

How to Choose the Correct Number of Band Saw Blade Teeth Per Inch

The number of teeth per inch (TPI) is important in obtaining the finish desired and the proper feed rate. A coarse tooth blade (3, 4 TPI) should be used for re-sawing wood and cutting thicker stock up to 6 inches. A fine toothed blade (10 to 14 TPI) should be used for thinner metals and plastics under $\frac{1}{4}$ ". For general cutting of $\frac{3}{4}$ " wood 4 TPI will provide a fast cut and 14 TPI will cut slow but leave a smoother finish.

When Selecting TPI remember:

- More TPI give a smoother but slower cut.
- Fewer TPI allow a faster cut with a slightly rougher finish.
- At least 3 teeth must be in the workpiece – the charts below will help you decide.

Wood Band Saws	
TPI	MATERIAL THICKNESS
14	$1/8'' - 5/32''$
10	$1/4'' - 3/8''$
6	$1/2''$
4	$3/4''$
3	$1'' - 1\ 1/2''$

Bi-metal Band Saws	
TPI	MATERIAL THICKNESS
14/18	$1/8'' - 1/4''$
10/14	$1/4'' - 3/8''$
8/12	$3/8'' - 1/2''$
6/10	$1/2'' - 3/4''$
4/6	$1'' - 3''$