

Complete Metalworking Solutions Roseville Saginaw & Jackson, MI ISO Certified (800) 991-4225 www.ahbine.com customerservice@ahbinc.com

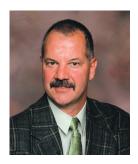
GAYLEE SAWS



Our "Back-To-Basics" Goals and Ideals:

- Outstanding Customer Service
- Quality Tools
- Shipped On Time

Contact Don or Mike at Gaylee Saws for all of your sawing requirements.



Don Muir General Manager Gaylee Saws



Mike Jensen Customer Service Gaylee Saws

Thank you for your interest in Gaylee Saws, a leading manufacturer of industrial thin saws and cutters available in solid carbide, carbide-tipped, and now, high speed steel.

Our position as a premier manufacturer of carbide thin saws is the result of over 60 years of extensive experience and service in the industrial tooling market. Originally founded in 1947, the Gaylee Corporation became an integral part of North American Tool Corporation in 1994.

This catalog from Gaylee Saws represents an extensive array of carbide thin saws, manufactured to limits of accuracy and tolerances unsurpassed by most tool manufacturers.

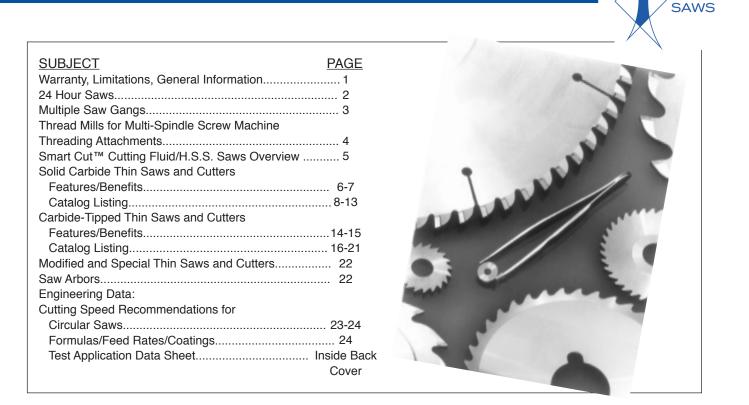
Whether as stocked standards, modified specials, or precision custom designed full specials, Gaylee saws and cutters could be your solution to costly 'problem jobs' or your everyday sawing and cutting operations.

We welcome the opportunity to work with you as your trusted source for solid carbide, carbide tipped and H.S.S. saws and cutters. Feel free to contact us to discuss your cutting tool requirements at: 800-991-4225 Phone





Gaylee Saw's modern manufacturing facility located in Sterling Heights, Michigan.



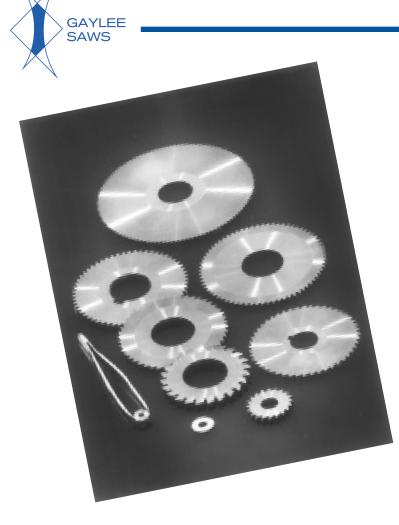
GAYLEE warrants its products to be free from defects in workmanship and material at the time of manufacture. Any products that are found to be defective in workmanship or material, will be repaired, replaced, or credit issued at the option of Gaylee, to the user of our products. Determination as to defective product rests solely with Gaylee. Before using, user shall determine the suitability of the product for its intended use, and user assumes all risk and liability whatsoever in connection therewith. Gaylee shall have no obligation to repair or replace products damaged by misuse, improper operating conditions, products altered or repaired by parties other than Gaylee, or the failure of the user to apply appropriate preventative maintenance or service. No product shall be returned to Gaylee without its prior consent. Product which Gaylee consents to be returned shall be sent freight prepaid. Complete information regarding the complaint must be furnished to Gaylee prior to consent to be returned. Gaylee will not assume responsibility or accept invoices for unauthorized repairs to its products, even though defective. Gaylee makes no warranty as to fitness of its products for specific applications by the user unless Gaylee specifically agrees otherwise in writing after review of the proposed usage, nor does Gaylee make any warranty as to period of service or productivity of its products. THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. Gaylee shall have no liability or responsibility on any claim of any kind, whether in contract, tort or otherwise, for any loss or damage arising out of, connected with, or resulting from the manufacture, sale, deliver or use of any product sold hereunder, in excess of the cost of replacement or repair as provided herein. IN NO EVENT SHALL GAYLEE BE LIABLE FOR ANY SPECIAL, INCIDNETAL, OR CONSEQUENTIAL DAMAGES. Gaylee makes no warranty, express or implied, except as set forth above; and Gaylee neither assumes nor authorizes any other person or entity to assume for it any other obligation or liability in connection with any of its products. All statements, technical information and recommendations herein are based on tests we believe to be reliable, but the accuracy or completeness thereof is not guaranteed.

SPECIAL GAYLEE THIN SAWS AND CUTTERS

If the cutting tool you need is not listed in this catalog, send specifications to GAYLEE for quotation on specially manufactured cutters. See page 22 of this catalog for information needed by Gaylee to properly determine the best cutter for your specific application. Gaylee is the cutting tool industry's leading specialist in design and manufacture of high precision, top quality SOLID CARBIDE SAWS, CARBIDE TIPPED SAWS, MULTIPLE SAW SETS, ARBOR MOUNTED SAW GANGS, THIN MILLING CUTTERS, AND AN ARRAY OF OTHER INDUSTRIAL CUTTERS.

WARNING: ALL CUTTING TOOLS CAN BREAK. USE EYE PROTECTION AND ADEQUATE SAFEGUARDS, SUCH AS MACHINE GUARDS, WHEN OPERATING TOOLS. DO NOT USE DAMAGED OR DULL TOOLS. KEEP MACHINE IN GOOD REPAIR AND IN PROPER WORKING ORDER. ALWAYS USE SAFE OPERATING PROCEDURES. ELIMINATE ANY POSSIBILITY OF OPERATOR CONTACT WITH A MOVING/OPERATING CUTTING TOOL.

GAYLEE



"What's so SPECIAL about these

solid carbide Thin Saws?"



✓ 24-HOUR SHIPMENT of premium quality SOLID CARBIDE "THIN SAWS"

- Diameter Range INCH: 3/4" through 4" METRIC: 20mm through 100mm
- Thickness Range INCH: .008" through .250" METRIC: .20mm through 6.35mm
- Arbor hole sizes INCH: 1/4", 5/16", 3/8", 1/2", 5/8", 7/8", 1"

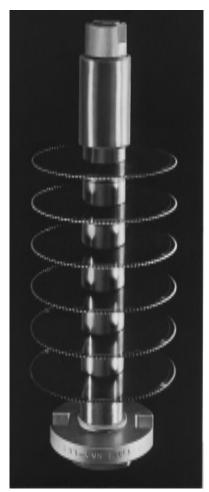
METRIC: 5mm, 8mm, 10mm, 13mm, 16mm, 22mm

• Tolerances - INCH: +.0005"/ -.0000" on ID and thickness; O.D. tolerance = +.005"/-.000" METRIC: +.013mm/ -.0000mm on ID and thickness;

O.D. tolerance = +.13mm/-.000mm

- ✔ Up to 6-pieces in 24-hours.
- ✔ Unsurpassed accuracy and tolerances provide consistent, dependable performance.
- ✓ Standard square tooth configurations available.
- ✓ Technical expertise to solve difficult or unusual sawing, slitting, slotting and cutting operations.
- ✔ Contact our Customer Service Dept. for special applications.
- ✔ GAYLEE SAWS tool designers will be pleased to assist with your specific needs.
- ✓ Inquire about Gaylee Saws carbide-tipped Thin Saws and other cutting tool products.

Multiple Saw Gangs

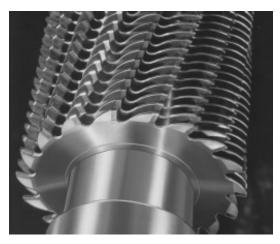


This gang includes six Gaylee solid carbide saws. Specifications are 6" O.D., .050" thickness, 120 teeth per saw, 30 minutes dish each side. Saws are mounted on an arbor with 2 degree spiral keyway and key. High precision, tight-tolerance saw gangs from GAYLEE provide multiple depth cutting, as well as multiple slitting in a single pass. The possibilities are limitless...

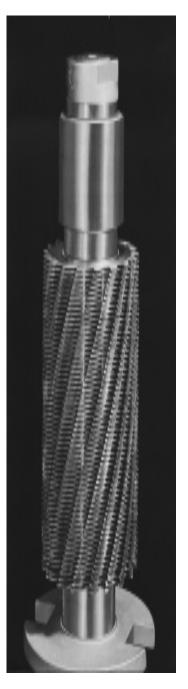


This quill mounted saw gang shows alternate saw diameters for varying depth cutting detail.

- Production costs are fractioned compared to repetitive individual slotting.
- Production capacity and productivity are maximized.
- Consistency and repeatability in your parts production is provided by the precision Gaylee saws built into the saw gang.







Arbors for saw gangs can be designed with a spiral keyway. The faces of the saw teeth are then designed to follow the helix.

This saw gang shows a close-up of saw teeth with faces designed to follow a spiral keyway.

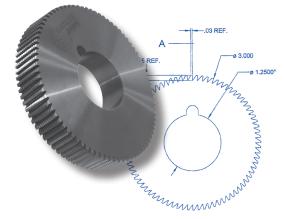


for Multiple Spindle Screw Machine Threading Attachments

For years, you have known Gaylee Saws as a premier manufacturer of high quality carbide and carbide-tipped circular thin saws.

In our continuing effort to help customers trim manufacturing production costs through tooling designed to achieve optimal performance, we are excited to

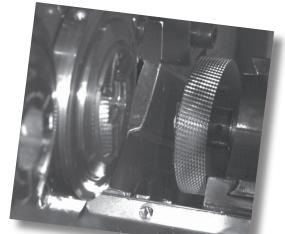
introduce Gaylee thread mills for multiple spindle screw machine threading attachments.



