

TPI Selection Guide for Solids

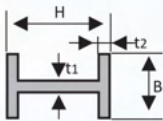
Size of Material	Pitch																
			(1.25)		(2)		(3)		(4)	6		8		10	12	14	18
mm	0.75/1	1/1.5	½	1.5/2	2/3		¾		4/6	5/7	6/10		8/12				
~4																	
~10																	
~20																	
~40																	
~60																	
~100																	
~150																	
~200																	
~300																	
~400																	
~600																	
~800																	
800~																	

Application Machines	For Cut Off Machine													
								For Rotary Machine						
	For Contour Machine													

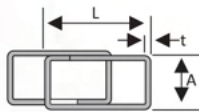
Note: Bundle cutting, please select the size that one pitch is large when cutting length is equal to or less than 100mm (3.94inch).

TPI Selection Guide for Structural Steels & Tubes

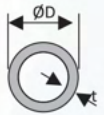
● H section steels



● Light gauge steels



● Tube



	Size of Material				TPI
	H	B	t ₁	t ₂	
mm	300	150	6	9	5/7
mm	400	200	8	13	3/4
mm	500	200	10	16	3/4
mm	600	200	11	17	3/4
mm	700	300	13	24	3/4
mm	800	300	14	26	2/4, 3/4
mm	900	300	16	28	2/3

	Size of Material			TPI
	L	A	T	
mm	60	30	1.6	14
mm	75	45	1.6	12
mm	100	50	2.0	8/12
mm	125	50	3.2	8/12
mm	150	65	3.2	6/10
mm	200	75	4.0	6/10
mm	250	75	4.5	5/7

t	D mm	TPI						
		20	40	60	80	120	160	200
mm	2	14	14	14	14	14	14	14
mm	4	14	14	12	12	8/12	8/12	6/10
mm	6		8/12	8/12	6/10	6/10	5/7	5/7
mm	8			6/10	6/10	5/7	5/7	4/6
mm	10				5/7	5/7	4/6	4/6
mm	12					4/6	4/6	4/6

Please select a TPI in such a way that at any time of cutting at least two teeth are engaged in the section.