



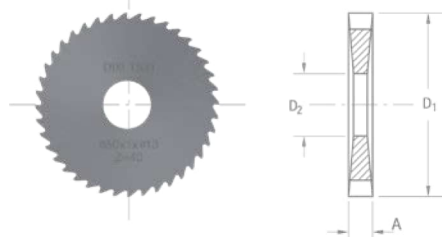
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SLITTING SAWS COARSE PITCH TEETH



- Coarse pitch slitting saws developed for deep grooving. For optimal performance, it is recommended to have 3 to 5 teeth in material.

○ good ⊗ excellent

ISO	P													M				K					
Materials description	Unalloyed steel					Low alloyed steel				High alloyed steel		Martensitic stainless steel		Austenitic stainless steel (DUPLEX / PH)				Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	14.4	15	16	17	18	19	20
Recommendations	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	○	○	○	○	○	○	○	○	⊗	⊗	○	○	○	○

ISO	N												S					H			
Materials description	Wrought aluminium alloy		Cast aluminium alloy			Cu + Pb alloy	Cu alloy difficult		Gold, Silver	Graphite	Plastic	Wood	Special alloy Ni / Co			Titanium, titanium alloy		Hardened steel		Hard cast iron	
VDI 3323	21	22	23	24	25	26	27	28	-	-	29	30	31	32	33-35	36	37	38	39	40	41
Recommendations	○	○	○	○	○	⊗	⊗	⊗	⊗	⊗	○	○	○	○	○	⊗	⊗				

D _{1 js12}	A _{± 0.01}	D _{2 H6}	Z	CARBIDE
15	0.20	5	32	37180
15	0.30	5	24	37182
15	0.40	5	24	35382
15	0.50	5	24	35383
15	0.60	5	20	601
15	0.70	5	20	603
15	0.80	5	20	2532
15	0.90	5	20	7707
15	1.00	5	20	602
15	1.20	5	16	38947
15	1.50	5	16	38948
15	1.60	5	16	42457
15	1.80	5	16	42536
15	2.00	5	16	38949
20	0.20	5	40	35384
20	0.30	5	32	35385
20	0.40	5	32	3281
20	0.50	5	24	31481
20	0.60	5	24	604
20	0.70	5	24	605
20	0.80	5	24	37080
20	0.90	5	20	3282
20	1.00	5	20	3283
20	1.20	5	20	2425
20	1.50	5	20	3287
20	1.60	5	20	3288
20	1.80	5	20	3290
20	2.00	5	16	42458
20	2.50	5	16	42459

D _{1 js12}	A _{± 0.01}	D _{2 H6}	Z	CARBIDE
25	0.30	8	40	37740
25	0.40	8	32	42461
25	0.50	8	32	42376
25	0.60	8	24	42377
25	0.70	8	24	42378
25	0.80	8	24	2479
25	0.90	8	24	42379
25	1.00	8	24	42380
25	1.20	8	24	42462
25	1.50	8	20	3299
25	1.60	8	20	3300
25	1.80	8	20	3301
25	2.00	8	20	3303
25	2.50	8	20	3305
30	0.30	8	40	37845
30	0.40	8	40	37841
30	0.50	8	40	35386
30	0.60	8	32	30662
30	0.70	8	32	3309
30	0.80	8	32	41350
30	0.90	8	32	41351
30	1.00	8	32	36413
30	1.20	8	24	1327
30	1.50	8	24	3316
30	1.60	8	24	3317
30	1.80	8	24	3319
30	2.00	8	24	3321
30	2.50	8	20	42466
30	3.00	8	20	42467



SLITTING SAWS COARSE PITCH TEETH



D _{1 js12}	A _{± 0.01}	D _{2 H6}	Z	CARBIDE
30	4.00	8	20	42468
40	0.40	10	48	42470
40	0.50	10	40	2662
40	0.60	10	40	6348
40	0.70	10	40	17953
40	0.80	10	40	42471
40	0.90	10	32	38817
40	1.00	10	32	3034
40	1.20	10	32	3307
40	1.50	10	32	3326
40	1.60	10	32	3798
40	1.80	10	24	39499
40	2.00	10	24	42472
40	2.50	10	24	42473
40	3.00	10	24	42474
40	4.00	10	20	42475
50	0.40	13	48	26023
50	0.50	13	48	42477
50	0.60	13	48	42478
50	0.70	13	48	14681
50	0.80	13	40	3330
50	0.90	13	40	41064
50	1.00	13	40	8636
50	1.20	13	40	8637
50	1.40	13	32	3336
50	1.50	13	32	25731
50	1.60	13	32	3337
50	1.80	13	32	3657
50	2.00	13	32	2533
50	2.50	13	32	3339
50	3.00	13	24	42479
63	0.80	16	48	3342
63	0.90	16	48	49467
63	1.00	16	48	609
63	1.20	16	40	3658
63	1.50	16	40	3345
63	1.60	16	40	3346
63	1.80	16	40	3347
63	2.00	16	40	610
63	2.50	16	32	42483
63	3.00	16	32	611
80	0.80	22	64	6070

D _{1 js12}	A _{± 0.01}	D _{2 H6}	Z	CARBIDE
80	0.90	22	48	49665
80	1.00	22	48	3054
80	1.20	22	48	4016
80	1.50	22	48	3349
80	1.60	22	48	34808
80	1.80	22	40	22178
80	2.00	22	40	2807
80	2.50	22	40	42484
80	3.00	22	40	21847
100	1.00	22	64	38542
100	1.20	22	64	38543
100	1.50	22	48	35387
100	1.60	22	48	39146
100	1.80	22	48	38927
100	2.00	22	48	38928
100	2.50	22	48	36588
100	3.00	22	40	38713
125	1.00	22	80	42489
125	1.20	22	64	42490
125	1.50	22	64	38480
125	1.60	22	64	42492
125	1.80	22	64	42493
125	2.00	22	64	39005