

SOLID CARBIDE AND CARBIDE TIPPED

THIN SAWS & CUTTERS





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WARRANTY & LIMITATIONS

GAYLEE Corporation warrants it's 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 Corporation, to the user of our products. Determination as to defective product rests solely with Gaylee Corp. 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 Corp. shall have no obligation to repair or replace products damaged by misuse, improper operating conditions, products altered or repaired by parties other than Gaylee Corp., or the failure of the user to apply appropriate preventative maintenance or service. No product shall be returned to Gaylee Corp. without its prior consent. Product which Gaylee Corp. consents to be returned shall be sent freight prepaid. Complete information regarding the complaint must be furnished to Gaylee Corp. prior to consent to be returned. Gaylee Corp. will not assume responsibility or accept invoices for unauthorized repairs to its products, even though defective. Gaylee Corp. makes no warranty as to fitness of its products for specific applications by the user unless Gaylee Corp. specifically agrees otherwise in writing after review of the proposed usage, nor does Gaylee Corp. 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 Corp. 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, delivery or use of any product sold hereunder, in excess of the cost of replacement or repair as provided herein. IN NO EVENT SHALL GAYLEE CORP. BE LIABLE FOR ANY SPECIAL, INCIDENTAL, OR CONSEQUENTIAL DAMAGES. Gaylee Corp. makes no warranty, express or implied, except as set forth above; and Gaylee Corp. neither assumes nor authorizes any other person or entity to assume for it any other obligation or liability in connection with any of it's 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.

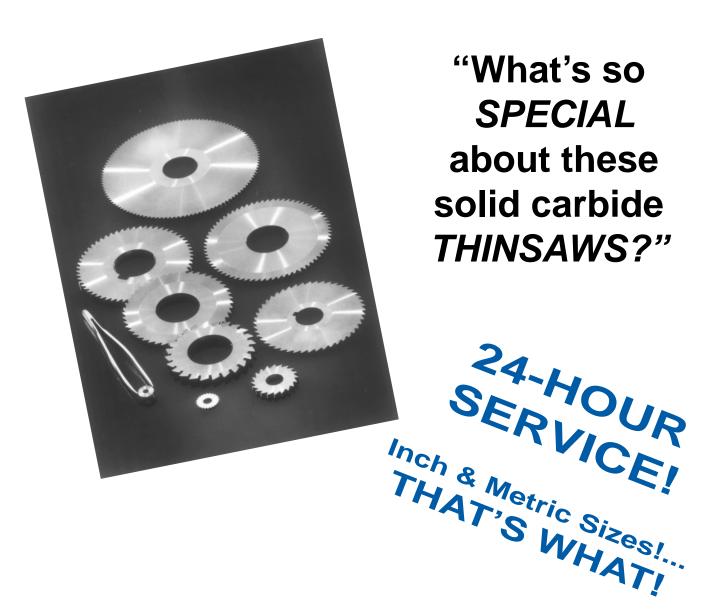
SPECIAL GAYLEE SOLID CARBIDE AND CARBIDE TIPPED THIN SAWS AND CUTTERS

If the cutting tool you need is not listed in this catalog, send specifications to GAYLEE Corporation for quotation on specially manufactured cutters. See page 20 of this catalog for information needed by Gaylee Corp. to properly determine the best cutter for your specific application. Gaylee Corporation 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 GOOD WORKING ORDER. ALWAYS USE SAFE OPERATING PROCEDURES. ELIMINATE ANY POSSIBILITY OF OPERATOR CONTACT WITH A MOVING/OPERATING CUTTING TOOL.

