



TOWERLEAF

TOWERLEAF LLC

The Ultimate Choice in Any Band Sawing Application

We at Towerleaf, have a long standing emphasis on quality and perfection. The result of this tradition is our high quality products, that are backed with over 50 years of combined experience in band sawing applications as well as customer service.

Towerleaf LLC Phone: 1-847-985-1937
1680 Wright Blvd. Fax: 1-847-985-9165
Schaumburg, IL 60193 www.towerleaf.com





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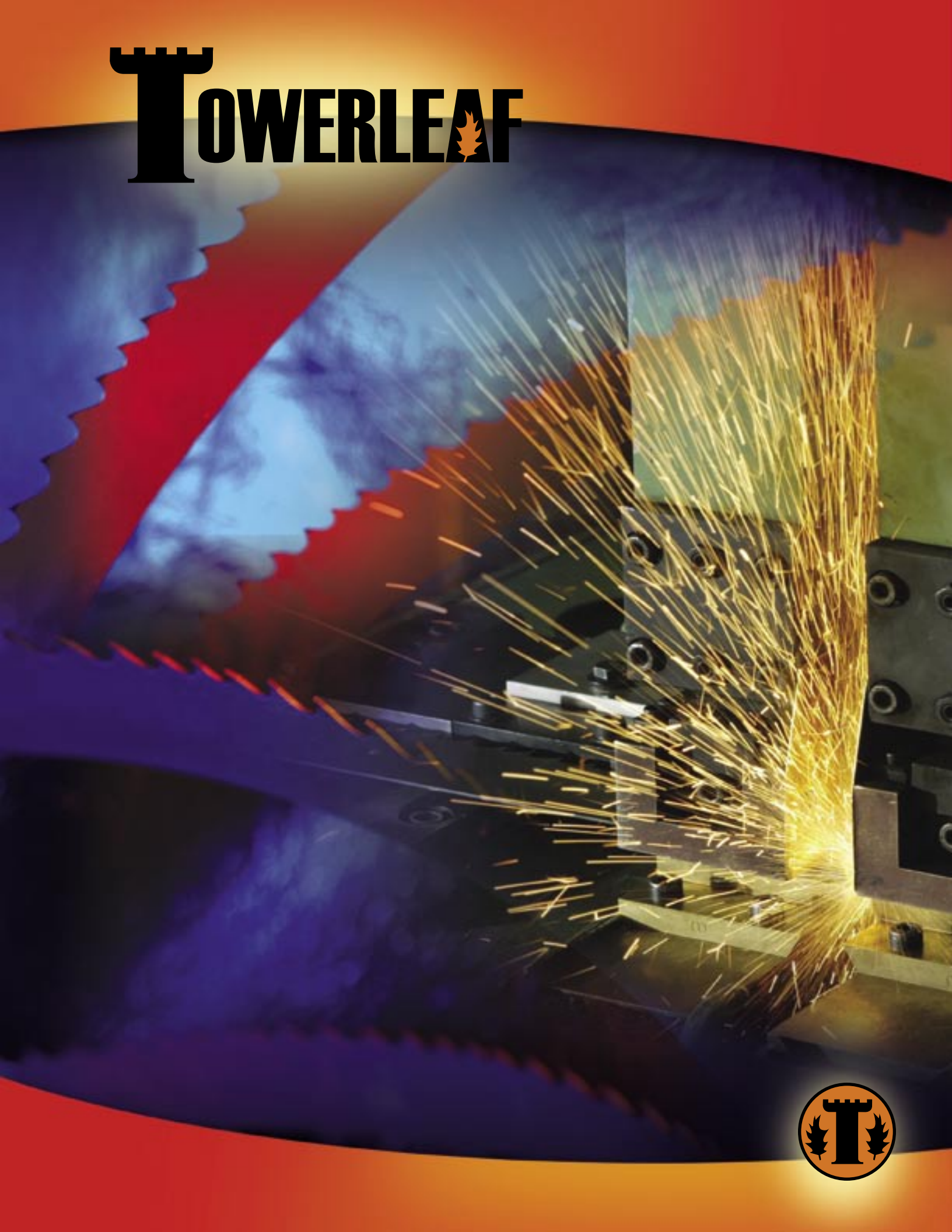
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BIMETAL / M42

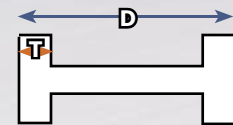
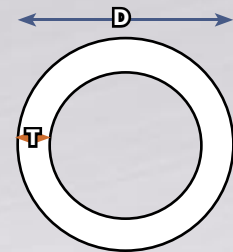
CHOOSING THE TOOTH PITCH

