

# BIMETAL / M42

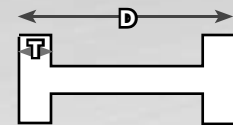
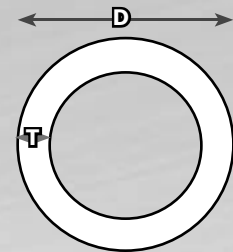
## CHOOSING THE TOOTH PITCH

### SOLID MATERIAL

<b>DIAMETER</b> of Solid Material	1/2"	1"	1-1/2"	2"	3"	5"	10"	20"
<b>TOOTHING</b> teeth/inch (tpi)	10-14	8-12	6-10	5-8	4-6	3-4	2-3	1.4-2

### TUBING AND PROFILES

WALL THICKNESS	OUTSIDE DIAMETER								
	3/4"	1-1/2"	2-1/4"	3"	4"	6"	8"	12"	20"
1/8"	14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	6/10
3/16"	14	10/14	10/14	8/12	6/10	6/10	5/8	4/6	4/6
1/4"	14	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6
3/8"		6/10	6/10	5/8	5/8	4/6	4/6	4/6	3/4
1/2"		6/10	5/8	4/6	4/6	4/6	4/6	3/4	3/4
5/8"				4/6	4/6	3/4	3/4	3/4	2/3
3/4"				4/6	4/6	3/4	3/4	3/4	2/3
1-1/4"				3/4	3/4	3/4	2/3	2/3	2/3
2"						2/3	2/3	2/3	1.4/2
3"							2/3	1.4/2	1.4/2
4" - UP								1.4/2	.75/1.25



**D** = OUTSIDE DIAMETER  
**T** = WALL THICKNESS

## BIMETAL BREAK IN PROCEDURE

In order to avoid tooth fracture, a break in procedure is recommended whenever a new bimetal band is installed. The softer the material is, the more a break in procedure is recommended. During break in, run the band at the recommended band speed for the material, but reduce feeding rate as indicated below.

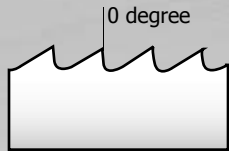
STEP 1			STEP 2		STEP 3	
SFPM	% Feed	Duration	% Feed	Duration	% Feed	Duration
300+	50	40 SQ. INCH	75	30 SQ. INCH	90	10 SQ. INCH
225-300	60	35 SQ. INCH	80	20 SQ. INCH	95	10 SQ. INCH
150-225	70	25 SQ. INCH	85	15 SQ. INCH	95	5 SQ. INCH
90-150	75	20 SQ. INCH	90	10 SQ. INCH		
50-90	80	15 SQ. INCH	95	5 SQ. INCH		



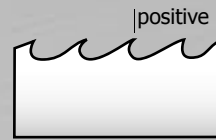
# AMA2

## RECOMMENDED TOOTH PROFILE

**S** - DESIGNED FOR THINNER SECTIONS



**P, XP** - DESIGNED FOR SOLIDS OR HEAVIER SECTIONS



## BIMETAL PROGRAM

**PITCH** - Teeth/Inch (TPI)

WIDTH	THK	1.25	3	4	6	10	14	.75/1.25	1.4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14	14/18	
1/4"	.035				P												S	
3/8"	.035			P													S	
1/2"	.025				P	S	S							S	S	S	S	
1/2"	.035		P	P			S								S	S		
5/8"	.035																S	
3/4"	.035		XP	P			S					P	P	S	S	S		
1"	.035									XP	XP	S, P, XP	P	S	S	S		
1-1/4"	.042									XP, W	XP, W	S, P	P	S	S			
1-1/2"	.050								XP	XP, W	XP, W	S, P	P	S				
2"	.050									XP	XP							
2"	.063	XP							XP	XP	XP, W	P						
2-5/8"	.063							XP	XP	XP								
3-1/8"	.063							XP	XP	XP								

w=widerset

