

Non-Ferrous Saw Blades

CUTTING NON-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"	135BW	135C	150C	165BW	165BW	210BW	240BW
3/4" - 1-1/4"	90C	90C	105C	135C	135C	180BW	165BW
1-1/4" - 1-3/4"	75C	75C	90C	105C	105C	150C	135C
1-3/4" - 2-1/4"	60C	60C	75C	90C	90C	105C	90C
2-1/4" - 2-3/4"	45C	45C	55C	60C	60C	70C	60C
2-3/4" - 3-1/2"				45C	45C	60C	45C

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CUTTING NON-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"	165BW	180BW	210BW	225BW	225BW	240BW	255BW
1/2"	.090" - .150"	150BW	165BW	180BW	210BW	210BW	225BW	240BW
1"	.030" - .060"	165BW	180BW	210BW	225BW	225BW	240BW	255BW
1"	.060" - .090"	165BW	165BW	180BW	210BW	210BW	225BW	240BW
1"	.090" - .150"	135BW	165BW	165BW	180BW	180BW	210BW	225BW
1-1/2"	.030" - .060"	165BW	180BW	195BW	225BW	225BW	240BW	255BW
1-1/2"	.060" - .090"	150BW	165BW	180BW	210BW	210BW	225BW	240BW
1-1/2"	.090" - .150"	135BW	150BW	165BW	180BW	180BW	210BW	225BW
1-1/2"	.150" - .250"	105C	120C	135C	150C	150C	165C	180BW
2"	.030" - .060"	180BW	195BW	210BW	225BW	225BW	240BW	255BW
2"	.060" - .090"	135BW	150BW	165BW	180BW	180BW	210BW	225BW
2"	.090" - .180"	105C	120C	135C	165C	150C	165C	180BW
2"	.180" - .300"	90C	105C	120C	135C	135C	150C	165C
2"	.300" - .500"	75C	85C	90C	105C	105C	120C	135C
2-1/2"	.030" - .060"	180BW	195BW	210BW	225BW	225BW	240BW	255BW
2-1/2"	.060" - .090"	150BW	165BW	180BW	195BW	195BW	210BW	225BW
2-1/2"	.090" - .150"	135BW	120C	135C	150C	150C	165C	180BW
2-1/2"	.150" - .250"	90C	105C	120C	135C	135C	150C	165C
2-1/2"	.250" - .400"	75C	85C	90C	105C	105C	120C	135C
2-1/2"	.400" - .500"	70C	75C	85C	90C	90C	105C	120C
3"	.030" - .060"			210BW	225BW	225BW	240BW	255BW
3"	.060" - .090"			180BW	195BW	195BW	210BW	225BW
3"	.090" - .150"			135C	150C	150C	165C	180BW
3"	.150" - .250"			120C	135C	135C	150C	165C
3"	.250" - .400"			90C	105C	105C	120C	135C
3"	.400" - .500"			75C	90C	90C	105C	120C
3-1/2"	.030" - .060"				225BW	225BW	240BW	255BW
3-1/2"	.060" - .090"				195BW	195BW	210BW	225BW
3-1/2"	.090" - .150"				150C	150C	165C	180BW
3-1/2"	.150" - .250"				135C	135C	150C	165C
3-1/2"	.250" - .400"				105C	105C	120C	135C
3-1/2"	.400" - .500"				90C	90C	105C	120C

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AVAILABLE TOOTH STYLES FOR NON-FERROUS SAW BLADES

Description of Teeth	Tooth Style	Profile of Tooth Style	Comments for use of Particular Tooth Style
Flat Top Teeth	A		Used for Plastics and Non-Ferrous cutting and slotting. This tooth style is used for small tooth pitches and shallow cuts.
Acme Straight Teeth	AW		Used for Non-Ferrous cutting of thin sections. It has an alternate top bevel. This tooth style is similar to straight tooth but used where fewer teeth are required.
Single or Curved Teeth	B		Used especially with thin kerf saws of 2mm and less for Non-Ferrous cutting. This is a high strength tooth and works well on light profiles and thin tubes and where changes in wall thickness is encountered. Improved chip exhaust over "A" tooth forms.
Acme Curved Teeth (Notch Grind)	BW		Used for cutting thin walled Non-Ferrous Tubing. It has an alternate top bevel. Tooth pitch of 4mm and less.
Heller or Cochrane Teeth High-Output	C		Most commonly used tooth style for cutting Ferrous and Non-Ferrous material. The triple chip design splits the cutting pressure between two teeth. For solid sections and thick wall tubing. Tooth pitch of 5mm and greater.

Safety Warning: *Non-Ferrous Cold Saws not to exceed 10,000 SFM in light thin walled extrusions.
Non-Ferrous Cold Saws not to exceed 5,000 SFM in rounds or solids.*

Non-Ferrous Saw Blades

NON-FERROUS

HSS M2 Steel - Bright Finish - Fully Hardened and Tempered to 56Rc.

