LENOX®

WAVE TECH™



Patent Pending Blade Enhancement for Cutting Work Hardening Metals

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ENHANCED CUTTING ABILITY
Engineered back edge enhancement creates a unique cutting action that increases tooth penetration without additional machine feed pressure

INCREASED BLADE LIFE*
Proprietary design balances the depth of penetration with cutting force to optimize chip load and reduce frictional wear

Precision chamfer on the back edge of the blade reduces stress risers and minimizes band breaks

FASTER CUTTING RATES*
Design-induced rocking motion improves cutting efficiency and speed by breaking through the work hardening layer

**Vs. Standard LENOX band saw blades*



WAVE TECH Type	Cutting Action
Level 1 (L1)	Light Action
Level 2 (L2)	Moderate Action
Level 3 (L3)	Heavy Action

APPLICATION

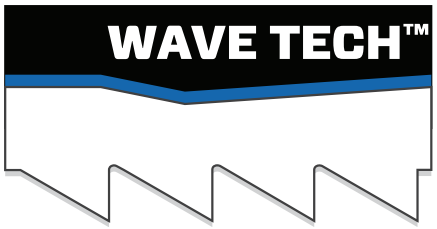
Work Hardening Materials	Stainless Steels
Nickel-Based Alloys	Tool Steels
Titanium	



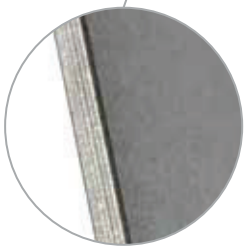
PRODUCTS

Bi-Metal	Carbide
CONTESTOR GT®	LENOX MAX CT™
CONTESTOR XL™	ARMOR CT® BLACK
QXP™	TRI-MASTER®
LENOX CLASSIC PRO™	TRI-TECH CT™

Minimum band length of 10 feet (3,048mm) and minimum width of 1" (27mm)

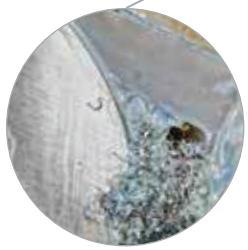






CHAMFERED BACK EDGE
Precise chamfer applied to the back edge of the blade reduces stress risers and band breakage

ENHANCED BACK EDGE
Engineered back edge pattern features a larger penetration zone, which evens out tooth wear and limits tooth strippage



INCREASED TOOTH PENETRATION
Design-induced rocking motion breaks though the work hardening layer

RECOMMENDATION CHART

WAVE TECH Level 3	
MATERIAL	**MACHINABILITY RATING**
Rene 41	7%
L-605	9%
188	9%
Inconel 617, 625, 718, X-750	12%
Waspalloy, Hastelloy C, Hastelloy X	12%
Monel K500 (Aged)	15%
Nitronic 50 (22-13-5), Nitronic 60 (22-4-9)	17%
M-4	17%
Inconel 600, 601, 800H/AT, 825	18%
M-3, M-42	18%
Ti-6Al-4V HT	18%
330	20%
A286 (Discalloy)	20%
D-3	21%
Ti-6Al-4V	22%
316B	22%
Nitronic 40 (21-6-9)	22%
Kovar	22%
Invar 36	25%
D-2, D-5, M-1, M-2, T-1	25%
304B	28%
Super Duplex	29%

WAVE TECH Level 2	
MATERIAL	**MACHINABILITY RATING**
Duplex	35%
A-2, DC-53	35%
309, 310, 316, 316L, 317, 317L, 321, 347, 446	36%
13-8 PH-MO, 17-4 PH H1025	36%
Maraging 300, 4750, Monel K500 (Annealed)	36%
A-8, L-6	38%
Alloy 20, Monel 400	39%
A-6, S-5	39%
CP Titanium Grade 2	40%
302, 304, 304L, 440A, 440C	40%
Carpenter 20, AM 355	40%
H-19	42%
303 High Tensile	43%
15-5, 17-4 PH, 17-7 PH	45%

