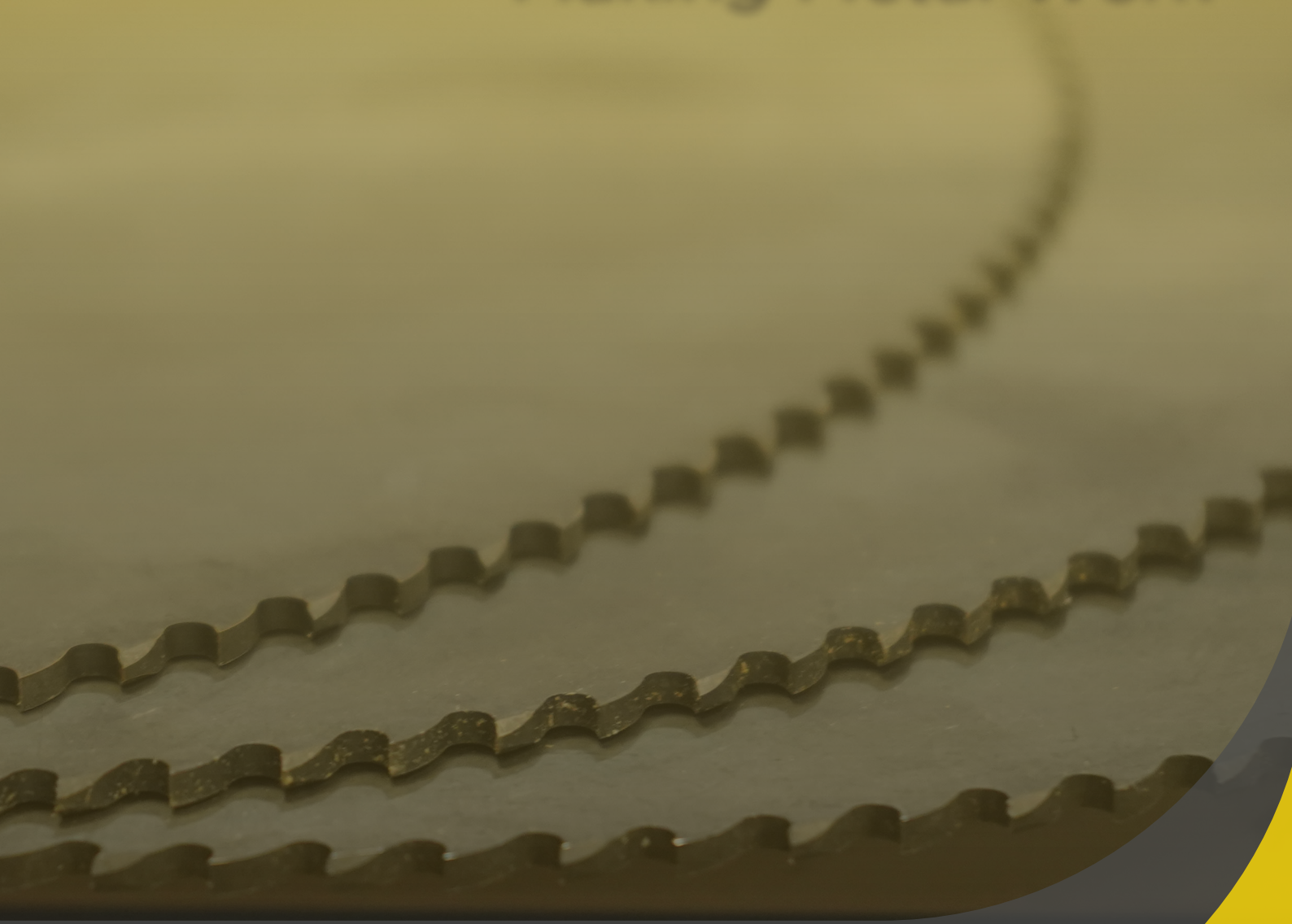




Making Metal Work



**CIRCULAR SAW BLADE
SELECTION GUIDE**



Tooth Pitch Selector Guide

When selecting the optimum circular saw blade, the following factors need to be taking into account:

1. Material to be cut
2. Type and cross section of material to be cut
3. Type of lubrication
4. Tooth geometry
5. Toothform
6. Type of coating on saw blade

Recommended tooth pitches, feeds and speeds:

	Mild Steel	Medium Steel	Hard Steel	Stainless Steel	Cast Iron	Aluminium	Bronze / Copper	Brass
Tube Section (mm)		Pitch T (mm)						
<1	3	3	3	3	-	4	4	4
1-1.5	4	4	3	4	-	5	5	5
1.5-2	5	4	4	5	-	6	6	6
2-3	5	5	5	5	-	7	7	7
>3	6	6	5	6	-	8	8	8
Solid Section (mm)		Pitch T (mm)						
10-20	5	5	5	5	5	6	6	8
20-40	8	6	6	6	6	8	8	10
40-60	10	10	8	8	8	12	10	12
60-90	12	12	10	11	11	16	13	14
90-110	14	14	12	14	14	18	15	17
110-130	16	16	14	16	16	20	17	19
130-150	18	16	14	16	16	20	19	20
Pitch T (mm)		Feed Speed A (mm/min)						
3	350-450	250-350	90-160	70-150	350-550	-	-	-
4	300-400	200-300	80-140	60-130	280-440	-	-	-
5	250-350	150-250	70-130	55-100	210-350	-	-	-
6	200-300	100-180	60-120	50-90	180-300	-	1,400-2,000	2,000-4,000
8	150-250	80-130	45-90	40-75	140-250	4,500-8,500	1,000-1,600	1,500-3,200
10	100-200	70-100	40-80	35-60	120-180	3,800-6,000	700-1,200	1,000-2,500
12	80-150	65-90	35-65	30-55	90-150	3,000-5,000	550-850	800-1,800
14	70-130	60-80	25-50	20-50	75-125	2,800-4,600	500-700	700-1,400
16	50-120	55-70	15-40	5-35	65-110	2,500-3,700	400-600	600-1,000
Saw Diameter (mm)		(RPM)						
200	45-80	30-65	25-40	15-35	45-85	950-1500	320-480	650-950
225	45-70	30-60	20-35	15-30	45-70	850-1250	300-430	550-850
250	40-65	25-50	20-30	15-25	40-65	750-110	250-380	500-700
275	35-60	25-45	15-30	10-25	35-60	700-1050	230-350	450-700
300	30-55	20-45	15-25	10-20	30-55	650-950	210-320	430-640
315	30-50	20-40	15-25	10-20	30-50	600-900	200-300	400-600
350	25-45	20-35	15-25	10-20	25-45	550-820	180-270	350-550
370	25-45	15-35	15-25	10-15	25-45	520-770	170-260	350-520
400	20-40	15-30	10-20	8-15	20-40	470-720	160-240	300-480
500	18-35	13-26	10-16	6-12	18-35	380-570	130-190	250-380



Standard Programme of Cut Off Saws

Dimensions mm	T=Pitch in mm.										Toothform and number	
	T3	T4	T5	T6	T7	T8	T9	T10	T11	T12	T14	
200 x 1.8 200 x 2	200 BW	160 BW	128 C	100 C	-	80 C	-	-	-	-	-	
225 x 2 225 x 2.5	220 BW	180 BW	140 C	120 C	-	90 C	-	-	-	-	-	
250 x 1.6 250 x 2 250 x 2.5	250 BW	200 BW BR	160 C BR	128 C BR	-	100 C	-	80 C	-	-	-	
275 x 1.6 275 x 2 275 x 2.5	280 BW	220 BW BR	180 C BR	140 C	120 C	110 C	-	90 C	-	-	-	
300 x 2 300 x 2.5 300 x 3	300 BW	220 BW BR	180 C BR	160 C	140 C	120 C	-	90 C	-	-	-	
315 x 2 315 x 2.5 315 x 3	320 BW	240 BW BR	200 C BR	160 C	140 C	120 C	-	100 C	-	80 C	-	
350 x 2.5 350 x 3	350 BW	280 BW BR	220 BW BR	180 C BR	160 C	140 C	120 C	110 C	-	90 C	80 C	
370 x 3	-	290 BW	220 C	200 C	160 C	140 C	120 C	110 C	100 C	90 C	80 C	
400 x 3 400 x 3.5	-	310 BW BR	260 BW BR	220 BW	-	160 C	140 C	128 C	110 C	100 C	-	
425 x 3 425 x 3.5	-	320 BW BR	260 BW BR	220 BW	-	160 C	-	-	-	100 C	-	
450 x 3.5 450 x 4	-	340 BW BR	-	220 BW BR	-	180 C	-	140 C	-	120 C	100 C	
500 x 4	-	-	-	240 C BR	-	200 C	-	160 C	-	-	110 C	

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