

PRODUCT SELECTION

Step #1

Analyze the sawing application

Machine: For most situations, knowing the blade dimensions (length x width x thickness) is all that is necessary.

Material: Find out the following characteristics of the material to be cut.

- Grade • Shape • Hardness (if treated) • Size
- Is the material to be stacked (bundled) or cut one at a time?

Other Customer Needs:

- The specifics of the application should be considered.
- Production or utility/general purpose sawing operation?
 - What is more important, fast cutting or tool life?

Step #2

Determine the proper number of teeth per inch

Use the Tooth Selection Chart on the right.

A general rule for bundles: Determine the correct TPI for one piece, and choose one pitch coarser for the bundle.

Step #3

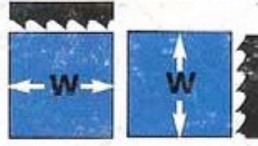
Determine which blade type to use

Refer to the Product Selection Charts on the opposite page. Find the material type to be cut in the top row. Read down the chart to find which blade is recommended.

TOOTH SELECTION CHART

Square/ Rectangle Solid Round Solid

Locate width of cut (W)



Locate diameter (D)



INCHES	Teeth Per Inch/25mm	MM
.1	14/18	
.2		5
.3	10/14	
.4		10
.5	8/12	
.6		15
.7	6/10	
.8		20
.9	5/8	
1		25
2	4/6	
5		50
10	3/4	
15		75
20	2/3	
25		100
30	1.5/2.0	
35		150
40	1.4/2.0	
45		200
50	1.0/1.3	
55		250
60	1.0/1.3	
65		300
70	1.0/1.3	
75		350
80	1.0/1.3	
85		400
90	1.0/1.3	
95		450
100	1.0/1.3	
105		500
110	1.0/1.3	
115		550
120	1.0/1.3	
125		600
130	1.0/1.3	
135		650
140	1.0/1.3	
145		700
150	1.0/1.3	
155		750
160	1.0/1.3	
165		800
170	1.0/1.3	
175		850
180	1.0/1.3	
185		900
190	1.0/1.3	
195		950
200	1.0/1.3	
205		1000
210	1.0/1.3	
215		1050
220	1.0/1.3	
225		1100
230	1.0/1.3	
235		1150
240	1.0/1.3	
245		1200
250	1.0/1.3	

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.4		10
.5	8/12	
.6		15
.7	6/10	
.8		20
.9	5/8	
1		25
2	4/6	
5		50
10	3/4	
15		75
20	2/3	
25		100
30	1.5/2.0	
35		150
40	1.4/2.0	
45		200
50	1.0/1.3	
55		250
60	1.0/1.3	
65		300
70	1.0/1.3	
75		350
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215		1050
220	1.0/1.3	
225		1100
230	1.0/1.3	
235		1150
240	1.0/1.3	
245		1200
250	1.0/1.3	

Tubing/Pipe/Structurals

Wall thickness (T)



INCHES	Teeth Per Inch/25mm	MM
.05	14/18	1
.10	10/14	2
.15	8/12	3
.20	6/10	4
.25	6/8 5/8	5
.30		6
.35		7
.40	4/6	8
.45		9
.50		10
.60		15
.70		20
.80	3/4	25
.90		30
1		35
1.5	2/3	40
2		50