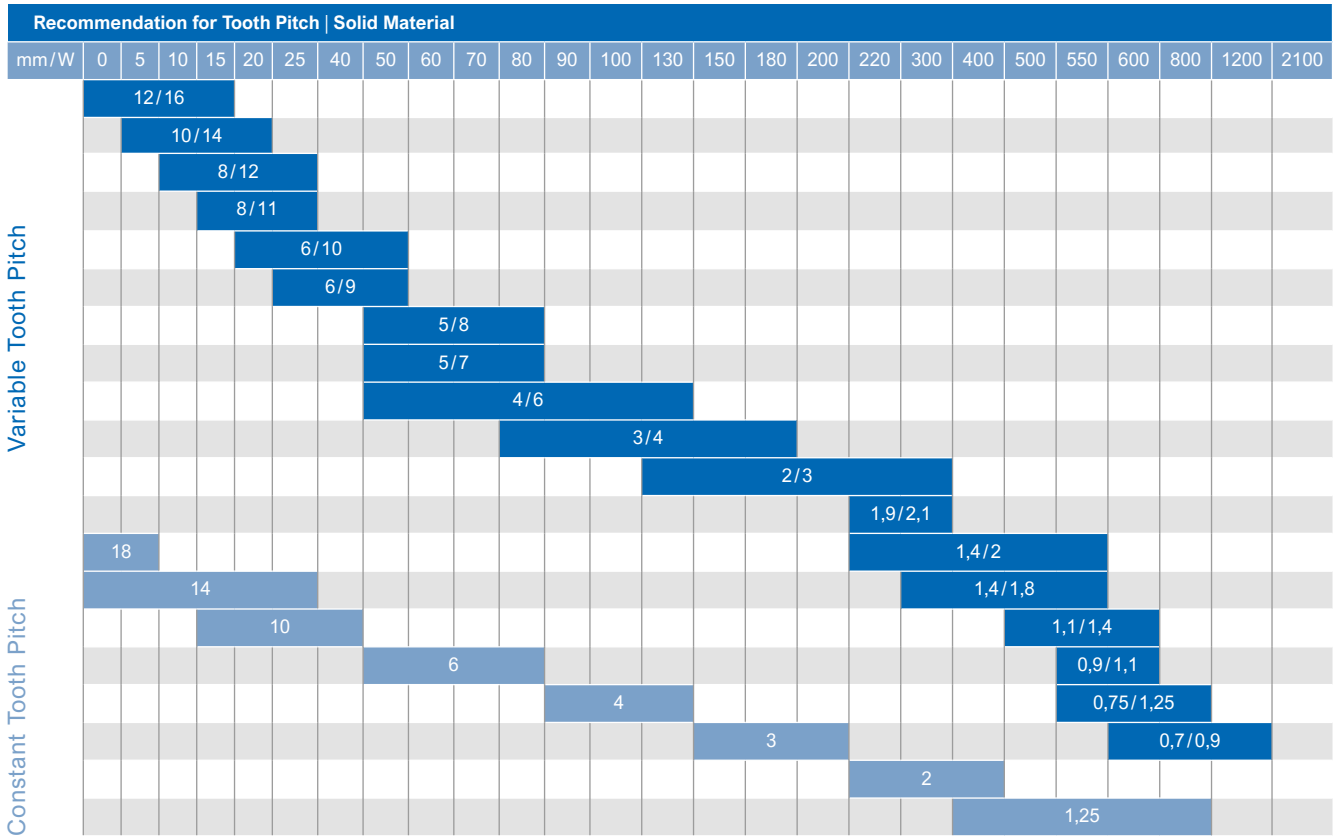


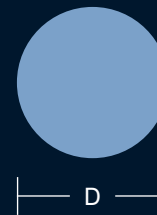
Choosing the Right Tooth Pitch



W - Width

D - Diameter

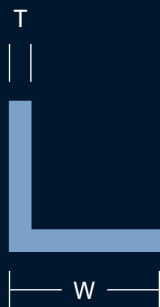
T - Thickness



Correct Tooth Pitch

- Selecting the correct tooth pitch is important for optimized cutting results
- The tooth pitch results from the engaged length of band saw blade in the material
- If the tooth pitch is too small, (irregular) cutting may result. Chips may clog the cutting length, forcing the band saw blade from its cutting line
- If the tooth pitch is too large, teeth may break out because the cutting pressure acting upon individual teeth becomes too high
- At least 3 teeth are recommended to be engaged to achieve an optimum result

Recommendation for Tooth Pitch Tubes and Profiles												
Diameter in mm	25	50	75	100	125	150	175	200	250	300	400	500
Thickness in mm	Toothing											
2	18	18	18	18	12 / 16	10 / 14	10 / 14	10 / 14	8 / 11	8 / 11	8 / 11	8 / 11
4	12 / 16	12 / 16	10 / 14	8 / 11	6 / 9	6 / 9	6 / 9	6 / 9	5 / 7	5 / 7	5 / 7	5 / 7
6	12 / 16	8 / 11	8 / 11	6 / 9	5 / 7	5 / 7	5 / 7	5 / 7	4 / 6	4 / 6	4 / 6	4 / 6
8	12 / 16	6 / 9	6 / 9	5 / 7	5 / 7	5 / 7	4 / 6	4 / 6	4 / 6	4 / 6	4 / 6	4 / 6
10	12 / 16	5 / 7	5 / 7	4 / 6	4 / 6	4 / 6	4 / 6	4 / 6	3 / 4	3 / 4	3 / 4	3 / 4
15		5 / 7	4 / 6	4 / 6	4 / 6	4 / 6	3 / 4	3 / 4	3 / 4	3 / 4	3 / 4	3 / 4
25			4 / 6	4 / 6	3 / 4	3 / 4	3 / 4	3 / 4	2 / 3	2 / 3	2 / 3	2 / 3
35			3 / 4	3 / 4	3 / 4	3 / 4	2 / 3	2 / 3	2 / 3	2 / 3	2 / 3	2 / 3
50					2 / 3	2 / 3	2 / 3	2 / 3	2 / 3	2 / 3	2 / 3	2 / 3
65						2 / 3	2 / 3	1,4 / 2	1,4 / 2	1,4 / 2	1,4 / 2	1,4 / 2
75							2 / 3	1,4 / 2	1,4 / 2	1,4 / 2	1,4 / 2	1,4 / 2
100								2 / 3	1,4 / 2	1,4 / 2	1,4 / 2	0,75 / 1,25
130									1,4 / 2	1,4 / 2	1,4 / 2	0,75 / 1,25
150										1,4 / 2	1,4 / 2	0,75 / 1,25
200												0,75 / 1,25
250												0,75 / 1,25



If you have two or more tubes side by side lying to be separated, then you consult the table under consideration of the doublewall thickness.

Factors for the right choice of the tooth pitch:

- Saws of tubes and profiles in bundles
- Saws of tubes and profiles in the single cut