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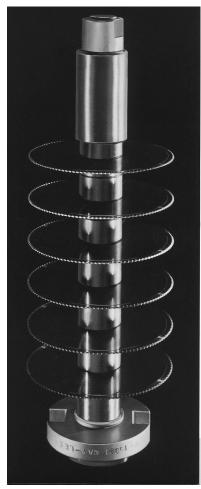




- ✓ 24-HOUR SHIPMENT of premium quality SOLID CARBIDE "THINSAWS"
 - Diameter Range INCH: 3/4" through 4" METRIC: 20mm through 100mm
 - Thickness Range INCH: .008" through .250" METRIC: .20mm through 6.35mm
 - Arbor hole sizes INCH: Standard sizes METRIC: 5mm, 8mm, 10mm, 13mm, 16mm, 22mm
 - Tolerances 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 slitting, slotting and cutting operations.
- ✓ Contact our Customer Service Dept. for special applications.
- ✓ GAYLEE tool designers will be pleased to assist with your specific needs.
- ✓ Inquire about Gaylee Carbide-tipped ThinSaws.

GAYLEE 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.

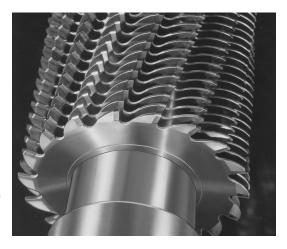
High precision, tight-tolerance saw gangs from GAYLEE provide multiple depth cutting, as well as multiple slitting in a single pass.

The possibilities are limitless...

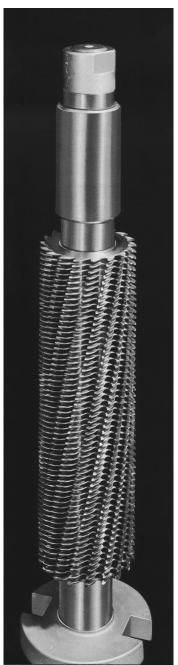


This quill mounted saw gang shows alternate saw diameters for varying depth cutting detail.

- 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.



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



Arbors for saw gangs can be designed with a spiral keyway. The faces of the saw teeth are then designed to follow the helix. Saws can be resharpened on the O.D. without disassembly of the saw gang.



THIN SAWS & CUTTERS

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 to 7.5"
- 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 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.



+.0005" -.0000"

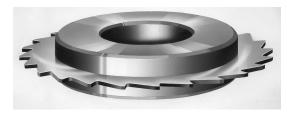


EXTREME PRECISION AND MINIATURIZATION

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.

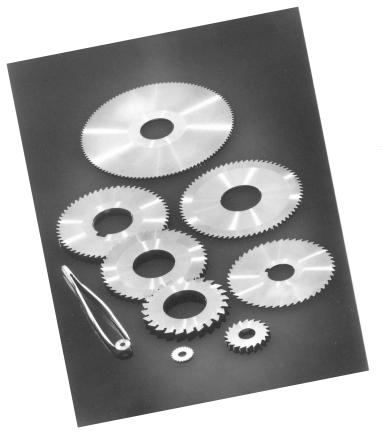
SOLID CARBIDE COMMUTATOR UNDER CUTTING SAW

The speeds and extra wear of carbide are made practical in a saw that has been specifically designed for undercutting commutators economically and at high feed rates. The brazed steel hub (optional) makes the solid carbide blade and hub one unit that will not part in use or during regrinding. The blade and hub unit offers extreme rigidity for extremely thin cutters. Diameter range from 5/16" to 3".





TECHNICAL DATA-CARBIDE SAWS



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 nonferrous and non-metallic materials such as fiberglass, epoxies and composites.

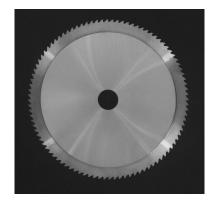
Use of solid carbide saws permits a far greater number of teeth in a given saw size than is possible with carbide tipped saws. A greater number of teeth allows reduced chip load, higher speeds & feeds, and improved quality of the finished cut.

THIN SAWS & CUTTERS

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. If the customer so desires, cutters may be ordered without hubs or keyways.