These carbide thread mills are used with threading attachments on your automatic screw machine with direct drive technology from the main housing. This allows the spindle and threading attachment to maintain a 1:1 RPM ratio. By utilizing an easy to install cross-slide mounted threading attachment, you can thread mill parts with incredible accuracy and versatility. These arbor mounted thread mills are designed to cut external threads.

The flexibility and speed of multi-spindle automatics has made them the original 'multitasking' machine tool. And with high performance carbide thread mills from Gaylee Saws, the thread milling function of these multi-spindle automatics is further enhanced with increased throughput and improved thread quality.

In a recent application, an 82-tooth Gaylee thread mill cutting external threads on a steel shaft for an appliance manufacturer, yielded an incredible 76,000 threaded parts before a tooling change was needed.



A Gaylee Saws 82-tooth (fine tooth) thread mill on a multi-spindle screw machine with threading attachment.

Photo courtesy of Tribal Manufacturing, Inc., Marshall, MI

These thread mills can be re-ground or sharpened to a like-new condition (with a smaller diameter). Limitations would be clearance issues of the part being machined. Contact Gaylee Saws for details on re-sharpening.

Gaylee thread milling cutters can be designed for single or double threaded components, as well as for deep threaded parts requiring Acme threads.

Varying thread forms and pitches are available. Contact Gaylee Saws for additional information.



A Gaylee Saws thread mill ready to cut external taper pipe threads on a brass pipe fitting.

Photo courtesy of Tribal Manufacturing, Inc., Marshall, MI

SMART CUT™









An extreme duty drilling, tapping, cutting fluid which is considered environmentally safe. Smart Cut is thick, like honey, and will stick to the tool throughout the cutting operation. Ideal for machining stainless steel, carbon steel, inconel, monel, hastalloy, titanium, aluminum and other alloys and exotic metals. Originally designed as a tapping and drilling fluid, but works well for sawing and other machining/metalcutting operations.

Advantages:

- Increases Productivity
- · Greatly extends tool life
- Reduces torque
- Improves finish and size
- Mild pleasant odor
- Does not contain 1,1,1 Trichlorothane
- Environmentally smart!

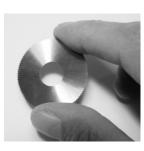
High Speed Steel Saws

The following styles of H.S.S. Saws are now available from Gaylee Saws:

- Specials
- Cermet-Tipped
- Jewelers Slotting Saws
- Straight Tooth Metal Slitting Saws
- Staggered Tooth Metal Slitting Saws
- Concave Slitting Saws
- Screw Slotting Saws







Call, fax or e-mail your H.S.S. saw specifications to Gaylee Saws for quotation. Refer to the inside back cover of this catalog for an application data sheet.



Features and Benefits

SOLID CARBIDE THIN SAWS & CUTTERS

Designed and manufactured to your exact specifications.

- Solid Carbide Saws as THIN as .0020"
- As THICK as 1.000"
- O.D.'s: 1/4" to 7-1/2"
- Tolerances to: +.0005" - .0000"
- Modified and Special Saws available, with tighter tolerances when required.



EXTREME THINNESS

Gaylee solid carbide saws can be manufactured as thin as .0020" (a human hair is about .0040" thick!). This extreme miniaturization is made possible through our numerous years of experience, a dedicated team of saw-makers unparalleled the world over, and our service-oriented approach to meeting your cutting tool requirements. From saws to cutting knives to slitters, slotters and cutters...we're prepared to work with you on your specific application.



→ II ← .006" WIDTH +.0005" -.0000"

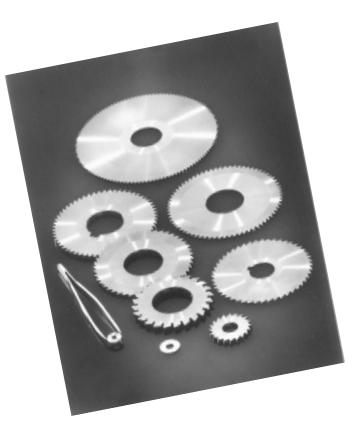


EXTREME PRECISION AND MINIATURIZATION

The miniature saw shown at left has an O.D. of .5000" with 24 precision teeth. GAYLEE takes pride in producing saws with precision and tolerances unexcelled by any other manufacturer. We will provide saws with any degree of precision and tolerance required by your job application.

Technical Data





GAYLEE cutters are manufactured with dish towards the arbor hole to avoid dragging in the cut, thereby reducing side friction. This feature is especially helpful in deep cuts, cutting copper, certain plastics and where parts tend to compress on the saw blade from cutting pressures.

GAYLEE solid carbide saws excel in overcoming the abrasive action encountered in individual and gang slotting of tough steels, cast irons and exotic non-ferrous and non-metallic materials such as fiberglass, epoxies and composites.

Use of solid carbide saws permits a far greater number of teeth in a given saw size than is possible with carbide tipped saws. A greater number of teeth allows reduced chip load, higher speeds and feeds, and improved quality of the finished cut. Titanium Nitride (TiN) coating and other surface treatments can be added to all GAYLEE cutters for superior cutting performance and finish, providing up to 8 times increase in tool life in many materials.

At GAYLEE, cutters with an O.D. of 2" or larger are stocked with standard hubs and keyways to give you the highest performance. Cutters may be ordered without hubs or keyways.

Timely shipment of your tooling is of paramount importance because GAYLEE believes that customer satisfaction is our most important goal. We realize that we can gain the highest degree of customer confidence by manufacturing and shipping only the best saws and cutters available. This dedication to service excellence has earned GAYLEE recognition as "Specialists in Precision" and has established the company as one of the leading precision saw manufacturers in the world.



GAYLEE precision solid carbide saws provide the ultimate combination of:

- Maximum cutting speeds for minimum cost per unit of production and maximum output;
- Maximum tool life (up to 100 times the life of high speed steel), giving dramatic savings in machine downtime, regrinding and tool costs;
- Maximum precision and finish of cut (generally burr-free);
- Maximum precision of saw tolerances; +.0005" / -.0000" on thickness, and +.005" / -.000" outside diameter. (Tighter tolerances are available as specials.)



STANDARD	SAW	ARBOR HOLE		SAW WIDTH		NO OF	
TOLERANCES	DIA.	DIA.	Fraction	Decimal	ММ	TEETH	EDP#
			1/32	0.0313	0.794	18	G15000
SAW DIA:	3/4"	1/4"	3/64	0.0469	1.191	18	G15005
+.005"			1/16	0.0625	1.588	18	G15010
000"				0.0080	0.203	20	G15100
				0.0100	0.254	20	G15105
ARBOR HOLE				0.0120	0.305	20	G15110
SIZE:				0.0140	0.356	20	G15115
+.0005"			1/64	0.0156	0.397	20	G15120
				0.0180	0.457	20	G15125
0000"				0.0200	0.508	20	G15130
				0.0230	0.584	20	G15135
SIDE RUN-OUT				0.0250	0.635	20	G15140
LESS THAN				0.0230	0.035	20	G15140 G15145
.0005"							
			4/00	0.0300	0.762	20	G15150
THICKNESS:			1/32	0.0313	0.794	20	G15155
+.0005"				0.0350	0.889	20	G15160
0000"				0.0394	1.000	20	G15165
				0.0400	1.016	20	G15170
			3/64	0.0469	1.191	20	G15175
				0.0500	1.270	20	G15180
				0.0510	1.295	20	G15185
				0.0600	1.524	20	G15190
			1/16	0.0625	1.588	20	G15195
				0.0700	1.778	20	G15200
			5/64	0.0781	1.984	20	G15205
				0.0787	2.000	20	G15210
				0.0800	2.032	20	G15215
				0.0900	2.286	20	G15220
	1"	3/8"	3/32	0.0938	2.381	20	G15225
			0,02	0.1000	2.540	20	G15230
				0.1000	2.794	20	G15235
				0.1100	3.000	20	G15233
			1/0	0.1200	3.048	20	G15245
			1/8	0.1250	3.175	20	G15250
				0.1300	3.302	20	G15255
				0.1400	3.556	20	G15260
				0.1500	3.810	20	G15265
			5/32	0.1563	3.969	20	G15270
				0.1575	4.000	20	G15275
				0.1600	4.064	20	G15280
				0.1700	4.318	20	G15285
				0.1800	4.572	20	G15290
			3/16	0.1875	4.763	20	G15295
				0.1900	4.826	20	G15300
				0.1969	5.000	20	G15305
				0.2000	5.080	20	G15310
				0.2000	5.334	20	G15315
			7/32	0.2100	5.556	20	G15315 G15320
			1132				
				0.2200	5.588	20	G15325
				0.2300	5.842	20	G15330
				0.2362	6.000	20	G15335
				0.2400	6.096	20	G15340
			1/4	0.2500	6.350	20	G15345



