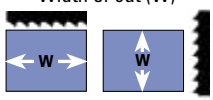
BI-METAL TOOTH SELECTION

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

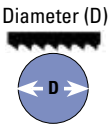
Width of cut (W)



SQUARE/RECTANGLE SOLID Locate width of cut (W)

WIDTH OF CUT																									
IN	.1	.2	.3	.4	.5	.6	.7	.8	.9	1	2	5	10	15	20	25	30	35	40	45	50				
MM	2.5	5	7.5	10	12.5	15	17.5	20	22.5	25	50	125	250	375	500	625	750	875	1000	1125	1250				
TPI	14/18	10/14	8/12	6/10	6/8 5/8					4/6	3/4	2/3	1.5/2.0	1.4/2.0	1.0/1.3					0.7/1.0					

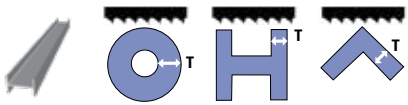
Diameter (D)



ROUND SOLID Locate diameter of cut (D)

DIAMETER OF CUT																									
IN	.1	.2	.3	.4	.5	.6	.7	.8	.9	1	2	5	10	15	20	25	30	35	40	45	50				
MM	2.5	5	7.5	10	12.5	15	17.5	20	22.5	25	50	125	250	375	500	625	750	875	1000	1125	1250				
TPI	14/18		10/14	8/12	6/10	6/8 5/8				4/6	3/4	2/3	1.5/2.0	1.4/2.0	1.0/1.3					0.7/1.0					

Wall thickness (T)



TUBING/PIPE/ STRUCTURALS Locate wall thickness (T)

WALL THICKNESS																				
IN	.05	.10	.15	.20	.25	.30	.40	.50	.60	.70	.80	.90	1	1.5	2					
MM	1.25	2.5	3.75	5	6.25	7.5	10	12.5	15	17.5	20	22.5	25	37.5	50					
TPI	14/18	10/14	8/12	6/10	6/8 5/8		4/6			3/4				2/3						

BUNDLED/STACKED MATERIALS:

To select the proper number of teeth per inch (TPI) for bundled or stacked materials find the recommended TPI for a single piece and choose one pitch coarser to cut the bundle