

FP

## TECHNICAL INFORMATION

### CUT OFF SAW BLADES

Pitch of teeth, approximate cutting speeds for cut off saw blades and approximate rate of feed values are presented in the charts below.

#### TOOTH PITCH:

full material	E	nominal pitch							
		3	4	5	6	8	10	12	14
	4	●							
	6	●	○						
	8	●	○	○					
	10		●	○	○				
	15		●	○	○	○			
	20			●	○	○	○		
	30				○	●	○	○	
	40					○	●	○	○
	60						○	●	○
	80							○	●
100								○	●

profile	E	nominal pitch				
		3	4	5	6	8
	1	●				
	1,5	●				
	2		●			
	3		○	●	○	
	4			○	●	○
	5				●	
	6					●
	8					●

#### CUTTING PARAMETERS:

type of material being cut			feed rate (mm/min)
stainless steel	10°	6°	30 ÷ 150
steel 1000 N/mm <sup>2</sup>	10°	6°	35 ÷ 160
steel 750 N/mm <sup>2</sup>	15°	6°	60 ÷ 350
steel 500 N/mm <sup>2</sup>	18°	8°	60 ÷ 350
cast iron	10°	6°	75 ÷ 350
copper, bronze	20°	8°	500 ÷ 2000
brass	8°	6°	700 ÷ 4000
aluminium and light alloys	25°	10°	2800 ÷ 8500

#### SPINDLE SPEED:

type of material being cut	cut off saw blades diameter								
	Ø200	Ø225	Ø250	Ø275	Ø300	Ø315	Ø350	Ø370	Ø400
stainless steel	15 ÷ 35	15 ÷ 30	15 ÷ 25	10 ÷ 25	10 ÷ 20	10 ÷ 20	10 ÷ 20	10 ÷ 20	5 ÷ 15
steel 1000 N/mm <sup>2</sup>	25 ÷ 40	20 ÷ 35	20 ÷ 30	15 ÷ 30	15 ÷ 25	15 ÷ 25	15 ÷ 25	15 ÷ 25	10 ÷ 20
steel 750 N/mm <sup>2</sup>	30 ÷ 65	30 ÷ 60	25 ÷ 50	25 ÷ 45	20 ÷ 45	20 ÷ 40	20 ÷ 35	20 ÷ 35	15 ÷ 30
steel 500 N/mm <sup>2</sup>	45 ÷ 80	45 ÷ 70	40 ÷ 65	35 ÷ 60	30 ÷ 55	30 ÷ 50	25 ÷ 45	25 ÷ 45	20 ÷ 40
cast iron	45 ÷ 80	45 ÷ 70	40 ÷ 65	35 ÷ 60	30 ÷ 55	30 ÷ 50	25 ÷ 45	25 ÷ 45	20 ÷ 40
copper, bronze	320 ÷ 480	300 ÷ 430	250 ÷ 380	230 ÷ 350	210 ÷ 320	200 ÷ 300	180 ÷ 270	170 ÷ 260	160 ÷ 240
brass	680 ÷ 950	550 ÷ 850	500 ÷ 770	450 ÷ 700	430 ÷ 640	400 ÷ 600	350 ÷ 550	350 ÷ 520	300 ÷ 480
aluminium and light alloys	950 ÷ 1500	850 ÷ 1250	750 ÷ 1100	700 ÷ 1050	650 ÷ 950	600 ÷ 900	550 ÷ 820	520 ÷ 770	470 ÷ 720

