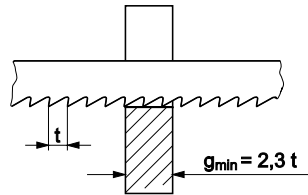


## TECHNICAL INFORMATION

### POWER HACKSAW BLADES

#### SELECTION OF THE NUMBER OF TEETH AND THE THICKNESS OF THE MATERIAL BEING CUT:

number of teeth per 25 mm	n minimum thickness of material being cut $g_{min}$
	mm
4	14,5
6	9,5
8	7,2
10	5,7
14	4,1



#### SELECTION OF TEETH AND CUTTING SPEED OF POWER HACKSAW BLADES:

material	number of teeth per 25 mm	slide strokes per minute
aluminium	4-6	120
hard bronze	6-8-10	60-90
soft bronze	4-6	60-90
hard cast iron	6-8-10	60-90
soft cast iron	4-6	90-120
hard brass	6-8-10	90
soft brass	4-6	120
soft carbon steel	4-6	120
low-alloy structural steel	4-6	120
high-alloy structural steel	6-8-10	90-120
low-alloy tool steel	6-8-10	120
high-alloy tool steel	6-8-10-14	90
high-speed steel	6-8-10-14	90
stainless steel	4-6-8-10	60-90