

## HSS / COLBALT SLITTING SAWS

MATERIAL GROUP	MATERIAL	Diameter (mm)												
		20	25	32	40	50	63	80	100	125	160	200	250	315
<b>M</b>	Stainless Steel	318	255	199	159	127	101	80	64	51	40	32	25	20
<b>P</b>	Steel	637	509	398	318	255	202	159	127	102	80	64	51	40
<b>K</b>	Cast Iron	637	509	398	318	255	202	159	127	102	80	64	51	40
<b>N</b>	Copper	2387	1910	1492	1194	955	758	597	477	382	298	239	191	152
	Brass	3183	2546	1989	1592	1273	1011	796	637	509	398	318	255	202
	Alu and Light Metals	6366	5096	3979	3183	2546	2021	1592	1273	1019	769	637	509	404
	Pipes Welded	955	764	597	477	382	303	239	191	153	119	95	76	61
	Pipes Seamless	1114	891	696	557	446	354	279	223	178	139	111	89	71

**ALL FIGURES GIVEN ARE RPM RECOMMENDED STARTING POINTS**

**RPM X 0.01 X NUMBER OF TEETH = FEED RATE (MM/MIN)**