

J&B INDUSTRIES INC

Material Thickness and Cutter Recommendations

<u>Material</u>	<u>Wall Thickness</u>	<u>Suggested Cutter Degree (Inclusive)</u>
Copper – Soft	.010 - .028"	15
	.029 - .040"	15 or 20
	.041 - .080"	20 or 30
Copper – ½ to Full Hard	.010 - .020"	15 or 20
	.021 - .041"	20 or 30
	.041 - .050"	30
	.051 - .080"	30 or 40
Aluminum – Soft	.010 - .028"	15
	.029 - .040"	15 or 20
	.041 - .080"	20 or 30
Aluminum – ½ to Full Hard	.010 - .020"	15 or 20
	.021 - .040"	20 or 30
	.041 - .050"	30
	.051 - .080"	30 or 40
Steel – Low Carbon	Up to .035"	20
	.035 and thicker	30
Steel – Stainless	Up to .035/.040"	30
	.040" and thicker	40
Brass	Up to .035"	20
Titanium		40-SHA

- Please note that the above mentioned are recommendations, and that the end condition can be altered by honing of the cutter blade.
- Also, cutter life is not an exact science, many factors come into play, such as:
 - Operator experience
 - Whether or not a mist lubricant is used
 - Speed of cut
 - Roundness of tubing

All cutter blades are manufactured at our South Carolina facility and kept in stock