SOLID MATERIAL

DIAMETER of Solid Material	1/2"	1"	1-1/2"	2"	3"	5"	10"	20"
TOOTHING teeth/inch (tpi)	10-14	8-12	6-10	5-8	4-6	3-4	2-3	1.4-2

TUBING AND PROFILES

WALL THICKNESS	OUTSIDE DIAMETER								
	3/4"	1-1/2"	2-1/4"	3"	4"	6"	8"	12"	20"
1/8"	14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	6/10
3/16"	14	10/14	10/14	8/12	6/10	6/10	5/8	4/6	4/6
1/4"	14	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6
3/8"		6/10	6/10	5/8	5/8	4/6	4/6	4/6	3/4
1/2"		6/10	5/8	4/6	4/6	4/6	4/6	3/4	3/4
5/8"				4/6	4/6	3/4	3/4	3/4	2/3
3/4"				4/6	4/6	3/4	3/4	3/4	2/3
1-1/4"				3/4	3/4	3/4	2/3	2/3	2/3
2"						2/3	2/3	2/3	1.4/2
3"							2/3	1.4/2	1.4/2
4" - UP								1.4/2	.75/1.25



D = OUTSIDE DIAMETER
T = WALL THICKNESS

BIMETAL BREAK IN PROCEDURE

In order to avoid tooth fracture, a break in procedure is recommended whenever a new bimetal band is installed. The softer the material is, the more a break in procedure is recommended. During break in, run the band at the recommended band speed for the material, but reduce feeding rate as indicated below.

STEP 1			STEP 2		STEP 3	
SFPM	% Feed	Duration	% Feed	Duration	% Feed	Duration
300+	50	40 SQ. INCH	75	30 SQ. INCH	90	10 SQ. INCH
225-300	60	35 SQ. INCH	80	20 SQ. INCH	95	10 SQ. INCH
150-225	70	25 SQ. INCH	85	15 SQ. INCH	95	5 SQ. INCH
90-150	75	20 SQ. INCH	90	10 SQ. INCH		
50-90	80	15 SQ. INCH	95	5 SQ. INCH		



BAND BLADES

KNIFE BLADE

This blade is used when a dust free, smooth precise cut is required such as cutting or splitting prime foam, rebonded foam, sponge, rubber, or leather. Standard widths from 3/16" to 3-5/8" with thickness ranging from .015" to .048", single or double bevel, single or double edge, welded to customer length or available in coils of 250 & 500 feet. Precision Trac available on widths of 1-1/2" to 3-5/8". Other than standard specifications are available upon request. Note: See edge description key for correct edge description when placing an order.

V-TOOTH BLADE

The tooth design on this blade is the shape of a V. This blade is commonly used to cut softer materials such as foam, sponge, and light weight rubber. The V-Tooth Blade is manufactured in a wide variety of different specifications depending on customer requirements. Standard widths are 3/16" to 1-1/2" with thickness ranging from .015" to .032", 10, 12 or 14 teeth per inch, single or double bevel, single or double edge, welded to customer length or available in coils of 250 and 500 feet. Other than standard specifications are available upon request. Note: See edge description key for correct edge description when placing an order.

SCALLOP BLADES

Designed to give a fast, smooth dust free cut in foam, corrugated cardboard, plastic, sponge, rubber, and many other materials. Standard widths are 3/16" to 1-1/2" with thickness ranging from .015 to .032, single or double bevel, 2 teeth or 4 teeth per inch. Welded to customer length or available in coils of 250 and 500 feet.

HAND BLADE

Hand Blades are designed for hand-held cutting machines used primarily for pattern cuts in foam, sponge and rubber. Straight cuts are also possible. When cutting heavier foams, we recommend the scallop edge for extended blade life as well as ease to the cutter operator. Scallop edge is available in 2 teeth and 4 teeth per inch. Standard lengths are 5", 8", 12" and 14", however, we can produce them in any specified length. When ordering specify the length, followed by a tooth design, i.e., V-Tooth, 2-Tooth Scallop, or 4-Tooth Scallop.

HANDKNIFE



DOUBLE BEVEL KNIFE EDGE



PIRANHA SCALLOP



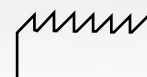
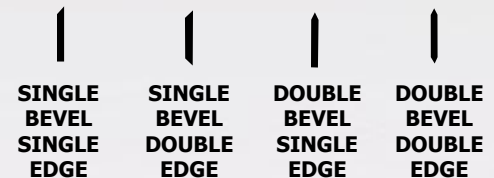
SCALLOP



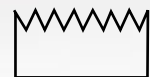
PACKAGING (ETS) Every Tooth Set



DOUBLE BEVEL V-TOOTH DOUBLE EDGE



**CONVENTIONAL
TOOTH**



V-TOOTH



CARBIDE TIPPED

CARBIDE PROGRAM

THE HIGH TECH Q4 VERSION

To get the full benefit from this design, the blade should be used on machines with automatically controlled feed rates.