SAW	ARBOR HOLE		SAW WIDTH		NO OF		STANDARD
DIA.	DIA.	Fraction	Decimal	MM	TEETH	EDP#	TOLERANCES
		1/32	0.0313	0.794	24	G15400	
		3/64	0.0469	1.191	24	G15405	SAW DIA:
	5/16"	1/16	0.0625	1.588	24	G15410	+.005"
		3/32	0.0938	2.381	24	G15415	000"
1 1/4"		1/8	0.1250	3.175	24	G15420	
1 1/4		1/32	0.0313	0.794	24	G15450	ARBOR HOLE
		3/64	0.0469	1.191	24	G15455	SIZE:
	1/2"	1/16	0.0625	1.588	24	G15460	+.0005"
		3/32	0.0938	2.381	24	G15465	0000"
		1/8	0.1250	3.175	24	G15470	
		1/32	0.0313	0.794	32	G15500	SIDE RUN-OUT
		3/64	0.0469	1.191	32	G15505	LESS THAN
1 1/2"	1/2"	1/16	0.0625	1.588	32	G15510	.0005"
		3/32	0.0938	2.381	32	G15515	
		1/8	0.1250	3.175	32	G15520	THICKNESS:
		1/32	0.0313	0.794	36	G15600	+.0005"
	1/2"	3/64	0.0469	1.191	36	G15605	0000"
		1/16	0.0625	1.588	36	G15610	0000
		1/32	0.0313	0.794	36	G15700	
	5/8"	3/64	0.0469	1.191	36	G15705	
1 3/4"		1/16	0.0625	1.588	36	G15710	
		1/32	0.0313	0.794	36	G15800	
		3/64	0.0469	1.191	36	G15805	
	7/8"	1/16	0.0625	1.588	36	G15810	
	7/8"	3/32	0.0938	2.381	36	G15815	
		1/8	0.1250	3.175	36	G15820	
			0.0080	0.203	36	G16000	
			0.0100	0.254	36	G16005	
			0.0120	0.305	36	G16010	
			0.0140	0.356	36	G16015	
		1/64	0.0156	0.397	36	G16020	
			0.0180	0.457	36	G16025	
	·		0.0200	0.508	36	G16030	
			0.0230	0.584	36	G16035	
			0.0250	0.635	36	G16040	
			0.0280	0.711	36	G16045	
			0.0300	0.762	36	G16050	
		1/32	0.0313	0.794	36	G16055	
			0.0350	0.889	36	G16060	
			0.0394	1.000	36	G16065	
2"	1/2"		0.0400	1.016	36	G16070	
		3/64	0.0469	1.191	36	G16075	
		0/04	0.0500	1.270	36	G16080	
			0.0510	1.295	36	G16085	
			0.0600	1.524	36	G16090	
		1/16	0.0625	1.588	36	G16095	
		1/10	0.0700	1.778	36	G16100	
		5/64	0.0781	1.984	36	G16105	
		5/04	0.0781	2.000	36	G16105 G16110	
			0.0800	2.032	36	G16115	
		0/00	0.0900	2.286	36	G16120	
		3/32	0.0938	2.381	36	G16125	
			0.1000	2.540	36	G16130	
			0.1100	2.794	36	G16135	



STANDARD SAW TOLERANCES DIA. SAW DIA: +.005" +.000" ARBOR HOLE SIZE: +.0005" 000" SIDE RUN-OUT LESS THAN .0005" THICKNESS: +.0005" +.0005" 0000" 2"	ARBOR HOLE DIA. 1/2"	Fraction 1/8 5/32 3/16	Decimal 0.1181 0.1200 0.1250 0.1300 0.1400 0.1563 0.1575 0.1600 0.1700 0.1800	MM 3.000 3.048 3.175 3.302 3.556 3.810 3.969 4.000 4.064 4.318	NO OF TEETH 36 36 36 36 36 36 36 36 36 36 36 36 36	EDP# G16140 G16145 G16150 G16155 G16160 G16165 G16170 G16175
+.005" 000" ARBOR HOLE SIZE: +.0005" 0000" SIDE RUN-OUT LESS THAN .0005" THICKNESS: +.0005"	1/2"	5/32	0.1200 0.1250 0.1300 0.1400 0.1500 0.1563 0.1575 0.1600 0.1700	3.048 3.175 3.302 3.556 3.810 3.969 4.000 4.064	36 36 36 36 36 36 36 36 36	G16145 G16150 G16155 G16160 G16165 G16170 G16175
+.005" 000" ARBOR HOLE SIZE: +.0005" 0000" SIDE RUN-OUT LESS THAN .0005" THICKNESS: +.0005"	1/2"	5/32	0.1250 0.1300 0.1400 0.1500 0.1563 0.1575 0.1600 0.1700	3.175 3.302 3.556 3.810 3.969 4.000 4.064	36 36 36 36 36 36 36 36	G16150 G16155 G16160 G16165 G16170 G16175
+.005" 000" ARBOR HOLE SIZE: +.0005" 0000" SIDE RUN-OUT LESS THAN .0005" THICKNESS: +.0005"	1/2"	5/32	0.1300 0.1400 0.1500 0.1563 0.1575 0.1600 0.1700	3.302 3.556 3.810 3.969 4.000 4.064	36 36 36 36 36 36 36	G16155 G16160 G16165 G16170 G16175
000" ARBOR HOLE SIZE: +.0005" 0000" SIDE RUN-OUT LESS THAN .0005" THICKNESS: +.0005"	1/2"		0.1400 0.1500 0.1563 0.1575 0.1600 0.1700	3.302 3.556 3.810 3.969 4.000 4.064	36 36 36 36 36 36 36	G16155 G16160 G16165 G16170 G16175
ARBOR HOLE SIZE: +.0005" 0000" SIDE RUN-OUT LESS THAN .0005" THICKNESS: +.0005"	1/2"		0.1400 0.1500 0.1563 0.1575 0.1600 0.1700	3.556 3.810 3.969 4.000 4.064	36 36 36 36 36 36	G16165 G16170 G16175
SIZE: +.0005" 0000" SIDE RUN-OUT LESS THAN .0005" THICKNESS: +.0005"	1/2"		0.1500 0.1563 0.1575 0.1600 0.1700	3.810 3.969 4.000 4.064	36 36 36 36	G16165 G16170 G16175
SIZE: +.0005" 0000" SIDE RUN-OUT LESS THAN .0005" THICKNESS: +.0005"	1/2"		0.1563 0.1575 0.1600 0.1700	3.969 4.000 4.064	36 36 36	G16170 G16175
+.0005" 0000" SIDE RUN-OUT LESS THAN .0005" THICKNESS: +.0005"	1/2"		0.1575 0.1600 0.1700	4.000 4.064	36 36	G16175
0000" SIDE RUN-OUT LESS THAN .0005" THICKNESS: +.0005"	1/2"	3/16	0.1600 0.1700	4.064	36	
SIDE RUN-OUT LESS THAN .0005" THICKNESS: +.0005"	1/2"	3/16	0.1700			G16180
LESS THAN .0005" THICKNESS: +.0005"	1/2"	3/16		4.010	36	G16185
LESS THAN .0005" THICKNESS: +.0005"	1/2"	3/16	0.1000	4.572	36	G16190
.0005" THICKNESS: +.0005"		0/10	0.1875	4.763	36	G16195
THICKNESS: +.0005"			0.1900	4.826	36	G16200
+.0005"		I	0.1900	4.820 5.000	36	G16205
+.0005"						
0000"			0.2000	5.080	36	G16210
0000" 2 "		7/00	0.2100	5.334	36 26	G16215
		7/32	0.2188	5.556	36	G16220
			0.2200	5.588	36	G16225
			0.2300	5.842	36	G16230
			0.2362	6.000	36	G16235
			0.2400	6.096	36	G16240
		1/4	0.2500	6.350	36	G16245
		1/16	0.0625	1.588	24	G20536
		3/32	0.0938	2.381	24	G20537
		1/8	0.1250	3.175	24	G20538
		1/32	0.0313	0.794	36	G16500
		3/64	0.0469	1.191	36	G16505
		1/16	0.0625	1.588	36	G16510
	1"	3/32	0.0938	2.381	36	G16515
		1/8	0.1250	3.175	36	G16520
		3/16	0.1875	4.763	36	G16525
		1/4	0.2500	6.350	36	G16530
		1/16	0.0625	1.588	48	G20539
		3/32	0.0938	2.381	48	G20540
		1/8	0.1250	3.175	48	G20541
		1/32	0.0313	0.794	40	G17000
		3/64	0.0469	1.191	40	G17005
		1/16	0.0409	1.588	40	G17003
	1/2"	3/32	0.0025	2.381	40	G17010 G17015
		3/32 1/8	0.0938	3.175	40 40	G17015 G17020
		5/32	0.1563	3.969	40	G17025
		1/16	0.0625	1.588	28	G20542
		3/32	0.0938	2.381	28	G20543
2 1/4"	5/8"	1/8	0.1250	3.175	28	G20544
		1/16	0.0625	1.588	56	G20545
		3/32	0.0938	2.381	56	G20546
		1/8	0.1250	3.175	56	G20547
		1/32	0.0313	0.794	40	G17500
		3/64	0.0469	1.191	40	G17505
	1"	1/16	0.0625	1.588	40	G17510
		3/32	0.0938	2.381	40	G17515
		1/8	0.1250	3.175	40	G17520
		5/32	0.1563	3.969	40	G17525

Solid Carbide Thin Saws



SAW	ARBOR HOLE		SAW WIDTH		NO OF		
DIA.	DIA.	Fraction	Decimal	ММ	TEETH	EDP#	<u>Т</u>
			0.0080	0.203	48	G18000	
			0.0100	0.254	48	G18005	
			0.0120	0.305	48	G18010	
			0.0140	0.356	48	G18015	
		1/64	0.0156	0.397	48	G18020	
			0.0180	0.457	48	G18025	A
			0.0200	0.508	48	G18030	
			0.0230	0.584	48	G18035	
			0.0250	0.635	48	G18040	
			0.0280	0.711	48	G18045	
			0.0300	0.762	48	G18050	
		1/32	0.0313	0.794	48	G18055	S
		1702	0.0350	0.889	48	G18060	
			0.0394	1.000	48	G18065	
			0.0394	1.000	48	G18005 G18070	
		2/64					
		3/64	0.0469	1.191	48	G18075	
			0.0500	1.270	48	G18080	
			0.0510	1.295	48	G18085	
			0.0600	1.524	48	G18090	
		1/16	0.0625	1.588	48	G18095	
			0.0700	1.778	48	G18100	
		5/64	0.0781	1.984	48	G18105	
			0.0787	2.000	48	G18110	
			0.0800	2.032	48	G18115	
	5/8"		0.0900	2.286	48	G18120	
	5/0	3/32	0.0938	2.381	48	G18125	
0 4 /01			0.1000	2.540	48	G18130	
2 1/2"			0.1100	2.794	48	G18135	
			0.1181	3.000	48	G18140	
			0.1200	3.048	48	G18145	
		1/8	0.1250	3.175	48	G18150	
			0.1300	3.302	48	G18155	
			0.1400	3.556	48	G18160	
			0.1500	3.810	48	G18165	
		5/32			48		
		0102	0.1563	3.969		G18170	
			0.1575	4.000	48	G18175	
			0.1600	4.064	48	G18180	
			0.1700	4.318	48	G18185	
		0// -	0.1800	4.572	48	G18190	
		3/16	0.1875	4.763	48	G18195	
			0.1900	4.826	48	G18200	
			0.1969	5.000	48	G18205	
			0.2000	5.080	48	G18210	
			0.2100	5.334	48	G18215	
		7/32	0.2188	5.556	48	G18220	
			0.2200	5.588	48	G18225	
			0.2300	5.842	48	G18230	
			0.2362	6.000	48	G18235	
			0.2400	6.096	48	G18240	
		1/4	0.2500	6.350	48	G18245	
		1/16	0.0625	1.588	28	G20548	
		3/32	0.0025	2.381	28	G20548 G20549	
	1"						
		1/8 5/22	0.1250	3.175	28	G20550	
		5/32	0.1563	3.969	28	G20551	

