

Selecting the Cutting Load and Blade for XB-65A / 125 / 120A mini / 180WS / 180WA

Use the table below to select the blade and cutting load that are appropriate for the type, diameter, wall thickness etc. of the material to be cut.

Material				Alloy Blade					High-speed steel Blade				Grid saw	
			tooth	8	10	14	18	24	10	14	18	24		
Steel pipe			Nominal size	8A - 25A (¼"-1")			L	L		L	L			
				32A - 80A (1¼"-3")			M	M		M	M			
				90A - 150A (3½"-6")			H	H		H	H			
Stainless steel	Schedule 40	8A - 25A (¼"-1")						L	L					
		32A - 80A (1¼"-3")						M	M					
		90A - 150A (3½"- 6")						H	H					
	Thin wall stainless steel (SU pipe)	13 - 125Su								LL				
		150Su								LL	L*3			
Plastic pipe (Polyethylene pipe / Vinyl chloride pipe)						LL	LL			LL	LL			
Conduit				Thick steel				M				M		
			Thin steel				L	L			L	L		
Cast iron pipe						H				H				
Mortar-lined cast-iron pipe													H	
Steel	Section steel	Thickness	≤ 1.9 mm					LL				LL		
			2 - 3.4 mm			L*1	L*2			L*1	L*2			
			3.5 - 4.9 mm			M*1	M			M	M			
			5 - 7.9 mm		M	H			M	H				
			≥ 8 mm		H	H			H	H				
	Round bar		≤ 15 mm			M	M			M	M			
			16 - 50 mm*4			H				H				
			51 - 80 mm*1	H	H					H	H			

LL= ultra-light load L= light load M= medium load H= heavy load

Notes: · The figures in the table are examples only. Select the blade and cutting load to match the actual material to be cut.

· When selecting the proper number of teeth on the blade, use the following guideline: thickness of material = 2 teeth.

· Depending on their composition or hardness, some materials are not applicable to the above table.

· When cutting plastic pipes, even if LL (ultra-light load) is selected, the cutting load may be too heavy and the pipe may be cut at an angle.

To prevent this, hold the handle on the frame with your hand and lower it slowly as you cut the pipe..

*1 XB180W only

*2 XB125/120A mini : M

*3 XB125/120A mini : LL

*4 XB125/120A mini : 16 - 60mm

No. of notches to set the valve lever at when cutting (for XB270A)

Material				High-speed steel Blade	
				14	18
				Valve lever notches	
Steel pipe		Nominal size	20A - 50A (¾"-2")	1-2	1-3
			65A - 250A (2½"-10")	2-4	2-4
Stainless steel	Schedule 40		20A - 50A (¾"-2")	1-2	1-3
			65A - 250A (2½"-10")	2-4	2-4
	Thin wall stainless steel (SU pipe)		20 - 25Su		0.5
			30Su - 75Su		0.5-1
			80Su - 125Su		1-2
			150Su		1-3
Plastic pipe (Vinyl chloride / Polyethylene pipe)			1-2	1-2	
Cast iron pipe			2-4		
Steel	Section steel	Thickness	1 - 2 mm		0.5-1
			2 - 3 mm		1-3
			3 - 4 mm	1-2	1-3
			>= 4 mm	2-4	2-4
	Round bar		=< 15 mm	1-2	1-3
			16 - 40 mm	2-4	

Saw blade essentials

Two types available

Alloy blade for steel pipe

HSS blade for stainless steel pipe

What is the difference between the 14-tooth and the 18-tooth blade?

14-T: Provides a sharper, faster cut

18-T: More precise for right angles

but slower than the 14-T

What does "tooth" mean?

14-tooth means there are 14 teeth per inch (25.4mm).