The Unique tooth geometry provides:

- high production in materials that are difficult to cut
- faster production rates that are not possible with ordinary carbide tipped blades

THE NEWLY DEVELOPED F6 VERSION

For universal use on all band sawing machines.

- for steel and non-ferrous materials
- can be used for both automatically controlled feed and manual feed machines

		PITCH - Teeth/Inch (TPI)				
		0.75-1.25	1.4-2	2	2-3	3
SIZE	3/4"	.035				Q4, F6
	1"	.035			Q4	F6
	1-1/4"	.042		Q4, F6	Q4	F6
	1-1/2"	.050		Q4	Q4	
	2"	.063	Q4	Q4	Q4	
	2-5/8"	.063	Q4	Q4		
	3-1/8"	.063	Q4			



CARBON

CARBON BLADES

CARBON PROGRAM

An economical alternative to the bimetal blades.

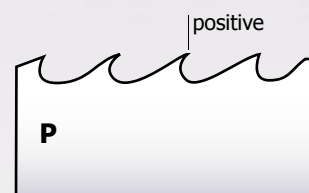
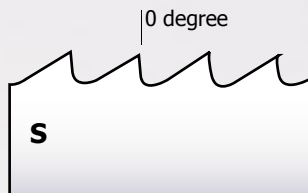
Towerleaf carbon blades combine a flexible back with hardened teeth.

Carbon Blades are well suited for cutting non-alloyed metals as well as most composite materials of low tensile strength. Our carbon quality blades are also widely used in wood cutting.