STANDARD TOLERANCES

SAW DIA: +.005" -.000"

ARBOR HOLE SIZE: +.0005" -.0000"

SIDE RUN-OUT LESS THAN .0005"

> THICKNESS: +.0005" -.0000"



STANDARD	SAW	ARBOR HOLE		SAW WIDTH		NO OF	
TOLERANCES	DIA.	DIA.	Fraction	Decimal	ММ	TEETH	EDP#
			1/32	0.0313	0.794	48	G18500
SAW DIA:			3/64	0.0469	1.191	48	G18505
+.005"			1/16	0.0625	1.588	48	G18510
000"			3/32	0.0938	2.381	48	G18515
.000			1/8	0.1250	3.175	48	G18520
ARBOR HOLE	0.4/01		5/32	0.1563	3.969	48	G18525
SIZE:	2 1/2"	1"	3/16	0.1875	4.763	48	G18530
			1/4	0.2500	6.350	48	G18535
+.0005"			1/16	0.0625	1.588	56	G20552
0000"			3/32	0.0938	2.381	56	G20553
			1/8	0.0950	3.175	56	G20555 G20554
SIDE RUN-OUT			5/32		3.969		G20554 G20555
LESS THAN				0.1563		56	
.0005"			1/16	0.0625	1.588	30	G20556
			3/32	0.0938	2.381	30	G20557
THICKNESS:			1/8	0.1250	3.175	30	G20558
+.0005"			5/32	0.1563	3.969	30	G20559
0000"				0.0080	0.203	60	G19000
				0.0100	0.254	60	G19005
				0.0120	0.305	60	G19010
				0.0140	0.356	60	G19015
			1/64	0.0156	0.397	60	G19020
				0.0180	0.457	60	G19025
				0.0200	0.508	60	G19030
				0.0230	0.584	60	G19035
				0.0250	0.635	60	G19040
				0.0280	0.711	60	G19045
				0.0300	0.762	60	G19050
			1/32	0.0313	0.794	60	G19055
				0.0350	0.889	60	G19060
				0.0394	1.000	60	G19065
				0.0394	1.000	60	G19005 G19070
			2/04				
	0.0/4	4.11	3/64	0.0469	1.191	60	G19075
	2 3/4"	1"		0.0500	1.270	60	G19080
				0.0510	1.295	60	G19085
				0.0600	1.524	60	G19090
			1/16	0.0625	1.588	60	G19095
				0.0700	1.778	60	G19100
			5/64	0.0781	1.984	60	G19105
				0.0787	2.000	60	G19110
				0.0800	2.032	60	G19115
				0.0900	2.286	60	G19120
			3/32	0.0938	2.381	60	G19125
				0.1000	2.540	60	G19130
				0.1100	2.794	60	G19135
				0.1181	3.000	60	G19140
				0.1200	3.048	60	G19145
			1/8	0.1200	3.175	60	G19145 G19150
			170	0.1250	3.302	60	G19150 G19155
				0.1400	3.556	60 60	G19160
			E 100	0.1500	3.810	60	G19165
			5/32	0.1563	3.969	60	G19170
				0.1575	4.000	60	G19175
	1			0.1600	4.064	60	G19180



SAW	ARBOR HOLE		SAW WIDTH		NO OF		STANDARD
DIA.	DIA.	Fraction	Decimal	ММ	TEETH	EDP#	TOLERANCES
			0.1700	4.318	60	G19185	
			0.1800	4.572	60	G19190	SAW DIA:
		3/16	0.1875	4.763	60	G19195	+.005"
			0.1900	4.826	60	G19200	000"
			0.1969	5.000	60	G19205	
			0.2000	5.080	60	G19210	ARBOR HOLE
2 3/4"	1"		0.2100	5.334	60	G19215	SIZE:
		7/32	0.2188	5.556	60	G19220	+.0005"
			0.2200	5.588	60	G19225	0000"
			0.2300	5.842	60	G19230	
			0.2362	6.000	60	G19235	SIDE RUN-OUT
			0.2400	6.096	60	G19240	LESS THAN
		1/4	0.2500	6.350	60	G19245	.0005"
		1/16	0.0625	1.588	30	G20560	.0000
		3/32	0.0938	2.381	30	G20561	THICKNESS:
		1/8	0.1250	3.175	30	G20562	+.0005"
		5/32	0.1563	3.969	30	G20563	0000"
		1/32	0.0313	0.794	60	G20000	0000
3"	1"	3/64	0.0469	1.191	60	G20005	
3		1/16	0.0625	1.588	60	G20010	
		3/32	0.0938	2.381	60	G20015	
		1/8	0.1250	3.175	60	G20020	
		5/32	0.1563	3.969	60	G20025	
		3/16	0.1875	4.763	60	G20030	
		1/4	0.2500	6.350	60	G20035	
		1/16	0.0625	1.588	36	G20564	
		3/32	0.0938	2.381	36	G20565	
		1/8	0.1250	3.175	36	G20566	
		5/32	0.1563	3.969	36	G20567	
		1/4	0.2500	6.350	36	G20568	
		1/32	0.0313	0.794	72	G20500	
4"	1"	3/64	0.0469	1.191	72	G20505	
		1/16	0.0625	1.588	72	G20510	
		3/32	0.0938	2.381	72	G20515	
		1/8	0.1250	3.175	72	G20520	
		5/32	0.1563	3.969	72	G20525	
		3/16	0.1875	4.763	72	G20530	
		1/4	0.2500	6.350	72	G20535	

Your Source for High Precision Solid Carbide and Carbide-Tipped Thin Saws and Cutters!





Features and Benefits

CARBIDE-TIPPED THIN SAWS & CUTTERS

Designed and manufactured to your exact specifications.

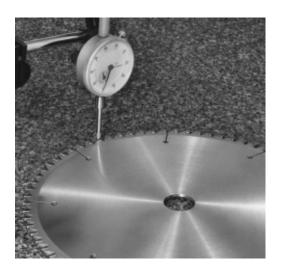
- · Carbide Tipped Saws as THIN as .030"
- As THICK as 1.000"
- O.D.'s: 1-1/2" to 10"
- Tolerances to: +.0010"

- .0000"

• Modified and Special Saws available, with tighter tolerances when required.

UNPARALLELED PRECISION AND QUALITY CONTROL

Thorough inspection and quality control at every step of production insure that every GAYLEE saw is absolutely true to your specifications. These same standards are applied to repair and resharpen your GAYLEE saws. Our unmatched reputation has been built upon years of dedication to superior quality tooling...a reputation that's used as a standard to which others are measured.



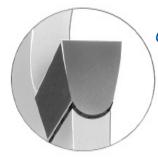


THIN SAW WITH INTEGRAL SPACER FOR PRECISION GANG SET-UPS

For precision gang set-ups, specify the GAYLEE "Thin Saw" with integral spacer. This spacer is actually part of the saw itself...*allowing no room for dirt or chips to accumulate.* Made to your specific requirements for the utmost precision spacing in gang sawing, slotting, and slitting.

Technical Data





CIRCULAR SEAT ADDS STRENGTH TO TIP BRAZE

The Gaylee circular seat provides mechanical strength, as well as a greater brazing area for the carbide tip, which insures it being held securely to the steel body.

SAW MODIFICATIONS

Gaylee can modify standard carbide-tipped saws and cutters to meet many 'special' job cutting requirements. Most modified standard cutters can be shipped within 48 hours...much sooner than the time required to manufacture full special saws and cutters.

Modified standard cutters usually offer substantial cost savings over specialty manufactured tools. Pricing on modified standard cutters is based on quantities and the degree of modifications required. Call GAYLEE to discuss the many modifications possible, depending on your application. **CUTTING WIDTH OR THICKNESS** can be adjusted to the exact dimension needed.

• General Purpose and Stainless Steel Cutting saws and cutters can be modified to any exact width between .040" and .375". Other carbide tipped cutters in this catalog can be modified to most widths within the same range.

• METRIC widths can be provided between: 1.0mm and 9.5mm

TIGHTER TOLERANCES

• Although GAYLEE Standard Carbide Tipped cutters already have the tightest tolerances available "off-the-shelf", even tighter tolerances are available on a modified standard basis (i.e. thickness tolerance: +/- .0001). Tolerances may vary depending on O.D. size.

• MATCHED OUTSIDE DIAMETERS can be provided so that a set of cutters used together will all cut to the exact same depth.

CARBIDE TIPPED TOOTH FORMS (PROFILE GROUND)

All GAYLEE Standard Carbide Tipped Thin Saws are straight tooth (i.e. square tooth) off-the-shelf. However, a wide variety of profile ground modified tooth forms can be provided, for example:





STANDARD STRAIGHT (SQUARE) TOOTH

ALTERNATE CHAMFER (EVERY OTHER TOOTH)

TRIPLE

TOOTH



RADIUS

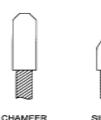
BOTH

SIDES



FULL

RADIUS



BOTH

SIDES

SINGLE



Carbide-Tipped Thin Saws

Coarse Tooth

These cutters are designed for slotting, milling, and cut-off applications. Tool geometry is designed to be suitable for work materials listed. All cutters have optimal dish and side clearance (side runout) for free-cutting action with reduced friction. Gaylee carbide tipped saws allow maximum durability due to the hardened tool steel saw body that supports the top-grade carbide inserts. Economical cutters for roughing and short-run cutting of cast iron, non-ferrous metals, and non-metallics.

Note: Coarse-tooth cutters are the lowest priced carbide tipped tools made by Gaylee. Cost savings are acheived entirely by use of a minimum number of teeth. These cutters are manufactured with the same premium quality materials and craftsmanship found in our Standard Tooth Cutters. Coarse-tooth cutters on this page are the most economical tools in short-run applications. For improved surface finish, longer tool life, and more economical long-run performance, we recommend the General Purpose Standard Carbide Tipped Thin Saws.

