

BI-METAL TOOTH SELECTION

1. Determine size and shape of material to be cut.
2. Identify chart to be used (square solid, round solid, or tubing/structurals).
3. Read teeth per inch next to material size.

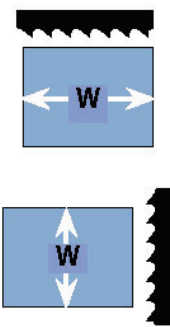
Square/Rectangle Solid



Locate width of cut (W)

INCHES	TPI	MM
.1	14/18	5
.2	10/14	10
.3	8/12	15
.4	6/10	20
.5	6/8 5/8	25
.6		
.7		
.8		
.9		
1		
1.5	4/6	50
2		
2.5		
3	3/4	75
4		
5	2/3	100
6		
7		
8		
9		
10	1.5/2.0	250
11	1.4/2.0	300
12		
13		
14		
15		
16		
17		
18		
19	1.0/1.3	500
20		
21		
22		
23		
24		
25		
26		
27		
28		
29		
30		
31		
32		
33		
34		
35		
36		
37		
38		
39		
40	.7/1.0	1000
41		
42		
43		
44		
45		
46		
47		
48		
49		
50		

Width of cut (W)



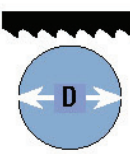
Round Solid



Locate diameter (D)

INCHES	TPI	MM
.1	14/18	5
.2	10/14	10
.3	8/12	15
.4	6/10	20
.5	6/8 5/8	25
.6		
.7		
.8		
.9		
1		
1.5	4/6	50
2		
2.5		
3	3/4	75
4		
5	2/3	100
6		
7		
8		
9		
10	1.5/2.0	250
11	1.4/2.0	300
12		
13		
14		
15		
16		
17		
18		
19		
20	1.0/1.3	500
21		
22		
23		
24		
25		
26		
27		
28		
29		
30		
31		
32		
33		
34		
35		
36		
37		
38		
39		
40	.7/1.0	1000
41		
42		
43		
44		
45		
46		
47		
48		
49		
50		

Diameter (D)



Tubing/Pipe/Structurals



Locate wall thickness (T)

INCHES	TPI	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

TPI

Wall thickness (T)