Tooth Shapes

P = Positive Rake Angel

S = Neutral Rake Angel

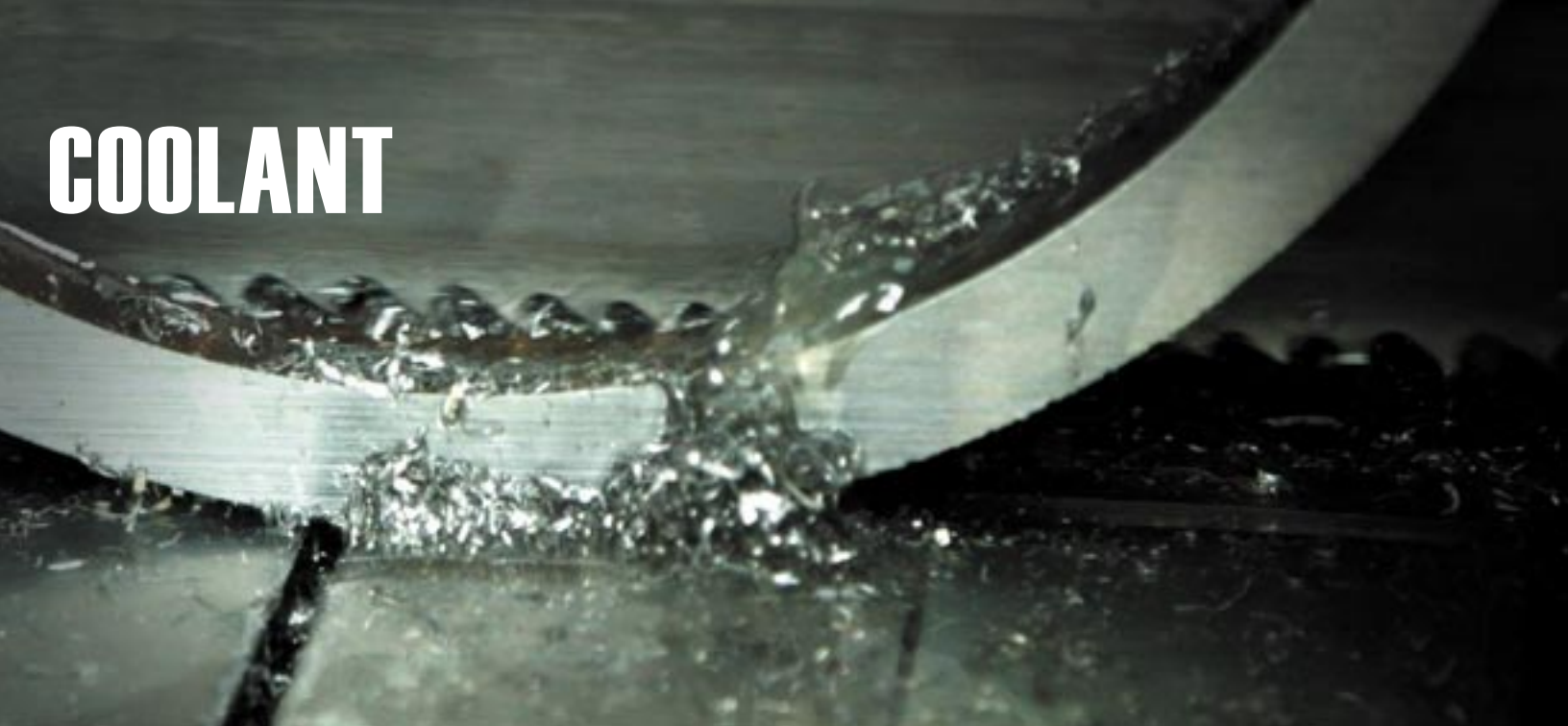


		PITCH - Teeth/Inch (TPI)								
		1.25	2	3	4	6	8	10	14	18
SIZE	1/4"				P	P		S	S	S
	3/8"			P	P	P		S	S	S
	1/2"			P	P	P	S	S	S	S
	5/8"			P	P	P		S	S	
	3/4"			P	P	P		S, F	S	
	1"		P	P	P		S	S, F	S	
	1-1/4"	P	P	P		P	S			

F=Friction Quality



COOLANT



TL-SYN: SYNTHETIC FLUID Minimizing Problems with Bacteria and Odor

FORMULA	SAW	DRILL	MILL	TAP	GRIND		HMIS
TL-SYN-050	10:1	8:1	8:1	5:1	20:1		000A
TL-SYN-080	20:1	15:1	15:1	10:1	30:1		000A
TL-SYN-100	25:1	20:1	20:1	15:1	30:1		000A



TL-SOL: SOLUBLE FLUID Maximum Lubrication and Coolant Effect

FORMULA	SAW	DRILL	MILL	TAP	GRIND	BROACH	HMIS
TL-SOL-700	20:1	20:1	20:1	15:1	30:1	10:1	110A



TL-SEMI-SYN Combining the lubricating properties in TL-SOL with the favorable bacteria/odor properties of TL-SYN

FORMULA	SAW	DRILL	MILL	TAP	GRIND	BROACH	HMIS
TL-S-SYN-000	20:1	15:1	15:1	10:1	20:1	2:1	100A
TL-S-SYN-015	25:1	20:1	20:1	15:1	25:1	5:1	100A
TL-S-SYN-030	30:1	25:1	25:1	20:1	30:1	7:1	100A



ANTI-SPATTER FLUID Water based, free of any hazardous ingredients, and environmentally safe. It does NOT contain any types of solvents, ozone depletors, silicones, or oils. It can be safely handled with no special storage precautions

Synthetic Anti-Spatter TL-192	Robotic Anti-Spatter TL-963
May be applied with a brush, dip or spray. The unique water based formula keeps welded surfaces cooler and helps prevent bowing.	Applied automatically by pulse, it is fed to the nozzle for application by internal spray, piggybacking the gas line.

ALSO AVAILABLE

Cutting Oil	TL-210
Screw Machine Oil	TL-185
Stamping Oil	TL-692
Tapping Fluid	TL-400
Air Mist Fluid	TL-006
Rust Inhibitor	TL-964

CONTAINER SIZES

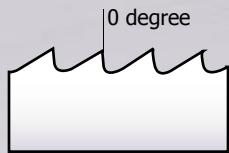
1 Gallon Bottle
4 x 1 Gallon Pack
5 Gallon Pail
55 Gallon Drum
275 Gallon Tote Tank



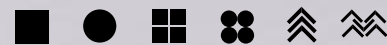
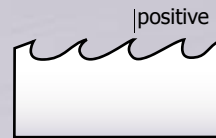
MM42

RECOMMENDED TOOTH PROFILE

S - DESIGNED FOR THINNER SECTIONS



P, XP - DESIGNED FOR SOLIDS OR HEAVIER SECTIONS



BIMETAL PROGRAM

PITCH - Teeth/Inch (TPI)

WIDTH	THK	1.25	3	4	6	10	14	.75/1.25	1.4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14	14/18	
1/4"	.035				P												S	
3/8"	.035			P													S	
1/2"	.025				P	S	S							S	S	S	S	
1/2"	.035		P	P			S								S	S		
5/8"	.035																S	
3/4"	.035		XP	P			S					P	P	S	S	S		
1"	.035									XP	XP	S, P, XP	P	S	S	S		
1-1/4"	.042									XP, W	XP, W	S, P	P	S	S			
1-1/2"	.050							XP	XP, W	XP, W	XP, W	S, P	P	S				
2"	.050									XP	XP							
2"	.063	XP							XP	XP	XP, W	P						
2-5/8"	.063							XP	XP	XP								
3-1/8"	.063							XP	XP	XP								

w=widerset