STANDARD	SAW	ARBOR HOLE		SAW WIDTH			
TOLERANCES	DIA.	DIA.	Fraction	Decimal	MM	NO. OF TEETH	EDP#
			1/4	0.2500	6.350	4	G12000
SAW DIA:	3"	1"	5/16	0.3125	7.9375	4	G12005
+.015"			3/8	0.3750	9.525	4	G12010
000"			3/32	0.0938	2.381	6	G12015
000			1/8	0.1250	3.175	6	G12020
ARBOR HOLE		1"	3/16	0.1875	4.763	6	G12025
SIZE:	4"	•	1/4	0.2500	6.350	6	G12030
			5/16	0.3125	7.9375	6	G12035
+.0005"			3/8	0.3750	9.525	6	G12040
0000"		1.25"	3/8	0.3750	9.525	6	G12045
	6"	1.25"	1/8	0.1250	3.175	8	G12050
SIDE RUN-OUT	8"	1.25"	1/8	0.1250	3.175	10	G12055
LESS THAN .0005" THICKNESS:			ТООТН СИ		USE ON CA	AST IRON	
.0005" THICKNESS:	SAW	ARBOR HOLE		SAW WIDTH			500#
.0005" THICKNESS: +.0010"	SAW DIA.		Fraction	SAW WIDTH Decimal	ММ	NO. OF TEETH	EDP#
.0005" THICKNESS:		ARBOR HOLE DIA.	Fraction 1/4	SAW WIDTH Decimal 0.2500	<u>мм</u> 6.350	NO. OF TEETH	G12200
.0005" THICKNESS: +.0010"	DIA.	ARBOR HOLE	Fraction 1/4 5/16	SAW WIDTH Decimal 0.2500 0.3125	<u>мм</u> 6.350 7.9375	NO. OF TEETH	G12200 G12205
.0005" THICKNESS: +.0010"	DIA.	ARBOR HOLE DIA.	Fraction 1/4	SAW WIDTH Decimal 0.2500 0.3125 0.3750	<u>мм</u> 6.350	NO. OF TEETH	G12200 G12205 G12210
.0005" THICKNESS: +.0010"	DIA.	ARBOR HOLE DIA.	Fraction 1/4 5/16 3/8	SAW WIDTH Decimal 0.2500 0.3125	<u>мм</u> 6.350 7.9375 9.525	NO. OF TEETH 6 6 6	G12200 G12205
.0005" THICKNESS: +.0010"	dia. 3"	ARBOR HOLE DIA.	Fraction 1/4 5/16 3/8 1/8	SAW WIDTH Decimal 0.2500 0.3125 0.3750 0.1250	<u>мм</u> 6.350 7.9375 9.525 3.175	NO. OF TEETH 6 6 6 8	G12200 G12205 G12210 G12215 G12220
.0005" THICKNESS: +.0010"	DIA.	ARBOR HOLE DIA. 1"	Fraction 1/4 5/16 3/8 1/8 3/16	SAW WIDTH Decimal 0.2500 0.3125 0.3750 0.1250 0.1875	<u>мм</u> 6.350 7.9375 9.525 3.175 4.763	NO. OF TEETH 6 6 6 8 8 8	G12200 G12205 G12210 G12215 G12220 G12225
.0005" THICKNESS: +.0010"	dia. 3"	ARBOR HOLE DIA. 1"	Fraction 1/4 5/16 3/8 1/8 3/16 1/4	SAW WIDTH Decimal 0.2500 0.3125 0.3750 0.1250 0.1875 0.2500	<u>мм</u> 6.350 7.9375 9.525 3.175 4.763 6.350	NO. OF TEETH 6 6 6 8 8 8 8 8	G12200 G12205 G12210 G12215 G12220 G12225 G12220 G12230
.0005" THICKNESS: +.0010"	dia. 3"	ARBOR HOLE DIA. 1"	Fraction 1/4 5/16 3/8 1/8 3/16 1/4 5/16	SAW WIDTH Decimal 0.2500 0.3125 0.3750 0.1250 0.1875 0.2500 0.3125	MM 6.350 7.9375 9.525 3.175 4.763 6.350 7.9375	NO. OF TEETH 6 6 6 8 8 8 8 8 8 8 8 8	G12200 G12205 G12210 G12215 G12220 G12225 G12230 G12235
.0005" THICKNESS: +.0010"	dia. 3"	ARBOR HOLE DIA. 1"	Fraction 1/4 5/16 3/8 1/8 3/16 1/4 5/16 3/8	SAW WIDTH Decimal 0.2500 0.3125 0.3750 0.1250 0.1875 0.2500 0.3125 0.3750	мм 6.350 7.9375 9.525 3.175 4.763 6.350 7.9375 9.525	NO. OF TEETH 6 6 6 8 8 8 8 8 8 8 8 8 8 8 8 8	G12200 G12205 G12210 G12215 G12220 G12225 G12230 G12235 G12240
.0005" THICKNESS: +.0010"	dia. 3"	ARBOR HOLE DIA. 1"	Fraction 1/4 5/16 3/8 1/8 3/16 1/4 5/16 3/8 3/8	SAW WIDTH Decimal 0.2500 0.3125 0.3750 0.1250 0.1875 0.2500 0.3125 0.3750 0.3750	<u>мм</u> 6.350 7.9375 9.525 3.175 4.763 6.350 7.9375 9.525 9.525	NO. OF TEETH 6 6 6 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8	G12200 G12205 G12215 G12215 G12225 G12225 G12235 G12235 G12245
.0005" THICKNESS: +.0010"	dia. 3" 4"	ARBOR HOLE DIA. 1" 1" 1.25"	Fraction 1/4 5/16 3/8 1/8 3/16 1/4 5/16 3/8 3/8 3/8 1/8	SAW WIDTH Decimal 0.2500 0.3125 0.3750 0.1250 0.1875 0.2500 0.3125 0.3750 0.3750 0.3750 0.3750 0.3750 0.3750 0.1250	MM 6.350 7.9375 9.525 3.175 4.763 6.350 7.9375 9.525 9.525 3.175	NO. OF TEETH 6 6 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 12	G12200 G12205 G12215 G12225 G12225 G12235 G12235 G12245 G12245 G12250
.0005" THICKNESS: +.0010"	dia. 3" 4"	ARBOR HOLE DIA. 1" 1" 1.25"	Fraction 1/4 5/16 3/8 1/8 3/16 1/4 5/16 3/8 3/8 1/8 3/16	SAW WIDTH Decimal 0.2500 0.3125 0.3750 0.1250 0.1875 0.2500 0.3125 0.3750 0.3125 0.3750 0.3750 0.3750 0.3750 0.1250 0.1250 0.1250 0.1875	<u>мм</u> 6.350 7.9375 9.525 3.175 4.763 6.350 7.9375 9.525 9.525 3.175 4.763	NO. OF TEETH	G12200 G12205 G12210 G12215

COARSE TOOTH CUTTERS FOR USE ON NON-FERROUS MATERIALS Aluminum • Copper • Plastics • Hard Rubber • Bakelite • Fiber

General Purpose

These Gaylee General Purpose standard carbide tipped saws are ideal for use on: Cast Iron

- Malleable Iron
- Aluminum
- Brass
- Plastics
- Other Non-Ferrous Metals Bakelite

Copper

- Hard Rubber
- Non-Metallics
- Composites
- Multi-Purpose Use



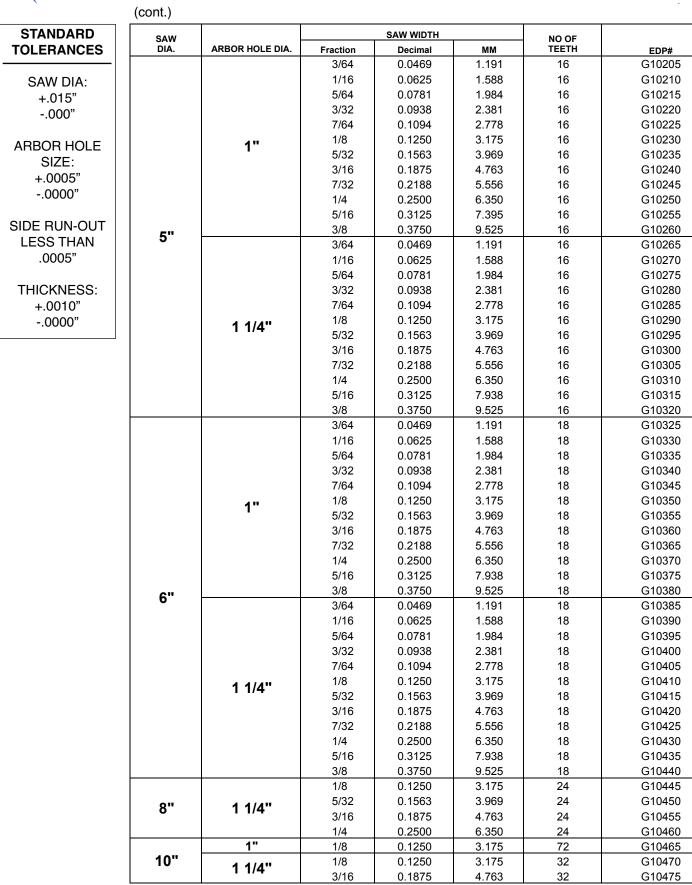
These cutters are designed for slitting, slotting, milling, and cut-off applications. These are precision cutting tools of the highest quality construction. Contact Gaylee with your requirements.