Timely shipment of your tooling order 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
TOLERANCES
SAW
DIAMETER:
+.005"
000"
ARBOR HOLE
DIAMETER:
+.0005"
0000"
SIDE RUN-OUT
LESS THAN
.0005"
THICKNESS:
+.0005"
0000"

SAW	ARBOR		SAW WIDTH		NO OF	EDP
DIA.	HOLE DIA.	Frac.	Deci.	mm	TEETH	NUMBER
		1/32	0.0313	0.794	18	G15000
3/4"	1/4"	3/64	0.0469	1.191	18	G15005
•		1/16	0.0625	1.588	18	G15010
			0.0080	0.203	20	G15100
			0.0100	0.254	20	G15105
			0.0120	0.305	20	G15110
		483.4.4.	0.0140	0.356	20	G15115
		1/64	0.0156	0.397	20	G15120
			0.0180	0.457	20	G15125
			0.0200	0.508	20	G15130
			0.0230	0.584	20	G15135
:			0.0250	0.635	20	G15140
			0.0280	0.711	20	G15145
			0.0300	0.762	20	G15150
		1/32	0.0313	0.794	20	G15155
			0.0350	0.889	20	G15160
			0.0394	1.000	20	G15165
			0.0400	1.016	20	G15103
		3/64	0.0469	1.191	20	G15175
		5,01	0.0500	1.270	20	G15173
•			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
		0,04	0.0787	2.000	20	G15203
			0.0800	2.032	20	G15210
		 -	0.0900	2.286	20	G15215
1"	3/8"	3/32	0.0938	2.381	20	1
•	0/0	3/32	0.1000	2.540	20	G15225
			0.1100	2.794	20	G15230 G15235
			0.1181	3.000	20	G15235
			0.1200	3.048	20	
		1/8	0.1250	3.175	20	G15245
		1/0	0.1230	3.302	20	G15250
			0.1400	3.556	20	G15255
	ĺ		0.1500	3.810	20	G15260 G15265
		5/32	0.1563	3.969	20	G15265 G15270
		G/GE	0.1575	4.000	20	G15270
	ŀ		0.1600	4.064	20	G15275 G15280
			0.1700	4.318	20	G15285
			0.1700	4.572	20	G15290
		3/16	0.1875	4.763	20	G15290 G15295
		5/15	0.1973	4.703	20	G15295 G15300
			0.1969	5.000	20	G15305
	ŀ		0.2000	5.080	20	G15310
			0.2100	5.334	20	G15315
		7/32	0.2188	5.556	20	G15315
	ŀ	,,,,,,	0.2200	5.588	20	G15325
			0.2300	5.842	20	G15325 G15330
			0.2362	6.000	20 20	
	ŀ		0.2302	6.096	20	G15335
		1/4	0.2500	6.350		G15340
		1/+	0.2000	0.000	20	G15345

SAW	ARBOR		SAW WIDTH		NO OF	EDP
DIA.	HOLE DIA.	Frac.	Deci.	mm	TEETH	NUMBER
		1/32	0.0313	0.794	24	G15400
		3/64	0.0469	1.191	24	G15405
	5/16"	1/16	0.0625	1.588	24	G15410
		3/32	0.0938	2.381	24	G15415
		1/8	0.1250	3.175	24	G15420
1-1/4"		1/32	0.0313	0.794	24	G15450
	1/2"	3/64	0.0469	1.191	24	G15455
		1/16	0.0625	1.588	24	G15460
	1	3/32	0.0938	2.381	24	G15465
		1/8	0.1250	3.175	24	G15470
		1/32	0.0313	0.794	32	G15500
	1/2"	3/64	0.0469	1.191	32	G15505
1-1/2"		1/16	0.0625	1.588	32	G15510
		3/32	0.0938	2.381	32	G15515
		1/8	0.1250	3.175	32	G15515
		1/32	0.0313	0.794	36	G15520
	1/2"	3/64	0.0313	1.191	36	G15605
	"-	1/16	0.0409	1.191	36	
		1/32	0.0623	0.794	36	G15610
	5/8"	3/64	0.0313	1.191		G15700
1-3/4"	3/0	3/64 1/16	0.0469	1.191	36 36	
. 9/7		1/32	0.0625	0.794	36	G15705 G15710 G15800 G15805 G15810
		3/64	I		36	
	7/8"	3/64 1/16	0.0469	1.191	36	
	""	3/32	0.0625	1.588	36	
		3/32 1/8	0.0938 0.1250	2.381	36 36	G15815
		1/0		3.175	36	G15820
			0.0080	0.203	36	G16000
			0.0100	0.254	36	G16005
	-		0.0120	0.305	36	G16010
		1/04	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
		4 100	0.0300	0.762	36	G16050
2"	4/0"	1/32	0.0313	0.794	36	G16055
2	1/2"		0.0350	0.889	36	G16060
			0.0394	1.000	36	G16065
			0.0400	1.016	36	G16070
		3/64	0.0469	1.191	36	G16075
			0.0500	1.270	36	G16080
	1		0.0510	1.295	36	G16085
			0.0600	1.524	36	G16090
		1/16	0.0625	1.588	36	G16095
			0.0700	1.788	36	G16100
		5/64	0.0781	1.984	36	G16105
			0.0787	2.000	36	G16110
	·		0.0800	2.032	36	G16115
	[Γ		0.0900	2.286	36	G16120
		3/32	0.0938	2.381	36	G16125
			0.1000	2.540	36	G16130
	i l		0.1100	2.794	36	G16135

