

## SAWBLADE RECOMMENDATION CHART

| TUBE & PIPE<br>WALL THICKNESS | SAWBLADE DIAMETER |           |                        |           |                        |
|-------------------------------|-------------------|-----------|------------------------|-----------|------------------------|
|                               | 250mm-10"         | 300mm-12" | 315mm-12"<br>325mm-13" | 350mm-14" | 400mm-16"<br>450mm-18" |
| .025 - .065                   | 240T              | 280T      | 280T                   | 360T      | 360T                   |
| .065 - .095                   | 180T              | 220T      | 220T                   | 280T      | 280T                   |
| .095 - .125                   | 140T              | 180T      | 180T                   | 220T      | 240T                   |
| .125 - .187                   | 120T              | 140T      | 160T                   | 160T      | 220T                   |
| .187 - .312                   | 90T               | 110T      | 140T                   | 140T      | 180T                   |
| .312 & ABOVE                  | 90T               | 80T       | 80T                    | 110T      | -                      |

| SOLID MATERIAL<br>DIAMETER | SAWBLADE DIAMETER |           |                        |           |                        |
|----------------------------|-------------------|-----------|------------------------|-----------|------------------------|
|                            | 250mm-10"         | 300mm-12" | 315mm-12"<br>325mm-13" | 350mm-14" | 400mm-16"<br>450mm-18" |
| .0250                      | 140T              | 180T      | 160T                   | 180T      | 220T                   |
| 0.250 - 0.750              | 120T              | 140T      | 140T                   | 160T      | 160T                   |
| 0.750 - 1.250              | 80T               | 110T      | 110T                   | 110T      | 110T                   |
| 1.250 - 2.0                | 80T               | 80T       | 80T                    | 80T       | -                      |
| 2.0 & ABOVE                | 60T               | 60T       | 80T                    | -         | -                      |

### CUTTING TIPS

- Let the saw do the work. Do not pull down too hard on the handle. Too much pressure increases chattering and vibration and decreases sawblade life.
- Make sure sawblade is tightly secured to main spindle (left-hand thread).
- Make sure material being cut is tightly vised in saw.
- When cutting non-ferrous materials, cut at the highest available speed, using largest diameter available sawblade, with one level coarser than above recommended chart.
- When cutting stainless or alloy steels, cut at lowest available speed, using smallest diameter sawblade, with one level finer than above recommended chart, and enrich coolant.
- When straight cutting square tubing with a seam, set the tube with a seam in a vertical wall.
- Always saw thru the thinnest part of the material. For example when sawing ½" by 3" flat bar, stand it up. Place angle iron in a teepee not an L.

## **DORINGER COLD SAWS, INC.**

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