Tool Number	Diameter		Kerf mm	Bore Size	Hub Diameter
	mm	in.			
CM800A	152mm	6"	1.5mm	1/2"	2-1/2"
CM802A	152mm	6"	1.5mm	5/8"	2-1/2"
CM804A	152mm	6"	1.5mm	1"	2-1/2"
CM806A	203mm	8"	0.9mm	5/8"	3-1/2"
CM808A	203mm	8"	0.9mm	1"	3-1/2"
CM810A	203mm	8"	1.2mm	5/8"	4"
CM812A	203mm	8"	1.2mm	1"	4"
CM814A	203mm	8"	1.6mm	5/8"	4"
CM816A	203mm	8"	1.6mm	1"	4"
CM818A	203mm	8"	2.0mm	5/8"	4"
CM820A	203mm	8"	2.0mm	1"	4"
CM822A	203mm	8"	2.5mm	5/8"	4"
CM824A	203mm	8"	2.5mm	1"	4"
CM826A	229mm	9"	1.2mm	5/8"	4"
CM828A	229mm	9"	1.2mm	1"	4"
CM830A	229mm	9"	1.6mm	5/8"	4"
CM832A	229mm	9"	1.6mm	1"	4"
CM834A	229mm	9"	2.0mm	5/8"	4"
CM836A	229mm	9"	2.0mm	1"	4"
CM838A	229mm	9"	2.5mm	5/8"	4"
CM840A	229mm	9"	2.5mm	1"	4"
CM842A	254mm	10"	1.2mm	5/8"	4"
CM844A	254mm	10"	1.2mm	1"	4"
CM846A	254mm	10"	1.6mm	5/8"	4"
CM848A	254mm	10"	1.6mm	1"	4"
CM850A	254mm	10"	2.0mm	5/8"	4"
CM852A*	254mm	10"	2.0mm	1"	4"
CM854A	254mm	10"	2.5mm	5/8"	4"
CM856A	254mm	10"	2.5mm	1"	4"
CM858A	254mm	10"	2.5mm	32mm	4"
CM860A	275mm	11"	1.6mm	32mm	110mm
CM862A	275mm	11"	2.0mm	32mm	110mm
CM864A	275mm	11"	2.5mm	32mm	110mm

*NOTE: CM852A - 4 mounting holes, 9mm dia., 50mm bolt circle, 90° apart

A = Available Item Shipped within 8 working days from the time the order is placed.

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HSS M2 Steel - Bright Finish - Fully Hardened and Tempered to 56Rc.

Tool Number	Diameter		Kerf mm	Bore Size	Hub Diameter
	mm	in.			
CM866A	305mm	12"	1.6mm	5/8"	4"
CM868A	305mm	12"	1.6mm	1"	4"
CM870A	305mm	12"	2.0mm	5/8"	4"
CM872A	305mm	12"	2.0mm	1"	4"
CM874A	305mm	12"	2.5mm	5/8"	4"
CM876A	305mm	12"	2.5mm	1"	4"
CM878A	305mm	12"	3.0mm	5/8"	4"
CM880A	305mm	12"	3.0mm	1"	4"
CM882A	315mm	12.5"	2.5mm	32mm	110mm
CM884A	355mm	14"	1.6mm	1"	5"
CM886A	355mm	14"	2.5mm	1"	5"
CM888A	355mm	14"	2.5mm	32mm	5"
CM890A	355mm	14"	3.0mm	1"	5"
CM892A	355mm	14"	3.0mm	32mm	5"
CM894A	406mm	16"	2.5mm	1"	6"
CM896A	406mm	16"	3.0mm	1"	6"
CM898A	508mm	20"	3.5mm	1"	6"

A = Available Item Shipped within 8 working days from the time the order is placed.

See page 60, center boxes marked Bore Mounting Hole Patterns.

Bore Sizes and Mounting Holes not listed on page 60 are available by special quote only.

For Hub Diameters on Non-Ferrous Cold Saws see page 60.

NOTE: Other kerf sizes available by special quote. Minimum order quantity may apply.

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Recommended SFM, Feed Rate, Hook and O.D. Clearance Angles

Material	Hook Angle	O.D. CL. Angle		STOCK DIAMETER RANGE			
				1/4" - 3/4"	3/4" - 1-1/2"	1-1/2" - 2-1/2"	2-1/2" - 3-1/2"
Aluminum	24°	12°	SFM	6500	6200	6000	5000
			Feed Rate	100"/Min.	85"/Min.	80"/Min.	75"/Min.
Light Alloys (with Cu, Mg, Zn)	22°	10°	SFM	3600	3300	3000	2600
			Feed Rate	70"/Min.	65"/Min.	63"/Min.	60"/Min.
High Alloys	20°	8°	SFM	650	600	550	550
			Feed Rate	16"/Min.	16"/Min.	14"/Min.	12"/Min.
Copper	20°	10°	SFM	1300	1150	1000	800
			Feed Rate	24"/Min.	24"/Min.	22"/Min.	22"/Min.
Phosphor Bronze	15°	8°	SFM	1300	1300	1150	100
			Feed Rate	31"/Min.	28"/Min.	28"/Min.	24"/Min.
Hard Bronze	10°	8°	SFM	400	360	325	300
			Feed Rate	6.3"/Min.	6"/Min.	5.5"/Min.	5.1"/Min.
Cu Zn Brass	16°	8°	SFM	2000	2000	1800	1800
			Feed Rate	43"/Min.	43"/Min.	39"/Min.	35"/Min.
Alloyed Brass	12°	8°	SFM	1650	1300	1150	1150
			Feed Rate	27.5"/Min.	23.5"/Min.	23.5"/Min.	20"/Min.

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