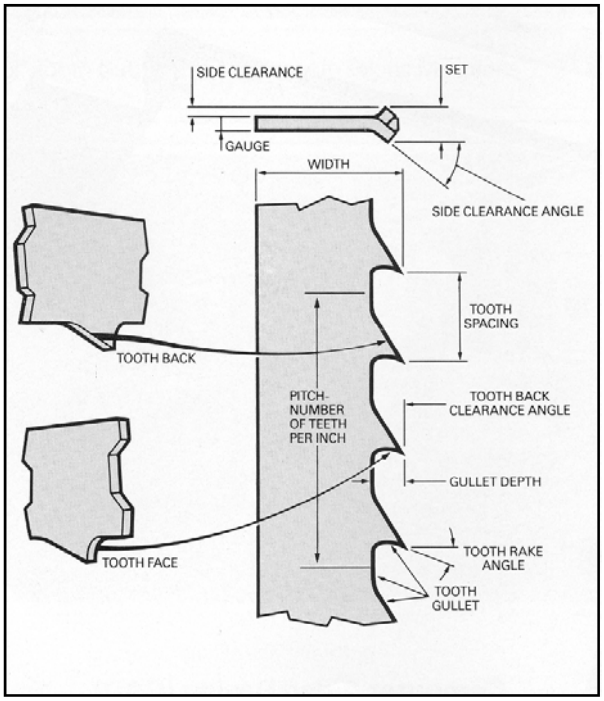
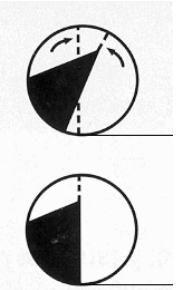
RAPTOR
Cutting Tools Inc.

Band Saw Blade Geometry



Tooth Forms

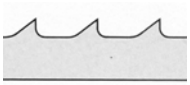


Hook Tooth 8-12° Positive
Aggressive cutting style in both wood and metal.

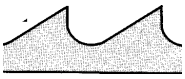
Straight, **Regular Tooth 0°**
Neutral cutting angle for finer tooth blades in metal & wood.

Blade Styles

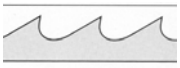
Skip: Special use blade. Wide flat and shallow gullets. Available in carbon only, for sticky materials.



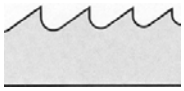
Regular: Straight Tooth 0° cutting angle, with round gullets. For general purpose cutting.



Hook: Hook Tooth 10° positive cutting angle, with round gullets. For aggressive cutting.

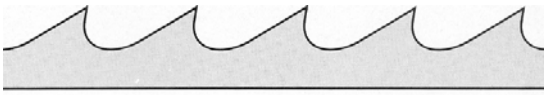


Variable Pitch: In bi-metal only, available in regular or hook cutting angle. For aggressive cutting.

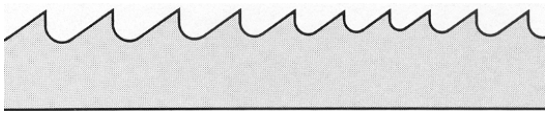


Tooth Pitch **The number of teeth per inch (25.4mm)**

Constant: Uniform gullets and tooth space. Common with carbon band saw blades & bi-metal blades for cutting solids.

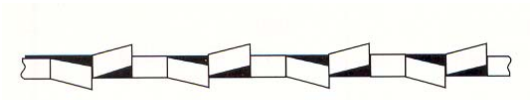


Variable: Two sets of tooth patterns alternate. Available in bi-metal only. Fast cutting of tubes,



Tooth Set **The bending of the tooth tips to provide clearance for the body**

Raker: (LRS,LRS) Common feature in constant pitch blades, both in carbon and bi-metal. The straight tooth clears the chips from the work.



Modified Raker: (LRLRLRS,LRLRLRS**)** Common feature in variable pitch bi-metal Blades. Pattern may be a set of 4 or six plus .

Wavy Set: (LLLS,RRRS**)** Available only in finer carbon and bi-metal blades. Wavy action helps cutting and reduces tooth damage in cutting thin ma-

ETS: (LR,LR) Available only in carbon blades. **E**very **T**ooth is **S**et. This aggressive cutting pattern speeds production