



Industrial Power/ Machine Saw Blades

Designed for use across a wide range of ferrous and non-ferrous materials.

Power Saw Blade Selection

Power Saw Hacksaw Blade Tooth Recommendations

TPI	Suitable for Section Width
18	up to 13mm (up to ½")
14	6 to 19mm (¼" to ¾")
10	8 to 25mm (⅝" to 1")
6	13 to 38mm (½" to 1 ½")
4	19mm and above (¾" and above)

Type of Machine	Coolant Required	Unannealed Tool Steel & Hard Metals	Annealed Tool Steel	Machinery Steel & Soft Metal
Light	No	40spm	50 - 60spm	50-60spm
Medium	No	40spm	50 - 60spm	50-60spm
Medium	Yes	60spm	60 - 90spm	100-110spm
Heavy	Yes	60spm	90spm	110-120spm
Ex. Heavy	Yes	60spm	90spm	110-120spm

18 Teeth Per Inch

Recommended for cutting thin cross-sections such as tubing, small bars and light angle iron. Because blades are relatively thin they should be used only on light machines.

10 - 14 Teeth Per Inch

Recommended for cutting small cross sections and hard stock. This is the most popular choice for machine shops that are cutting a wide variety of materials.

4 - 6 Teeth Per Inch

Recommended for cutting large sections of softer ferrous metals, most alloy steels and all non-ferrous metals. The increased gullet clearance is able to handle heavy chips without clogging.

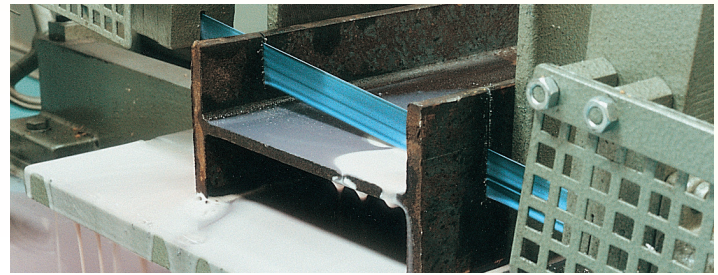
Operating Recommendations

Lower speeds and higher feed give best results. Ensure that the machine lifts the blade slightly on the return stroke. Exact speed and feed for each job can be established only from tests. The table below is to be used for guidance only.

When matching a section thickness against a suitable Blade TPI there are usually a number of blade options - Use coarse pitches (less TPI) for faster cutting and finer pitches (more TPI) for better surface finishes.

HSS All Hard Power Saw Blades

Recommended for cutting thin cross-sections such as tubing, small bars and light angle iron. Because blades are relatively thin they should be used only on light machines.



Length	Width	Thickness	TPI	Weight per 10	Order Code KEN-040	Price/1 THB
12"	5/8"	.032"	18T	0.36kg	-4630K	271.00
12"	1"	.050"	10T	0.78kg	-5030K	330.00
12"	1"	.050"	14T	0.79kg	-5040K	330.00
14"	1"	.050"	10T	0.93kg	-5130K	354.00
14"	1"	.050"	14T	0.80kg	-5140K	354.00
14"	1 ¼"	.062"	6T	1.30kg	-5200K	483.00
14"	1 ¼"	.062"	10T	1.30kg	-5220K	483.00
14"	1 ¼"	.062"	14T	1.30kg	-5230K	483.00
16"	1 ¼"	.062"	6T	1.40kg	-5390K	525.00
16"	1 ¼"	.062"	10T	0.90kg	-5410K	525.00
16"	1 ¼"	.062"	14T	1.60kg	-5420K	525.00
16"	1 ½"	.062"	4T	2.20kg	-5490K	672.00
16"	1 ½"	.062"	6T	2.20kg	-5500K	672.00
17"	1 ¼"	.062"	10T	1.80kg	-5530K	767.00
18"	1 ¼"	.062"	6T	1.90kg	-5550K	777.00
18"	1 ¼"	.062"	10T	1.60kg	-5570K	777.00
18"	1 ½"	.075"	6T	2.55kg	-5650K	767.00
19"	1 ¾"	.088"	6T	3.80kg	-5720K	1323.00
20"	1 ½"	.075"	6T	3.20kg	-5750K	1533.00
21"	1 ½"	.075"	6T	3.00kg	-5770K	1670.00
21"	1 ½"	.075"	10T	3.00kg	-5790K	1806.00
21"	1 ¾"	.088"	6T	5.30kg	-5820K	1869.00
24"	2"	.100"	6T	6.30kg	-5960K	2079.00

Speeds & Feeds - Recommended speeds, strokes per minute and TPI.

Group	Materials	Brinell Hardness HB	Rockwell Hardness HRC	Tensile Strength N/mm²	Cutting Speed m/min	Strokes Per Min	Section Thickness or diameter-Recommended TPI			
							Below 10mm	10-40 mm	40-80 mm	Above
1.1 to 1.2	General purpose steels mild and structural	<200	-	<700	25 - 35	70 - 90	14	10 - 6	6 - 4	4
1.3	Non-alloy, plain and medium carbon steels and castings	<260	<26	<850	20 - 30	50 - 70	14	10 - 6	6 - 4	4 - 3
1.4	Alloy steels generally low to medium steels and castings	<260	<26	<850	20 - 30	50 - 70	14	10 - 6	6 - 4	4 - 3
1.5	Medium to high alloy steels tool steels and steel castings	>260 <340	>26 <36	>850 <1200	18 - 28	40 - 60	14	10 - 6	6 - 4	4 - 3
1.6	Heat treated high alloy steels and castings	>340 <450	>36 <48	>1200 <1500	15 - 25	30 - 45	14	10 - 6	6 - 4	4 - 3
2.1 to 2.3	Stainless steels free machine and austenitic	<290	<30	<1000	10 - 25	40 - 60	14	10 - 6	6 - 4	4 - 3
3.1 to 3.2	Grey cast iron	<300	-	-	30 - 40	70 - 90	14	10 - 6	6 - 4	4 - 3
3.3 to 3.4	S.G. iron nodular and malleable	<300	-	-	30 - 40	70 - 90	14	10 - 6	6 - 4	4 - 3
6.1 to 6.3	Non ferrous metals brass, copper and bronze	-	-	<800	40 - 60	80 - 115	14	10 - 6	6 - 4	4 - 3
7.1 to 7.4	Aluminium alloys to zinc and magnesium	-	-	<50	40 - 60	80 - 115	14 - 10	10 - 6	6 - 4	4 - 3