			SAW WIDTH		NO OF		STANDARD
SAW DIA.	ARBOR HOLE DIA.	Fraction	Decimal	ММ	TEETH	EDP#	TOLERANCES
		3/64	0.0469	1.191	12	G10000	
		1/16	0.0625	1.588	12	G10005	SAW DIA:
		5/64	0.0781	1.984	12	G10010	+.015"
		3/32	0.0938	2.381	12	G10015	000"
		7/64	0.1094	2.778	12	G10020	000
	1"	1/8	0.1250	3.175	12	G10025	ARBOR HOLE
3"	1	5/32	0.1563	3.969	12	G10030	
		3/16	0.1875	4.763	12	G10035	SIZE:
		7/32	0.2188	5.556	12	G10040	+.0005"
		1/4	0.2500	6.350	12	G10045	0000"
		5/16	0.3125	7.938	12	G10050	
		3/8	0.3750	9.525	12	G10055	SIDE RUN-OUT
	1.25"	1/8	0.1250	3.175	12	G10060	LESS THAN
	5/8"	1/16	0.0625	1.588	14	G10075	.0005"
		3/64	0.0469	1.191	14	G10065	
		3/64	0.0469	1.191	30	G10070	THICKNESS:
		1/16	0.0625	1.588	14	G10080	+.0010"
		1/16	0.0625	1.588	20	G10085	0000"
		5/64	0.0781	1.984	14	G10090	
		3/32	0.0938	2.381	14	G10095	
		7/64	0.1094	2.778	14	G10100	
	1"	1/8	0.1250	3.175	14	G10105	
		1/8	0.1250	3.175	20	G10110	
		5/32	0.1563	3.969	14	G10115	
		3/16	0.1875	4.763	14	G10120	
		7/32	0.2188	5.556	14	G10125	
4"		1/4	0.2500	6.350	14	G10130	
4		5/16	0.3125	7.938	14	G10135	
		3/8	0.3750	9.525	14	G10140	
		3/64	0.0469	1.191	14	G10145	
		1/16	0.0625	1.588	14	G10150	
		5/64	0.0781	1.984	14	G10155	
		3/32	0.0938	2.381	14	G10160	
		7/64	0.1094	2.778	14	G10165	
	4 4/4"	1/8	0.1250	3.175	14	G10170	
	1 1/4"	5/32	0.1563	3.969	14	G10175	
		3/16	0.1875	4.763	14	G10180	
		7/32	0.2188	5.556	14	G10185	
		1/4	0.2500	6.350	14	G10190	
		5/16	0.3125	7.938	14	G10195	
		3/8	0.3750	9.525	14	G10200	

(cont.)



General Purpose





Stainless Steel Cutting



These GAYLEE Stainless Steel Cutting carbide tipped saws are ideal for use on:

 Stainless Steels - AISI Types 200-350 (Austenitic Stainless Steels)
 Note: For stainless steels other than AISI Types 200 through 350, we recommend using Steel Cut-

ting saws and cutters.

These cutters are designed for slitting, slotting, milling, and cut-off applications. Tool geometry is designed for work materials of Stainless Steel AISI Types 200 through 350. All cutters have both dish and side clearance for free-cutting action. Carbide tips are the best quality and grade of carbide.

					COA	RSE TOOTH	STD	. ТООТН	
SAW	ARBOR HOLE		SAW WIDTH		NO OF		NO OF		STANDARD
DIA.	DIA.	Fraction	Decimal	MM	TEETH	EDP#	TEETH	EDP#	TOLERANCES
		3/64	0.0469	1.191			12	G10500	
		1/16	0.0625	1.588			12	G10505	SAW DIA:
		5/64	0.0781	1.984			12	G10510	+.015"
		3/32	0.0938	2.381	8	G12400	12	G10515	000"
		7/64	0.1094	2.778			12	G10520	
	1"	1/8	0.1250	3.175	8	G12405	12	G10525	ARBOR HOLE
3"	•	5/32	0.1563	3.969			12	G10530	SIZE:
		3/16	0.1875	4.763	8	G12410	12	G10535	+.0005"
		7/32	0.2188	5.556			12	G10540	0000"
		1/4	0.2500	6.350	8	G12415	12	G10545	
		5/16	0.3125	7.9375	8	G12420	12	G10550	SIDE RUN-OUT
		3/8	0.3750	9.525	8	G12425	12	G10555	LESS THAN
	1.25"	1/8	0.1250	3.175			12	G10560	.0005"
	5/8"625"	1/16	0.0625	1.588			14	G10575	THICKNESS:
		3/64	0.0469	1.191			14	G10565	+.0010"
		3/64	0.0469	1.191			30	G10570	0000"
		1/16	0.0625	1.588			14	G10580	0000
		1/16	0.0625	1.588			20	G10585	
		5/64	0.0781	1.984			14	G10590	
		3/32	0.0938	2.381	10	G12430	14	G10595	
		7/64	0.1094	2.7781		0.2.00	14	G10600	
	1"	1/8	0.1250	3.175	10	G12435	14	G10605	
	•	1/8	0.1250	3.175	10	012100	20	G10610	
		5/32	0.1563	3.969			14	G10615	
		3/16	0.1875	4.763	10	G12440	14	G10620	
		7/32	0.2188	5.556	10	012110	14	G10625	
		1/4	0.2500	6.350	10	G12445	14	G10630	
4"		5/16	0.3125	7.9375	10	G12450	14	G10635	
		3/8	0.3750	9.525	10	G12455	14	G10640	
		3/64	0.0469	1.191	10	012400	14	G10645	
		3/04 1/16	0.0409	1.588			14	G10650	
		5/64					14		
			0.0781	1.984				G10655	
		3/32	0.0938	2.381			14	G10660	
		7/64	0.1094	2.7781			14	G10665	
	1 1/4"	1/8	0.1250	3.175			14	G10670	
		5/32	0.1563	3.969			14	G10675	
		3/16	0.1875	4.763			14	G10680	
		7/32	0.2188	5.556			14	G10685	
		1/4	0.2500	6.350			14	G10690	
		5/16	0.3125	7.9375		0.46.465	14	G10695	
		3/8	0.3750	9.525	10	G12460	14	G10700	(cont.)



Stainless Steel Cutting

	(cont.)					COAF	RSE TOOTH	STD.	тоотн
STANDARD	SAW	ARBOR HOLE		SAW WIDTH		NO OF		NO OF	
TOLERANCES	DIA.	DIA.	Fraction	Decimal	ММ	TEETH	EDP#	TEETH	EDP#
			3/64	0.0469	1.191			16	G10705
SAW DIA:			1/16	0.0625	1.588			16	G10710
+.015"			5/64	0.0781	1.984			16	G10715
000"			3/32	0.0938	2.381	12	G12465	16	G10720
			7/64	0.1094	2.778			16	G10725
ARBOR HOLE		1"	1/8	0.1250	3.175	12	G12470	16	G10730
SIZE:			5/32	0.1563	3.969	10	0 40 475	16	G10735
+.0005"			3/16	0.1875	4.763	12	G12475	16	G10740
0000"			7/32	0.2188	5.556			16	G10745
.0000			1/4 5/10	0.2500	6.350			16	G10750
SIDE RUN-OUT			5/16 2/8	0.3125	7.938			16	G10755
LESS THAN	5"		3/8	0.3750	9.525			16	G10760
.0005"			3/64 1/16	0.0469 0.0625	1.191 1.588			16 16	G10765 G10770
.0005			5/64	0.0625	1.588			16	G10770 G10775
			3/32	0.0781	2.381			16	G10775 G10780
THICKNESS:			3/32 7/64	0.0938	2.361			16	G10785
+.0010"			1/8	0.1094	3.175			16	G10790
0000"		1 1/4"	5/32	0.1260	3.969			16	G10795
			3/16	0.1875	4.763			16	G10800
			7/32	0.2188	5.556			16	G10805
			1/4	0.2500	6.350			16	G10810
			5/16	0.3125	7.938			16	G10815
			3/8	0.3750	9.525			16	G10820
			3/64	0.0469	1.191			18	G10825
			1/16	0.0625	1.588			18	G10830
			5/64	0.0781	1.984			18	G10835
			3/32	0.0938	2.381			18	G10840
			7/64	0.1094	2.778			18	G10845
		1"	1/8	0.1250	3.175			18	G10850
		I	5/32	0.1563	3.969			18	G10855
			3/16	0.1875	4.763			18	G10860
			7/32	0.2188	5.556			18	G10865
			1/4	0.2500	6.350			18	G10870
			5/16	0.3125	7.938			18	G10875
	6"		3/8	0.3750	9.525			18	G10880
			3/64	0.0469	1.191			18	G10885
			1/16	0.0625	1.588			18	G10890
			5/64	0.0781	1.984			18	G10895
			3/32	0.0938	2.381			18	G10900
			7/64	0.1094	2.778		040400	18	G10905
		1 1/4"	1/8 5/22	0.1250	3.175	14	G12480	18	G10910
			5/32	0.1563	3.969	4.4	040405	18	G10915
			3/16 7/22	0.1875	4.763 5.556	14	G12485	18	G10920 G10925
			7/32 1/4	0.2188 0.2500	5.556	14	G12490	18	G10925 G10930
			1/4 5/16	0.2500	6.350 7.938	14	G12490	18 18	G10930 G10935
			3/8	0.3750	9.525			18	G10935 G10940
			1/8	0.1250	3.175			24	G10940 G10945
			5/32	0.1250	3.969			24	G10945 G10950
	8"	1 1/4"	3/16	0.1503	3.909 4.763			24	G10955
			1/4	0.1675	6.350			24	G10955
		1"	1/4	0.1250	3.175	┤		72	G10495
	10"	-	1/8	0.1250	3.175	┤		32	G10495
		1 1/4"	3/16	0.1230	4.763			32	G10975
	I		5/10	0.1070	4.700	1		52	010070

Steel Cutting



These GAYLEE Steel Cutting carbide tipped saws are ideal for use on:

Steel Cutting Applications

Note: On Stainless Steel AISI Types 200 through 350, order Stainless Steel Cutting saws and cutters. For all other types of Stainless Steel, order Steel Cutting cutters from this page.

STEEL CUTTING carbide tipped thin saws are specifically designed for slitting, slotting, milling,

and cut-off of steel workpieces. Carbide tips are of premium quality steel-cutting grade. All cutters have both dish and side clearance for free-cutting action. These are precision cutting tools, with tool geometry to maximize steel cutting performance. Standard number of teeth has been significantly increased to meet steel-cutting demands.

