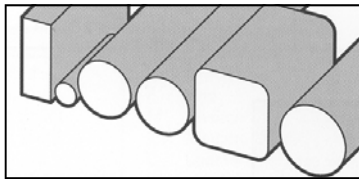
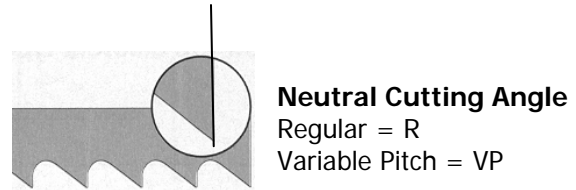
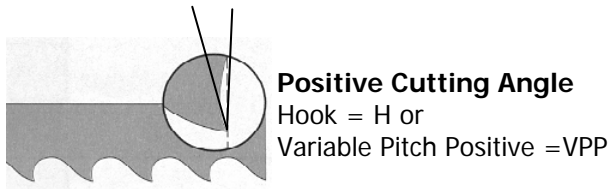


Blade Pitch (TPI=Teeth Per Inch)



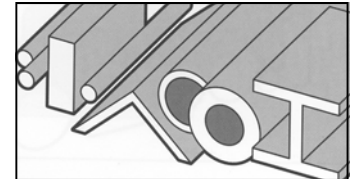
Choose The Proper Blade Pitch (Teeth Per Inch)

Use the charts to determine the proper TPI for cutting metal




Use H= Hook or
VPP= Variable Pitch, Positive

Use R= Regular or
VP= Variable Pitch



Saw Blades

| Blade Pitch, Solids | | | Blade Pitch, Profiles | | | | | | | | |
|--|--|---|--|--|-------------|-------------|------------|-------------|-------------|-------------|-------------|
| Constant Pitch R = 0° angle H = Hook | Thickness (Diameter)  | Variable Pitch VP= 0° angle VPP= Positive | * D = Diameter of Tube or Width of Profile | | | | | | | | |
| | | | D* | 3/4" | 1-1/2" | 2-1/4" | 3" | 4" | 6" | 8" | 12" |
| | | | Wall | Tooth Pitch R= °angle, VP= ° angle, VPP= Positive angle | | | | | | | |
| 18 R | 2 – 3mm 1/16" – 1/8" | 10/14 VP | 5/64" .078 | 14 R 18 R | 14 R VP | 14 R VP | 14 R VP | 10/14 VP | 10/14 VP | 10/14 VP | 10/14 VP |
| 14 R | 5 – 8mm 3/16" – 3/8" | 8/12 VP | 1/8" .125 | 14 R | 10/14 VP | 10/14 VP | 8/12 VP | 8/12 VP | 8/12 VP | 6/10 VP | 6/10 VP |
| 10 R | 12 – 16mm 1/2" – 5/8" | 6/10 VP | 5/32" .156 | 14 R | 10/14 VP | 10/14 VP | 8/12 VP | 8/12 VP | 6/10 VP | 6/10 VP | 5/8 VP |
| 8 R | 22 – 25mm 3/4" – 1" | 5/8 VP | 3/16" .188 | 14 R | 10/14 VP | 10/14 VP | 8/12 VP | 6/10 VP | 6/10 VP | 5/8 VP | 4/6 VP |
| 6 H | 25 – 30mm 1" – 1-1/4" | 5/8 VP | 1/4" .25 | 14 R | 10/14 VP | 8/12 VP | 8/12 VP | 6/10 VP | 5/8 VP | 5/8 VP | 4/6 VP |
| 4 H | 40 – 70mm 1-1/2" – 3" | 4/6 VPP | 5/16" .313 | 14 R | 8/12 VP | 6/10 VP | 6/10 VP | 6/10 VP | 5/8 VP | 5/8 VP | 4/6 VP |
| 3 H | 80 – 100mm 3" – 4" | 3/4 VPP | 3/8" .125 | | 6/10 VP | 6/10 VP | 5/8 VP | 5/8 VP | 4/6 VP | 4/6 VPP | 4/6 VPP |
| 2 H | 130 – 250mm 5" – 10" | 2/3 VPP | 1/2" .50 | | 6/10 VP | 5/8 VP | 4/6 VPP | 4/6 VPP | 4/6 VPP | 4/6 VPP | 3/4 VPP |
| 1.2 H | 300 – 500mm 12" – 18" | 1/2 VPP | 5/8" .625 | | | | 4/6 VPP | 4/6 VPP | 3/4 VPP | 3/4 VPP | 3/4 VPP |
| .75 H | 600mm + 24" + | .75/1.2 VPP | 3/4" .75 | | | | 4/6 VPP | 4/6 VPP | 3/4 VPP | 3/4 VPP | 3/4 VPP |

Bundle Cutting: Choose the correct blade for 1 piece and then use the next coarser tooth pitch for the bundle.