MATERIAL COLOR KEY
Stainless Steel
Tool Steels
Aerospace Alloys
Titanium

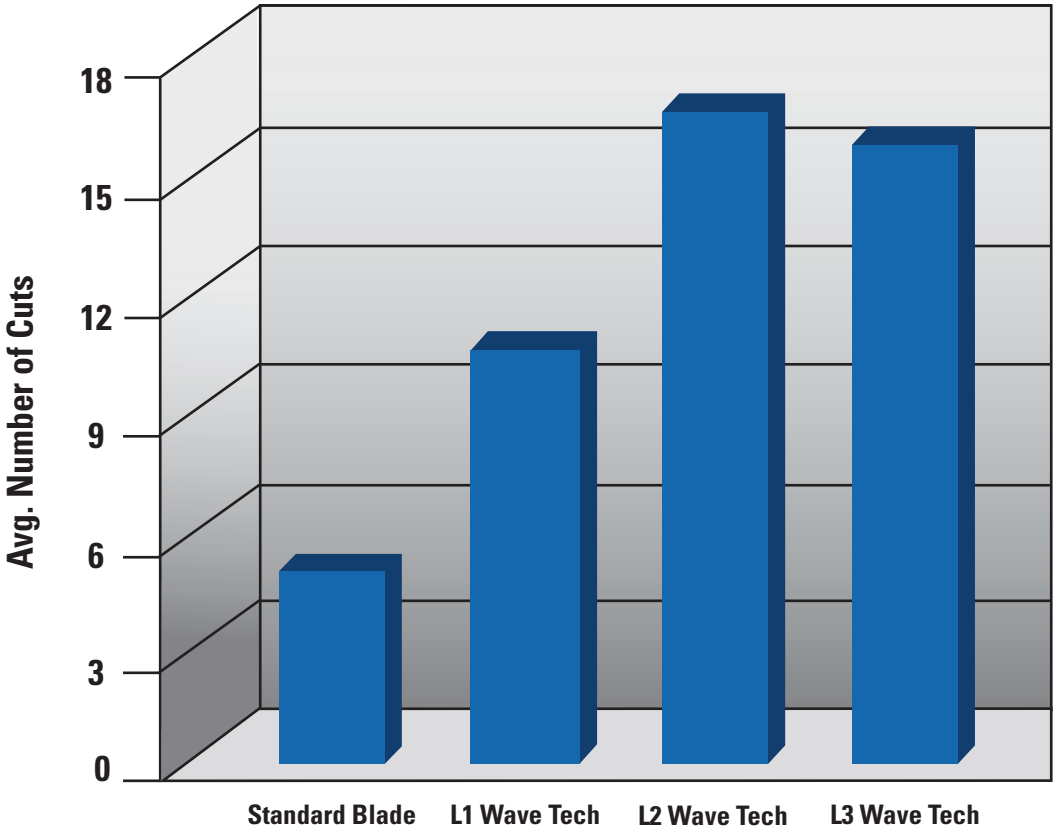
WAVE TECH Level 1	
MATERIAL	**MACHINABILITY RATING**
S-1	46%
431, 440F Se	48%
Monel 405	48%
H-11, H-12, H-13	49%
416 H.T.	50%
418 (Greek Ascoloy), 420, 17-4 PH H1150	50%
O-1, O-2, S-7	53%
410	54%
Invar 35 FM	55%
Lean Duplex	56%
O-6	63%
W-1	65%
430	66%
Nickel 200	66%
420F	68%
303, 410 Annealed, 430F	75%

Note: For cross sections less than 8" (203mm), use one level less than the recommendation above

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Test Results – LENOX Carbide Blade 2” x .063 x 1.4/2.0T (54mm x 1.6 x 1.4/2.0T) on Inconel® 718





WAVE TECH improved performance up to 300% when compared to a standard blade!

Internal Test Parameters:

- Kasto Tec AC5 Saw / Coolant is a 10:1 mix ratio
- Cutting one 12” (305mm) round bar of Inconel 718
- Band Speed – 115 ft./min. Cutting Rate – 2.5 in²/min (35 m/min., Cutting rate – 16 cm²/min)

Results may vary based on the cutting conditions and user expectations.
Consult LENOX® Technical Support for recommendations on your application.

LENOX®

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