COARSE TOOTH

MEDIUM TOOTH STD. TOOTH

	10000		SAW WIDTH								STANDARD
SAW DIA.	ARBOR HOLE DIA.	Fraction	Decimal	ММ	NO OF TEETH	EDP#	NO OF TEETH	EDP#	NO OF TEETH	EDP#	
		3/64	0.0469	1.191					16	G11000	TOLERANCES
		1/16	0.0625	1.588			12	G13000	16	G11005	
		5/64	0.0781	1.984					16	G11010	SAW DIA:
		3/32	0.0938	2.381			12	G13005	16	G11015	+.015"
		1/8	0.1250	3.175			12	G13010	16	G11020	000"
3"	1"	5/32	0.1563	3.969			12	G13015	16	G11025	
-		3/16	0.1875	4.763			12	G13020	16	G11030	ARBOR HOLE
		7/32	0.2188	5.556					16	G11035	SIZE:
		1/4	0.2500	6.35	6	G12600			16	G11040	-
		5/16	0.3125	7.9375	6	G12605					+.0005"
		3/8	0.3750	9.525	6	G12610					0000"
		1/16	0.0625	1.588			14	G13025	20	G11045	
		3/32	0.0938	2.381			14	G13030	20	G11050	SIDE RUN-OUT
		1/8	0.1250	3.175	8	G12615	14	G13035	20	G11055	LESS THAN
	1"	3/16	0.1875	4.763	8	G12620	14	G13040	20	G11060	.0005"
		1/4	0.2500	6.35	8	G12625			20	G11065	
4"		5/16	0.3125	7.9375	8	G12630					
		3/8	0.3750	9.525	8	G12635					THICKNESS:
		1/8	0.1250	3.175					20	G11070	+.0010"
	1 1/4"	3/16	0.1875	4.763					20	G11075	0000"
	1 1/4	1/4	0.2500	6.350	8	G12640			20	G11080	
		3/8	0.3750	9.525	8	G12645					
		1/16	0.0625	1.588			16	G13045	24	G11085	
	1"	3/32	0.0938	2.381			16	G13050	24	G11090	
	-	1/8	0.1250	3.175			16	G13055	24	G11095	
5"		3/16	0.1875	4.763			16	G13060	24	G11100	
	4 4 / 4 !!	3/32	0.0938	2.381					24	G11105	
	1 1/4"	1/8	0.1250	3.175				0.46555	24	G11110	
		3/16	0.1875	4.763			16	G13065	24	G11115	
		1/16	0.0625	1.588			18	G13070	28	G11120	
	1"	3/32	0.0938	2.381			18	G13075	28	G11125	
		1/8	0.1250	3.175			18	G13080	28 28	G11130	
6"		3/16	0.1875	4.763			18	G13085	-	G11135	
0		1/16	0.0625	1.588			18	G13090	28	G11140	
	1 1/4"	3/32 1/8	0.0938 0.1250	2.381 3.175	16	G12650	18 18	G13095 G13100	28 28	G11145 G11150	
	1 1/4	-			16 16		_		28 28		
		3/16	0.1875	4.763		G12655	18	G13105	-	G11155	
		1/4 3/16	0.2500	6.350 4.763	16 16	G12660 G12665	18	G13110	28	G11160	
8"	1 1/4"				-						
		1/4	0.2500	6.350	16	G12670					





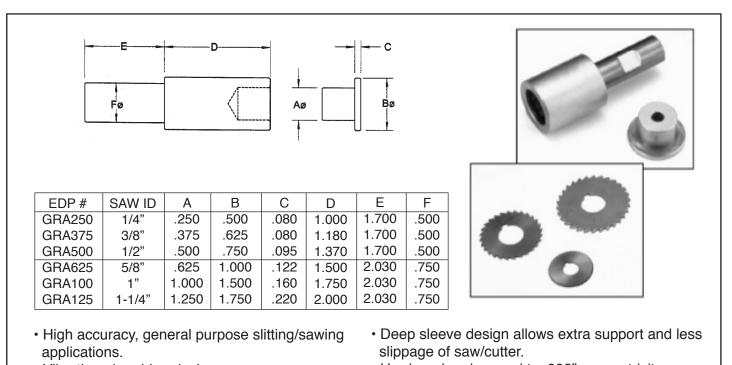
Each saw manufactured by Gaylee goes through stringent quality assurance checks before shipment.

GAYLEE can modify standard cutters in this catalog to meet your special job requirements. Most modified standards can be shipped within one week - much sooner than the time required to manufacture special saws and cutters. In addition, modified standard cutters usually offer substantial cost savings over specialty manufactured tools. Prices of modified and special cutters are quoted on quantities required. If your application requires a modified or special cutter, as much information as possible concerning your specific application should be supplied.

- Saw Diameter
- Saw Thickness
- Number of Teeth
- Keyway Dimension and Type
- Work Material
- Depth of Cut
- Tolerance Required
- Form To Be Generated
- Arbor (Hole) Size
- Slot Width
- Hub Width and Diameter

- Machine Used
- · Rockwell Hardness of Workpiece
- Detail of Present Cutter Used
- Results Obtained from Present Cutter
- Speeds RPM
- Feeds (SFM, CPI and/or IPR)
- Special Tooth Configuration
- Are Saws Used in Gang Configuration?
- A FAX or e-mail of a sketch showing your part and/or the saw or cutter now in use would be most helpful in making our recommendations. Include any notes or comments pertinent to the application.

Stub Arbors For Saws



- Vibration absorbing design.
- Weldon shanks.

• Hardened and ground to .002" concentricity. Tighter tolerances (to .0004") available.



These are general cutting speed recommendations on SFM - m/min. rates, and may vary from application to application. Gaylee Corporation does not assume any liability in the following recommendations, which are basically suggestions on where to start. Contact Gaylee if you have questions on speeds and feeds.

MATERIAL* TO BE CUT (BM) HARDES RANGE (BTM) CARIOF SAW (UTTN) (SFM / mm/n), SFED (SFM / m	,						
Carbon Steels-Wrought 40-170 9-40 Cast Irons 40-145 9-34 Carbon Steels-Wrought 85-425 135-530 25-125 Alloy Osatings 275-375 25-335 6-8 Carbon Steels-Wrought 150-200 320-425 27-300 Alluminum 30-150 3400-4250		RANGE	CUTTING SPEED	CUTTING SPEED	RANGE	CUTTING SPEED	CUTTING SPEED
Wrought 38-185 6-38 Alloy Castings 22-35 6-8 Carbon & Fertile Alloy Steles (High Trans, Sarvice) 150-200 320-425 323-30 Alloy-Wrought 30-150 3240-4250 820-1000 Free Machining Alloy Steles Wrought 150-425 35-470 3-110 Aluminum 40-125 2125-5315 500-1250 Alloy Steles, Wrought 125-425 35-225 8-100 Magnesium 40-125 5100-6375 1200-1500 High Strength 225-400 35-225 8-50 Magnesium 50-90 5100-6375 1200-1500 Marging Steels- 75-425 11-130 2.5-15 Alloy-Cast 50-90 50-650 151-125 Tool Swels- Wrought 100-375 35-470 3-5-10 Alloys-Wrought 100-40 25-130 51-125 Alloy Swels, hip Nate, Wrought 200-350 150-215 35-50 Copper Alloys-Cast 40-200 340-2126 80-400 Mircing Steels- Wrought 100-400 35-255 55-15 Alloys-Cast 40-200 365-100		100-425			 110-320		
Steels (High Temp, Service) 100-130 23-30 Alloys-Wrought 1042-1300 245-305 Free Machining Alloy 150-425 35-425 8-110 Alloys-Cast 40-125 2125-5315 500-1250 Alloy Steels 1125-425 35-255 8-100 Magnesium 40-125 5100-8325 1200-1500 Mice Steels 35-255 8-60 Magnesium 50-90 5100-8325 1200-1500 Marging Steels 275-425 35-215 8-50 Titanum 50-90 5100-8325 1200-1500 Marging Steels 100-375 31-65 8-50 Titanum 110-440 65-530 15-125 Tool Steels 100-375 35-470 8-110 Titanum 150-360 170-470 40-110 Mitriding Steels- 200-350 150-25 35-50 110-90 24-150 105-510 24-120 Mitriding Steels 100-400 35-255 15-50 Copper 40-200 340-120 25-10 105-510 24-120 Structurd St		85-425			 275-375		
Steets-Wrought 11-145 2.5-34 Altoys-Cast 640-1615 T50-380 Altoy Steels, Wrought 125-425 35-425 8-100 Magnesium 40-125 5100-8375 1200-1500 High Strength Steels-Wrought 225-400 35-255 8-60 Magnesium 50-90 5100-6375 1200-1500 Maraging Steels- Wrought 275-425 35-215 8-50 Titanium 110-440 65-330 15-125 Tool Steels- Wrought 100-375 35-5470 8-110 Titanium 110-440 65-330 120-472 40-110 Nitriding Steels- Wrought 100-375 35-5475 35-50 Copper Alloys-Wrought 107-840 28-100 24-150 Amor Plate, Ship Plate, Wrought 200-350 65-215 15-50 Copper Alloys-Cast 40-200 340-1200 24-150 Sturtural Steels- Wrought 105-400 35-255 8-60 Nickel Alloys- Wrought and Cast 80-300 65-300 15-70 Stainless Steels- Wrought 135-425 150-470 35-110 Beryllum Nickel A					 30-150		
Wrought 11-130 2.5-30 Alloyš-Wrought 155:1955 365-460 High Strength Steles-Wrought 225-400 35:255 8-60 Magnesium Alloys-Cast 50-90 5100-6375 11200-1500 365-460 Maraging Steels- Wrought 275-425 35:215 8-50 Titanium Alloys-Wrought 110-440 85:530 15:125 Tool Steels- Wrought 100-375 35:470 8:110 2:5-34 Titanium Alloys-Cast 150-350 170-470 40-110 Amor Plate, Ship Plate, Arcraft Plate-Wrought 200-350 65:215 15:50 Copper Alloys-Cast 40-200 340:2125 80-500 24-150 Stuctural Steels- Wrought 100-400 35:255 5:5-15 Copper Alloys-Cast 40-200 340:2125 80-500 15:70 Stuctural Steels- Wrought 100-400 35:255 8:40 Nickel Alloys- Wrought and Cast 80-360 65:300 15:70 Stainless Steels- Wrought 135:425 150:470 35:110 Wrought and Cast 140-475 35:255 8:50 Preciplat	Free Machining Alloy Steels-Wrought	150-425			 40-125		
Steels-Wrought 11-80 2.5-18 Alloys-Cast 1555-1955 365-460 Maraging Steels- Wrought 275-425 35-215 8-50 Titanium Alloys-Wrought 110-440 25-165 5-38 Tool Steels- Wrought 100-375 35-470 8-110 Titanium Alloys-Wrought 150-350 170-470 40-110 Ninding Steels- Wrought 200-350 150-215 35-50 Copper Alloys-Wrought 10R-100Rs 340-2125 80-500 Aircraft Plate, Wrought 200-350 65-215 15-50 Copper Alloys-Cast 40-200 340-1700 80-400 Aircraft Plate, Wrought 100-400 35-255 8-60 Nickel Alloys- Wrought and Cast 80-360 65-300 15-70 Structural Steels- Wrought 135-425 35-425 8-100 Nickel Alloys- Wrought and Cast 80-360 65-300 25-15 Steels-Wrought 135-425 35-425 8-100 Refractory Alloys- Wrought and Cast 140-475 35-255 8-60 Precipitation Hardening Stainless Steels- Cast 135-425 150-420 <t< td=""><td></td><td>125-425</td><td></td><td></td><td>40-125</td><td></td><td></td></t<>		125-425			40-125		
Wrought 11-65 2.5-15 Alloys-Wrought 25-165 5-38 Tool Steels- Wrought 100-375 35-470 35-470 8-110 2.5-34 Titanium Alloys-Cast 150-350 170-470 55-145 40-110 12:34 Nitriding Steels- Wrought 200-350 150-215 50-65 35-50 51-15 Copper Alloys-Cast 10Re-100Re 40-200 340-2125 424-150 80-500 24-150 Arrora Plate, Arrora Plate, Wrought 100-400 35-255 55-15 15.50 8-60 Copper Alloys-Cast 80-360 65-300 25-90 15-70 5-21 Structural Steels- Wrought 100-400 35-255 50-145 8-60 11-80 Nickel Alloys- Wrought and Cast 80-360 65-300 25-90 15-70 5-215 Stainless Steels- Wrought 135-425 35-425 35-425 8-100 11-30 High Temp. Alloys- Wrought and Cast 140-475 35-255 11-80 8-60 2.5-70 Stainless Steels- Wrought 150-440 85-340 25-405 25-10 6-224 Zinc Alloys- Cast 170-320 150-300 35-70 35-70 35-80 Stainless Steels-Wrought 150-400 35-425 35-103 15-30 25-40 Zinc Alloys- Cast 170-420 325-450 325-3		225-400			50-90		
Wrought 11-145 2.5-34 Alloys-Cast 55-145 12-34 Nitriding Steels- Wrought 200-350 150-215 50-85 32-50 11-15 Copper Alloys-Wrought 10Re-100Re 340-2125 30-540 80-500 24-150 Armor Plate, Ship Plate, Aircraft Plate-Wrought 200-350 65-215 25-65 15-50 5-15 Copper Alloys-Cast 40-200 340-1700 105-510 80-400 24-120 Structural Steels- Wrought 100-400 35-255 50-145 8-60 11-80 Nickel Alloys- Wrought and Cast 80-360 65-320 25-90 15-70 5-21 Free Maching Stainless 135-425 150-470 50-145 55-10 Beryllium Nickel Alloys- Wrought and Cast 140-475 35-255 31-85 8-50 2.5-18 Stainless Steels- Cast 135-425 35-425 35-130 8-100 11-130 High Term, Alloys- Wrought and Cast 140-475 35-255 110-8 8-60 2.5-18 Precipitation Hardening Stainless Steels- Cast 135-425 35-130 8-25 2.5-100 Zinc Aloys- Cast 80-100 1380-1720 325-300 325-300 35-70 76-90 Carbon Steels- Cast 150-400 35-130 15-30 2.5-16 15-30 2.5-16		275-425			110-440		
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Cast Irons 25-160 6-37 Bronzes 55-65 12-15		120-330			35-81Rн		
Cont. on page 24		120-330			30-75R⊧	55-65	12-15

