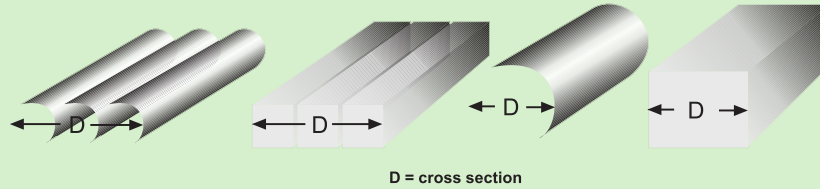


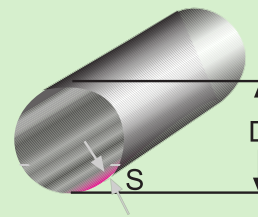
## Solid Material



Carbon Steel and Bimetal Bandsaw Blades				TCT Bandsaw Blades	
Standard Tothing		Vario Tothing		Vario Tothing	
Cross section	Tothing	Cross section	Tothing	Cross section	Tothing
bis 10 mm	14 tpi	bis 25 mm	10/14 tpi	50 - 120 mm	3/4 tpi
10 - 30 mm	10 tpi	15-40 mm	8/12 tpi	100 - 250 mm	2/3 tpi
30 - 50 mm	8 tpi	25-50 mm	6/10 tpi	150 - 400 mm	1,5/2 tpi
50 - 80 mm	6 tpi **	35-70 mm	5/8 tpi	350 - 600 mm	1,1/1,6 tpi
80 - 120 mm	4 tpi **	40-90 mm	5/6 tpi	> 500 mm	0,85/1,15 tpi
120 - 200 mm	3 tpi **	50-120 mm	4/6 tpi * **		
200 - 400 mm	2 tpi	80-180 mm	3/4 tpi * **		
300 - 700 mm	1,25 tpi	130-350 mm	2/3 tpi		
> 600 mm	0,75 tpi	150-450 mm	1,5/2 tpi		
		200-600 mm	1,1/1,6 tpi		
		> 500 mm	0,75/1,25 tpi		

- Advice:**
- \* For permanent mixed cutting with cross sections between 50 -150 mm of solid materials we also recommend our new vario tothing 4/5 tpi as an alternative of changing blades between 4/6 and 3/4 tpi.
  - \*\* Please select positive cutting angle (K, D, M or R) depending on blade quality
  - For cutting stainless steel and aluminium, we recommend choosing the tothing one grade coarser or using less than the maximum cross section width indicated.
  - For tempered materials ( $> 1200\text{N/mm}^2$ ), please choose the tothing one grade finer.
  - For cutting aluminium and non-ferrous metals we also offer special tothings e.g. 3 tpi aluminium.

## Tubes



Wall thickness S [mm]	Outside diameter D [mm]									
	20	40	60	80	100	120	150	200	300	500
2	14	10/14	10/14	10/14	10/14	8/12	8/12	8/12	8/12	5/8
3	14	10/14	10/14	8/12	8/12	8/12	8/12	6/10	6/10	5/8
4	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8	5/8	4/6 S
5	10/14	10/14	8/12	8/12	6/10	6/10	5/8	4/6 S	4/6 S	4/6 S
6	10/14	8/12	8/12	6/10	6/10	5/8	5/8	4/6 S	4/6 S	4/6 S
8	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6	4/6	4/6
10		8/12	6/10	5/8	4/6	4/6	4/6	4/6	4/6	4/5
12		8/12	6/10	4/6	4/6	4/6	4/6	4/6	4/6	4/5
15		8/12	6/10	4/6	4/6	4/6	4/6	4/5	4/5	4/5
20			4/6	4/6	4/6	4/6	4/6	4/5	4/5	3/4
30				4/6	4/6	4/5	4/5	4/5	4/5	2/3
50							4/5	3/4	2/3	2/3
80								3/4	2/3	2/3
>100									2/3	1,5/2