



Pipe Cutting System

Blade Life Chart

Stainless steel		Cermet			
Actual Pipe size	Nominal pipe size	SCHED 5	SCHED 10	SCHED 40	SCHED 80
14	14	9	5	0	0
12.75	12	9	8	0	0
10.75	10	13	11	0	0
8.625	8	20	15	7	0
6.625	6	26	21	10	0
5.563	5	31	25	14	0
4.500	4	50	35	18	0
4.000	3.5	57	40	22	16
3.500	3	65	46	26	19
2.875	2.5	80	56	34	26
2.375	2	123	75	54	39

Mild Steel		Cermet			
Actual Pipe size	Nominal pipe size	SCHED 5	SCHED 10	SCHED 40	SCHED 80
14	14	25	16		
12.75	12	28	24		
10.75	10	38	31		
8.625	8	58	43	20	
6.625	6	76	62	31	
5.563	5	91	75	40	
4.500	4	148	103	54	
4.000	3.5	167	117	64	46
3.500	3	191	134	77	57
2.875	2.5	234	164	100	76
2.375	2	361	220	159	115

Cast-Iron		Diamond Disk
Actual Pipe size	Nominal pipe size	
12.5	12	144
10.5	10	172
8.380	8	263
6.300	6	448
5.300	5	535
4.300	4	665
3.300	3	927
2.300	2	1363

Copper		TCT-Blade		
Actual Pipe size	Nominal Pipe size	K	L	M
12.125	12	*	74	82
10.125	10	*	100	117
8.125	8	116	156	182
6.125	6	217	294	337
5.125	5	311	395	451
4.125	4	461	559	644
3 5/8	3 1/2	587	700	839
3.125	3.000	750	903	1122
2 5/8	2 1/2	1026	1212	1483
2.125	2	1456	1715	2058

* Possible to cut with oversized blade

Fiber glass with a Diamond Disk

Thousands of cuts.

Plastics with TCT blade:

Thousands of cuts.

Note:

You can re-sharpen a blade 2-3 times. Getting 80% of previous blade life.

Example: 6" SCHED 10 Mild Steel cut with a Cermet blade.

New Blade	1 Re-sharpen	2 Re-sharpen	3 Re-sharpen	Total number of cuts
62	50	40	32	183