Cont. on page 24

*Materials list from Machining Data Handbook-3rd Edition, published by the Machinability Data Center. For specific metals/materials within each material category, refer to Machining Data Handbook.

**Hardness range listed in Brinell unless otherwise noted. 'Range' covers all metals/materials listed within each material group.

***Thermosetting plastics have various hardness scales. Refer to Machining Data Handbook.



<u> </u>	Recommendations (cont.)				
MATERIAL* TO BE CUT	HARDNESS RANGE (Bhn)**	CARBIDE SAW CUTTING SPEED (SFM / m/min.)	H.S.S. SAW CUTTING SPEED (SFM / m/min.)		
P/M Alloys-	22-100Rн	<u>170-215</u>	<u>40-50</u>		
Copper-Nickel Alloys		55-65	12-15		
P/M Alloys-	70-83	<u>170-215</u>	<u>40-50</u>		
Nickel and Nickel Alloys		55-65	12-15		
P/M Alloys-	101-260	<u>405-510</u>	<u>95-120</u>		
Refractory Metal Base		124-160	29-37		
P/M Alloys-	50-67	<u>215-255</u>	<u>50-60</u>		
Irons		65-80	15-18		
P/M Alloys-	101-426	<u>150-255</u>	<u>35-60</u>		
Steels		50-80	11-18		
P/M Alloys-	107-285	<u>170-215</u>	<u>40-50</u>		
Stainless Steels		55-65	12-15		
P/M Alloys-	55-98RH	<u>510-640</u>	<u>120-150</u>		
Aluminum Alloys		160-195	37-46		
Machinable	40-51Rc	<u>35-45</u>	<u>8-10</u>		
Carbides		11-13	2.5-3		
Free Machining	185-240	<u>215-340</u>	<u>50-80</u>		
Magnetic Alloys		65-105	15-24		
Magnetic	185-240	<u>55-215</u>	<u>12-50</u>		
Alloys		16-65	3.6-15		
Free Machining Controlled	125-220	<u>215-255</u>	<u>50-60</u>		
Expansion Alloys		65-80	15-18		
Controlled Expansion	125-250	<u>35-45</u>	<u>8-10</u>		
Alloys		11-13	2.5-333		
Carbons	8-100	<u>150-215</u>	<u>35-50</u>		
and Graphites	Shore	50-65	11-15		
Glasses and Ceramics-	250	<u>85-105</u>	<u>20-25</u>		
Machinable	Knoop	25-35	6-8		
Plastics-	60-120Rм	<u>1065-1490</u>	<u>250-350</u>		
Thermoplastics	50-120Rв	325-450	76-105		
Plastics-	50-120nk	<u>340-1490</u>	<u>80-350</u>		
Thermosetting	***	105-450	24-105		

*Materials list from Machining Data Handbook-3rd Edition, published by the Machinability Data Center. For specific metals/materials within each material category, refer to Machining Data Handbook.

**Hardness range listed in Brinell unless otherwise noted. 'Range' covers all metals/materials listed within each material group.

***Thermosetting plastics have various hardness scales. Refer to Machining Data Handbook.

USEFU	L METALWORKING FORMULAS			
SFPM =	.262 X (CUTTER DIA. X RPM)			
(or)	(RPM X CUTTER DIA.) ÷ .382			
RPM =	(3.82 X SFPM) ÷ CUTTER DIA.			
(or) SFPM ÷ (CUTTER DIA. X .262)				
IPM =	IPR X (# TEETH X RPM)			
IPT =	IPM ÷ (# TEETH X RPM)			
IPR =	IPM ÷ RPM			
CIM =	IPR X SPD. X DOC			
HP =	CIM X UHF			
FORCE =	= (33,000 X HP) ÷ SFM			

Cutting Speed FEED RATES:

Carbide Saws: .0002"-.0015" (in.per tooth - IPT or chip load per tooth - CLPT) *H.S.S. Saws:* .002-.006 (in.per tooth - IPT or chip load per tooth - CLPT) NOTE: This is a conservative recommendation as a *starting point* for feed rates, and may vary depending on material being cut and cutting speed (SFPM).

COATINGS FOR SAWS AND CUTTERS

Cutting tool surface coatings are available upon request. Tool coatings provide tool wear resistance while significantly improving the performance of saws in most applications, particularly when cutting ferrous materials. These coatings are extremely thin, harder than steel and greatly reduce friction and wear. The most common coatings available for Gaylee saws are:

• TiN: Titanium Nitride - General purpose TiN hard coating. Best suited for iron-based materials, unalloyed and alloyed steels and hardened steels.

• TiCN: Titanium Carbonitride - Enhanced hardness and wear resistance over TiN with better surface lubricity. Suited for difficult to machine materials such as cast iron, aluminum alloys, tool steels, copper, Inconel, titanium alloys and nonferrous materials.

• TiAIN: Titanium Aluminum Nitride - Nanolayered coating, high toughness and oxidation resistance. Recommended for high temperature cutting, and a good choice when coating carbide. Suited for difficult materials like cast iron, aluminum alloys, tool steels and nickel alloys.

• AICrN: Aluminum Chromium Nitride -

Expanded performance capabilities over titanium-based coatings. Highest oxidation resistance and hot hardness for high temperature wear resistance. Can be used in wet/dry cutting applications. Well suited for a wide range of materials - cast iron, unalloyed steels, high strength steels, high hardness steels.



SAWS TEST APPLICATION DATA SHEET

Solid Carbide, Carbide-Tipped and H.S.S. Saws

Gaylee Saws Rep.:							
Customer Name:		Date:	Date: /				
City/State:		Distributor:					
Phone:							
	Extn.:						
GENERAL INFORMATIO	N						
(Application) B/P or Job #							
SC C-Tipped H.	S.S. Saw	Dia	Saw Width		Tolerance		
Arbor Hole Dia.	# Teeth	۱SI	pecial Tooth Fo	orm			
Keyway (Y/N)	_ Keyway Dime	nsion	Hu	Hub (Y/N)			
			Rake Angle				
Positive / Negative	Positive / Negative Surface Treatment						
Unique Job Details							
JOB APPLICATION							
Operation	on Slot Wid		Tolerance)			
				Material			
Hardness							
Speed	Feed	Coolant	Туре		Mix		
Are saws ganged? (Y/N)		If yes, tolerance	e required				
Form to be generated				(Ske	etch or B/P helpful)		
COMPETITION							
Brand Name		Price (\$)					
Delivery							
Current performance info.	or problem						
Criteria for successful test	 t						
		Data					
GAYLEE PO#		Date	DIS	st. PO#			
Results							
Were you present for test	? Y/N	Comments					



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Roseville Saginaw & Jackson, MI

GAYLEE

SAWS

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