

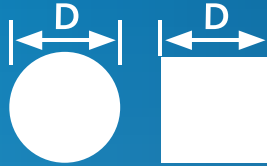
TOOTH SELECTION FOR METAL CUTTING BANDSAW BLADES



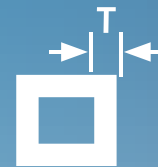
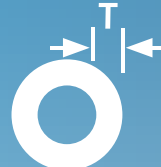
EXCISION NORMAL TOOTH



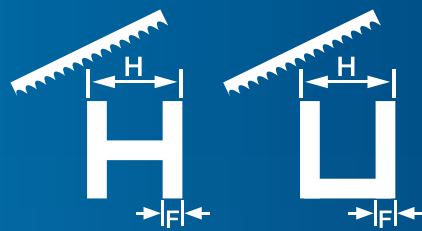
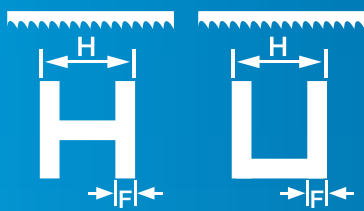
EXCISION PROFILE TOOTH



SOLIDS			
Vari-Pitch Tothing		TCT tothing (Materials over 50 HRc)	
Material Diameter (D) mm	Teeth Per Inch	Material Diameter (D) mm	Teeth Per Inch
0-5	18	50-120	3/4
4-8	14	100-250	2/3
2-15	10/14	150-400	1.5/2
8-20	8/12	350-600	1.1/1.6
16-30	6/10	500+	0.85/1.15
25-40	5/8		
35-70	4/6		
60-120	3/4		
80-200	2/3		
120-400	1.5/2		
250+	1.1/1.6		
400+	0.75/1.25		

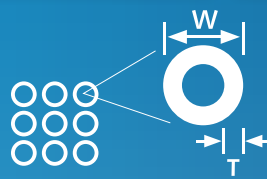
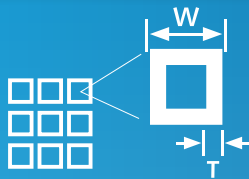


TUBES AND RHS																
Tube Width (W) mm	Wall Thickness (T)															
	1	1.6	2	2.5	3	4	5	6	7	8	9	10	12	15	20	50
10	14	10/14	10/14													
20	14	10/14	10/14	10/14	8/12											
25	14	10/14	10/14	10/14	8/12	8/12										
30	14	10/14	10/14	10/14	8/12	8/12	6/10									
40	14	10/14	10/14	10/14	8/12	8/12	6/10	5/8	5/8	5/8						
50	14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	5/8						
60-120	14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4	
130-150		10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4	3/4
150-180			10/14	8/12	6/10	6/10	5/8	4/6	4/6	4/6	4/6	4/6	4/6	3/4	3/4	3/4
190-300					6/10	6/10	5/8	4/6	4/6	4/6	4/6	4/6	4/6	3/4	3/4	2/3
350-400										4/6	4/6	3/4	3/4	3/4	3/4	2/3
450-500										4/6	4/6	3/4	3/4	3/4	3/4	2/3

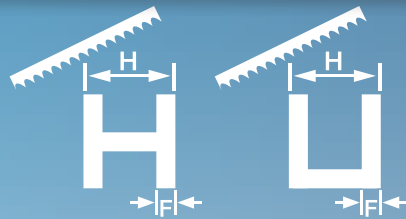
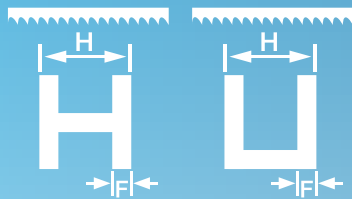


UNIVERSAL BEAM - 0° SAW ANGLE								
Beam Size (H)	Wall Thickness (F)							
	7	8	9	10	12	14	16	20
150	5/8	4/6	4/6					
180		4/6	4/6	4/6				
200		3/4	3/4	3/4				
250			3/4	3/4	3/4			
310			2/3	2/3	2/3			
360				2/3	2/3	2/3		
410				2/3	2/3	2/3		
460					2/3	2/3	2/3	
530					2/3	2/3	2/3	
610						1.5/2	1.5/2	1.5/2

UNIVERSAL BEAM - 5° SAW ANGLE								
Beam Size (H)	Wall Thickness (F)							
	7	8	9	10	12	14	16	20
150	6/10	6/10	6/10					
180		6/10	6/10	6/10				
200		4/6	4/6	4/6				
250			4/6	4/6	4/6			
310			4/6	4/6	4/6			
360				4/6	4/6	4/6		
410				4/6	4/6	4/6		
460					4/6	4/6	4/6	
530					4/6	4/6	4/6	
610						3/4	3/4	3/4



BUNDLE CUT TUBES AND RHS																				
Tube Width (W) mm	Wall Thickness (T)																			
	1	1.6	2	2.5	3	4	5	6	7	8	9	10	12	15	20	50				
10	14	8/11	8/11																	
20	14	8/11	8/11	8/11	8/11															
25	14	8/11	8/11	8/11	8/11	8/11														
30	14	8/11	8/11	8/11	8/11	8/11	5/7	5/7												
40		8/11	8/11	8/11	8/11	8/11	5/7	5/7	5/7	4/6	4/6									
50		8/11	8/11	8/11	8/11	8/11	5/7	5/7	5/7	5/7	4/6	4/6								
60-120		8/11	8/11	8/11	8/11	8/11	5/7	5/7	5/7	4/6	4/6	4/6	3/4	3/4	3/4	3/4				
130-150		8/11	8/11	8/11	8/11	8/11	5/7	5/7	4/6	4/6	4/6	4/6	3/4	3/4	3/4	3/4	2/3	2/3		
150-180			8/11	8/11	8/11	8/11	5/7	5/7	4/6	4/6	4/6	4/6	3/4	3/4	3/4	3/4	2/3	2/3		
190-300				8/11	8/11	8/11	5/7	5/7	4/6	4/6	4/6	4/6	3/4	3/4	3/4	3/4	2/3	2/3	1.5/2	
350-400					8/11	8/11	8/11	8/11	5/7	5/7	4/6	4/6	4/6	3/4	3/4	3/4	3/4	2/3	2/3	1.5/2
450-500						8/11	8/11	8/11	8/11	8/11	8/11	8/11	8/11	8/11	8/11	8/11	8/11	8/11	8/11	1.5/2



UNIVERSAL BEAM - 0° SAW ANGLE								
Beam Size (H)	Wall Thickness (F)							
	7	8	9	10	12	14	16	20
150	4/6	4/6	4/6					
180		3/4	3/4	3/4				
200		3/4	3/4	3/4				
250			2/3	2/3	2/3			
310			2/3	2/3	2/3			
360				2/3	2/3	2/3		
410				2/3	2/3	2/3		
460					2/3	2/3	2/3	
530					1.5/2	1.5/2	1.5/2	
610						1.5/2	1.5/2	1.5/2

UNIVERSAL BEAM - 5° SAW ANGLE								
Beam Size (H)	Wall Thickness (F)							
	7	8	9	10	12	14	16	20
150	5/7	5/7	5/7					
180		5/7	5/7	5/7				
200		4/6	4/6	4/6				
250			4/6	4/6	4/6			
310			4/6	4/6	4/6			
360				4/6	4/6	4/6		
410				4/6	4/6	4/6		
460					4/6	4/6	4/6	
530					4/6	4/6	4/6	
610						3/4	3/4	3/4