.7	4.6	4.4







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# Starrett Band Saw Blades

## Reading the Chips

Chip Formation	Chip Condition	Chip Color	Blade Speed	Blade Feed	Other
	Thin and Tightly Curled	Silver	Correct	Decrease	Refer to Machining Recommendations For Correct Tooth Pitch
	Powdered	Silver	Decrease	Increase	
	Thick and Short	Blue or Brown	Decrease	Decrease	Check Cutting Fluid
	Thin and Curly	Silver	Correct	Correct	

## Recommended Tension for Starrett Band Saw Blades

Blade Width	English	Metric
Bi-Metal: 1-1/2" & Wider	30,000 - 40,000 PSI	2,100 - 2,800 Kg/cm <sup>2</sup>
Bi-Metal: Thru 1-1/4" Wide	25,000 - 35,000 PSI	1,800 - 2,500 Kg/cm <sup>2</sup>
Duratec™ PH	20,000 - 25,000 PSI	1,400 - 1,800 Kg/cm <sup>2</sup>
Duratec™ FB	15,000 - 20,000 PSI	1,000 - 2,500 Kg/cm <sup>2</sup>

The above tension ranges are supplied as a guide for normal average cutting conditions. Insufficient blade tension can effect the cutting efficiency of the blade. Excessive tension may cause breakage of band saw blades.

As a general rule of thumb, the higher end of the tension range should be used when the guide arms are further apart and the lower end of the range should be used when the guide arms are closer together.

Bulletin 193 1M/MN 05/09

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