**TECHNICAL INFORMATION**  
**CUT OFF SAW BLADES**
**TYPE OF MACHINE AND CUT OFF SAW BLADES SPECIFICATIONS:**

type of machine	outer diameters (mm)	hole diameters (mm)	type and diameters of driving holes (mm)
ADIGE SALA	200 – 250	32	4/9/50
	275 – 315	32	2/11/63
	350	40	4/12/64
	400 – 425	50	4/15/80
BAIER	175 – 250	32	–
BEWO	200 – 300	32	2/8/45 + 2/11/63
	315 – 350	40	2/8/55 + 4/12/63
BIMAX	100 – 300	32	2/8/45
BONAK	250 – 350	40	2/8/55 + 4/12/64
BROBO WALDON	250	32	2/8/45 + 2/11/63
	300	38	2/9/55
	300 – 400	40	2/8/55 + 4/12/64
	500	40	2/8/55 + 4/12/64 + 2/12/80
CONNI	400 – 425	40	4/11/63
	400 – 425	50	4/15/80
DALLY	250 – 500	40	2/8/55 + 4/12/64 + 2/12/80
DEMURGER	160 – 300	25,4	–
	200 – 250	32	2/8/45 + 2/11/63
	225 – 350	40	2/8/55 + 4/12/64
DONG JIN	300 – 370	40	2/8/55 + 4/12/64
DORINGER	315 – 350	40	2/12/64
EISELE	210 – 225	40	2/8/55
	250 – 350	40	2/8/55 + 4/12/64
	370 – 450	40	2/12/64 + 2/15/80
	500	40	2/12/80 + 2/15/100
EUBAMA	130 – 160	32	1/9/50 + 1/9/60
EXACTCUT	250	32	4/9/50
FABRIS	225 – 350	32	2/8/45 + 2/11/63
FEMI	225 – 350	32	2/8/45 + 2/11/63
FONG-HO	250 – 275	32	2/8/45 + 2/9/50 + 2/11/63
	300 – 400	32	4/11/63
	360	40	2/11/63 + 3/11/65
GERNETTI	250 – 350	40	4/11/63
	350	50	4/15/80
	500	50	4/18/100
	225	32	2/8/45
HAEBERLE	225 – 275	40	2/8/55
	300 – 450	40	2/8/55 + 4/12/64
	200 – 350	32	2/8/45 + 2/11/63
IBP PEDRAZZOLI	425	50	4/15/80
	250 – 370	32	2/8/45 + 2/11/63
IMET	315 – 350	40	2/8/55 + 4/12/64
	225 – 250	32	–
KALTENBACH	350 – 370	50	4/15/80
	250 – 315	32	4/9/50
KASTO	350 – 425	50	4/15/80
	250 – 315	32	2/8/45 + 2/11/63
KENTAI	250	32	2/9/50 + 2/8/45
	275 – 380	45	4/11/66
KOSOKU	300	32	2/9/50
	370 – 450	40	4/11/63
	225 – 350	32	2/8/45 + 2/11/63
MACC	350 – 450	40	2/8/55 + 4/12/64
	350 – 425	50	4/15/80
MACO	300 – 350	32	2/8/45 + 2/11/63
	300 – 350	40	2/8/55 + 4/12/64
MAIR	225 – 350	32	2/8/45 + 2/11/63
MEP	250 – 350	32	2/11/80
METORA	300 – 350	32	–
MBM MERCURY	300	32	2/8/45
	400	40	4/12/64
	400	50	4/15/80
	450 – 550	90	3/13/160
	550	80	3/13/160

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OMES	250 – 300	32	2/8/45 + 2/11/63
OMP	250 – 370	32	2/8/45 + 2/11/63
	400 – 525	50	4/15/80
OTO MILLS	500	50	4/15/80
	550	140	4/20/170
PFIFFNER / HYDROMAT	160 – 250	32	1/9/50 + 1/9/60
	160 – 250	40	2/8/55
RATTUNDE	400	50	4/15/80
RAYGOR	225 – 350	32	2/8/45 + 2/11/63
	300	38	2/9/55
	250 – 370	40	2/8/55 + 4/12/64
RGA	225 – 275	25,4	–
	250 – 370	40	2/8/55 + 4/12/64
ROBEJO	250 – 350	32	2/8/45 + 2/11/63
ROHBI	175 – 300	32	2/8/45 + 2/11/63
RSA	315	40	4/13/63
RURACK OTTO	225	32	2/8/45 + 2/11/63
	250 – 315	32	2/8/45 + 4/9/50 + 2/12/84
	370	40	4/12/64 + 2/15/80
	300 – 350	40	2/8/55 + 4/12/64
SCOTCHMAN INDUSTRIES	250 – 300	32	2/8/45 + 2/11/63
	275 – 400	40	2/8/55 + 4/12/64
SIMEC	200 – 350	32	2/8/45 + 4/11/63
SINICO	350	32	2/8/45 + 2/11/63
SOCO	250 – 350	32	2/11/63
STARTRITE	250 – 315	32	2/9/56 + 2/12/64 + 2/11/80
STAYER	225 – 350	32	–
THOMAS	225 – 350	32	2/8/45 + 2/11/63
	315 – 350	32	2/11/63 + 2/12/75
TOMET	200 – 350	32	2/8/45 + 2/11/63
	250	32	2/9/50
TRENJAEGER	250 – 315	40	4/11/63
	315 – 450	50	4/14/85
	250 – 275	32	2/8/45 + 2/11/63
TSUNE	420	50	4/15/80
	160 – 300	32	–
ULMIA	250 – 400	40	4/11/63
	560	80	4/23/120
VAI SEUTHE	250 – 350	32	2/8/45 + 2/11/63
VIEMME	275	35	2/13,5/57,2
VOUCHER	200 – 315	32	4/9/50
WAGNER	350	50	4/14/80
	250 – 400	40	2/8/55 + 2/11/63
WAHLEN	210 – 275	32	2/8/45 + 2/11/63
WEIDMANN	250 – 315	40	2/8/55 + 4/12/64
WINTER	210 – 250	32	2/8/45
WUNSCH	210 – 400	40	2/8/55 + 4/12/64