	STANDARD
1	TOLERANCES
Ī	SAW
1	DIAMETER:
1	+.005"
1	000"
	ARBOR HOLE
	DIAMETER:
	+.0005"
	0000"
	SIDE RUN-OUT
	LESS THAN
	.0005"
Ī	THICKNESS:
	+.0005"
	0000"

SOLID CARBIDE THIN SAWS

STANDARD
TOLERANCES
SAW
DIAMETER:
+.005"
000"
ARBOR HOLE
DIAMETER:
+.0005"
0000"
SIDE RUN-OUT
LESS THAN
.0005"
THICKNESS:
+.0005"
0000"

SAW	ARBOR		SAW WIDTH		NO OF	EDP
DIA.	HOLE DIA.	Frac.	Deci.	mm	TEETH	NUMBER
			0.1181	3.000	36	G16140
		1/2 1/8 1/8 0.1250 3.175 1/2 1/8 0.1250 3.175 1/8 0.1250 3.175 0.1300 3.302 0.1400 3.556 0.1500 3.810 5/32 0.1563 3.969 0.1575 4.000 0.1600 4.064 0.1700 4.318 0.1800 4.572 3/16 0.1875 4.763 0.1900 4.826 0.1969 5.000 0.2000 5.080 0.2100 5.334 7/32 0.2188 5.556 0.2200 5.588 0.2300 5.842 0.2362 6.000 0.2400 6.096 1/4 0.2500 6.350 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 3/16 0.1875 4.763 1/8 0.1250 3.175 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 5/32 0.1563 3.969 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 5/32 0.1563 3.969 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 5/32 0.1563 3.969 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 5/32 0.1563 3.969 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 5/32 0.1563 3.969 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/16 0.0625 1.588 3/32 0.0938 2.381 1/16 0.0625 1.588 3/32 0.0938 2.381 1/16 0.0625 1.588 3/32 0.0938 2.381 1/16 0.0625 1.588 3/32 0.0938 2.381 1/16 0.0625 1.588 3/32 0.0938 2.381 1/16 0.0625 1.588 3/32 0.0938 2.	36	G16145		
	HOLE DIA. Frac. D O O O O O O O O O	0.1250	3.175	36	G16150	
		EDIA. Frac. Deci. mm 0.1181 3.000 0.1200 3.048 1/8 0.1250 3.175 0.1300 3.302 0.1400 3.556 0.1500 3.810 0.1563 3.969 0.1575 4.000 0.1600 4.064 0.1700 4.318 0.1800 4.572 3/16 0.1875 4.763 0.1900 4.826 0.1969 5.000 0.2000 5.080 0.2000 5.080 0.2100 5.334 7/32 0.2188 5.556 0.2200 5.588 0.2300 5.842 0.2300 5.842 0.2302 6.000 0.2400 6.096 1/4 0.2500 6.350 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 3/16 0.1875 4.763 1/4 0.2500 6.350 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 3/16 0.1875 4.763 1/4 0.2500 6.350 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 3/16 0.1875 4.763 1/4 0.2500 6.350 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 5/32 0.0313 0.794 3/64 0.0469 1.191 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 5/32 0.1563 3.969 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/32 0.0313 0.794 3/64 0.0469 1.191 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/32 0.0313 0.794 3/64 0.0469 1.191 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/32 0.0313 0.794 3/64 0.0469 1.191 1/16 0.0625 1.588 3/32 0.0938 2.381 1/8 0.1250 3.175 1/160 0.0625 1.588	36	G16155		
				. "	36	G16160
			1	I .	36	G16165
		5/32			36	G16170
			1		36	G16175
			I		36	G16180
		-			36	G16185
	1/2"		1		36	G16190
	''	3/16	1		36	G16195
			· · · · · · · · · · · · · · · · · · ·		36	G16200
			1	í	36	G16205
2"			i			
_					36	G16210
	1	7/20			36	G16215
		1132			36	G16220
					36	G16225
					36	G16230
					36 36	G16235
		4 / 4			36	G16240
·					36	G16245
					24	G20536
	1"		1		24	G20537
					24	G20538
			1	(36	G16500
			1		36	G16505
					36	G16510
			1		36	G16515
					36	G16520
			1		36	G16525
]				36	G16530
			1		48	G20539
					48	G20540
					48	G20541
			1		40	G17000
					40	G17005
	1/2"				40	G17010
					40	G17015
			1		40	G17020
					40	G17025
				1.588	28	G20542
			0.0938	2.381	28	G20543
	5/8"	1/8	0.1250	3.175	28	G20544
2-1/4"		1/16	0.0625	1.588	56	G20545
			1		56	G20546
			1		56	G20547
					40	G17500
			1		40	G17505
,					40	G17505 G17510
	10					
	•	3/32 1/8			40 40	G17515
		5/32	0.1250	3.175	40 40	G17520
	I	5/32	0.1563	3.969	40	G17525

