

# Ferrous Saw Blades

## CUTTING FERROUS SOLID STOCK MATERIAL

(Number of Teeth and Grind Style Selection Chart)

Thickness of Solid Material in inches	COLD SAW BLADE DIAMETER						
	225mm 9"	250mm 10"	275mm 10-3/4"	300mm 12"	315mm 12-1/2"	350mm 14"	400mm 16"
1/4" - 3/4"	180BW	180C	200C	220BW	220BW	280BW	320BW
3/4" - 1-1/4"	120C	120C	140C	180C	180C	240BW	220BW
1-1/4" - 1-3/4"	100C	100C	120C	140C	140C	200C	180C
1-3/4" - 2-1/4"	80C	80C	100C	120C	120C	140C	120C
2-1/4" - 2-3/4"	60C	60C	70C	80C	80C	90C	80C
2-3/4" - 3-1/2"				60C	60C	80C	60C

*When cutting stainless use the same chart and multiply the number of teeth by a factor of 1.2.*

STANDARD SAW BLADES

DISPOSABLE SAW BLADES

CUSTOM SAW BLADES

COLD SAW BLADES

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# Ferrous Saw Blades

## CUTTING FERROUS TUBING, PIPE AND STRUCTURAL SHAPES

(Number of Teeth and Grind Style Selection Chart)

Tube Diameter	Wall Thickness	COLD SAW BLADE DIAMETER						
		225mm 9"	250mm 10"	275mm 10-3/4"	300mm 12"	315mm 12-1/2"	350mm 14"	400mm 16"
1/2"	.030" - .090"	220BW	240BW	280BW	300BW	300BW	320BW	340BW
1/2"	.090" - .150"	200BW	220BW	240BW	280BW	280BW	300BW	320BW
1"	.030" - .060"	220BW	240BW	280BW	300BW	300BW	320BW	340BW
1"	.060" - .090"	220BW	220BW	240BW	280BW	280BW	300BW	320BW
1"	.090" - .150"	180BW	220BW	220BW	240BW	240BW	280BW	300BW
1-1/2"	.030" - .060"	220BW	240BW	260BW	300BW	300BW	320BW	340BW
1-1/2"	.060" - .090"	200BW	220BW	240BW	280BW	280BW	300BW	320BW
1-1/2"	.090" - .150"	180BW	200BW	220BW	240BW	240BW	280BW	300BW
1-1/2"	.150" - .250"	140C	160C	180C	200C	200C	220C	240BW
2"	.030" - .060"	240BW	260BW	280BW	300BW	300BW	320BW	340BW
2"	.060" - .090"	180BW	200BW	220BW	240BW	240BW	280BW	300BW
2"	.090" - .180"	140C	160C	180C	220C	200C	220C	240BW
2"	.180" - .300"	120C	140C	160C	180C	180C	200C	220C
2"	.300" - .500"	100C	110C	120C	140C	140C	160C	180C
2-1/2"	.030" - .060"	240BW	260BW	280BW	300BW	300BW	320BW	340BW
2-1/2"	.060" - .090"	200BW	220BW	240BW	260BW	260BW	280BW	300BW
2-1/2"	.090" - .150"	180BW	160C	180C	200C	200C	220C	240BW
2-1/2"	.150" - .250"	120C	140C	160C	180C	180C	200C	220C
2-1/2"	.250" - .400"	100C	110C	120C	140C	140C	160C	180C
2-1/2"	.400" - .500"	90C	100C	110C	120C	120C	140C	160C
3"	.030" - .060"			280BW	300BW	300BW	320BW	340BW
3"	.060" - .090"			240BW	260BW	260BW	280BW	300BW
3"	.090" - .150"			180C	200C	200C	220C	240BW
3"	.150" - .250"			160C	180C	180C	200C	220C
3"	.250" - .400"			120C	140C	140C	160C	180C
3"	.400" - .500"			100C	120C	120C	140C	160C
3-1/2"	.030" - .060"				300BW	300BW	320BW	340BW
3-1/2"	.060" - .090"				260BW	260BW	280BW	300BW
3-1/2"	.090" - .150"				200C	200C	220C	240BW
3-1/2"	.150" - .250"				180C	180C	200C	220C
3-1/2"	.250" - .400"				140C	140C	160C	180C
3-1/2"	.400" - .500"				120C	120C	140C	160C

**When cutting stainless use the same chart and multiply the number of teeth by a factor of 1.2.**

STANDARD SAW BLADES

DISPOSABLE SAW BLADES

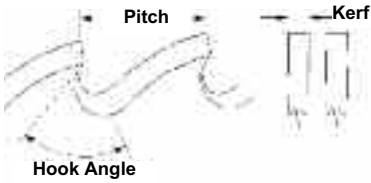
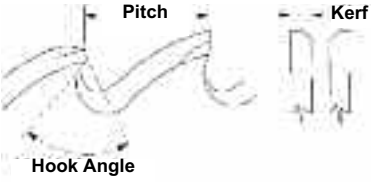
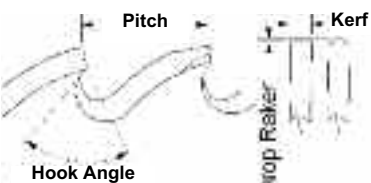
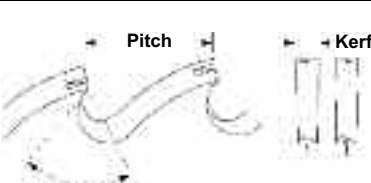
CUSTOM SAW BLADES

COLD SAW BLADES

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# Ferrous Saw Blades

## AVAILABLE TOOTH STYLES FOR FERROUS SAW BLADES

Description of Teeth	Tooth Style	Profile of Tooth Style	Comments for use of Particular Tooth Style
Single or Curved Teeth	B		Used especially for thin kerf saws of 2mm and less. Works well on small profiles and thin tubes and where changes in wall thickness is encountered.
Acme Curved Teeth	BW		Used for cutting thin walled steel tubing. It has an alternate top bevel. Ideally suited for fine tooth pitch of 4mm or less.
Heller or Cochrane Teeth High Output	C		Most commonly used tooth style for cutting Ferrous material. The triple chip design splits the cutting pressure between two teeth. For solid sections and thick wall tubing. Generally used on open tooth pitch of 5mm and larger.
Tooth B with Chipbreaker (Notch Grind)	BS		A new generation of tooth forms specifically designed for cutting thin-walled tubes and profiles with a maximum wall thickness of .098" (2.5mm). Primarily used on ferrous but also suited for hard tempered non-ferrous materials. The notch provides chip relieve with-out sacrificing the number of effective cutting teeth on the sides. Increased cutting speed and improved cut finish are possible compared to conventional BW & C grinds. This grind is limited to a kerf of 2.2mm and larger with a tooth pitch of 4mm or larger. This tooth style should only be used for production cutting on stable machines with power feed.

**Safety Warning:** *Ferrous Cold Saw Blades must not to exceed 1,000 SFM.  
Cobalt Ferrous Cold Saw Blades not to exceed 1,250 SFM.  
SF<sub>M</sub>= .262 X Diameter X RPM*