SAW	ARBOR		SAW WIDTH		NO OF	EDP
DIA.	HOLE DIA.	Frac.	Deci.	mm	TEETH	NUMBER
,			0.0080	0.203	48	G18000
	·		0.0100	0.254	48	NUMBER
	1/64 1/64 1/164 1/16 5/64 5/8" 3/32		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
			0.0200	0.508	48	G18030
			0.0230	0.584	48	G18035
			0.0250	0.635	48	G18040
			0.0280	0.711	48	l I
		1/32	0.0300	0.762	48	
	·		0.0313	0.794	48	l !
	ĺ		0.0350	0.889	48	
			0.0394	1.000	48	I I
			0.0400	1.016	48	
		3/64	0.0469	1.191	48	
		5, 0 →	0.0500	1.270	48	
			0.0500	1.270	48	
			0.0600	1.524	48	
		1/16	0.0625	1.524	48	
		1/10	0.0625	1.778	48	
0.4/01		E /O 4	I .		1	
2-1/2"		5/64	0.0781	1.984	48	
			0.0787	2.000	48	
	5 /0"		0.0800	2.032	48	
	5/8"		0.0900	2.286	48	
		3/32	0.0938	2.381	48	
			0.1000	2.540	48	
			0.1100	2.794	48	1 3
			0.1181	3.000	48	I
			0.1200	3.048	48	
	1	1/8	0.1250	3.175	48	
			0.1300	3.302	48	l I
			0.1400	3.556	48	} I
			0.1500	3.810	48	
		5/32	0.1563	3.969	48	
			0.1575	4.000	48	
			0.1600	4.064	48	
			0.1700	4.318	48	,
			0.1800	4.572	48	1
•		3/16	0.1875	4.763	48	
			0.1900	4.826	48	1
			0.1969	5.000	48	
			0.2000	5.080	48	1 1
			0.2100	5.334	48	1 1
		7/32	0.2188	5.556	48	
			0.2200	5.588	48	
			0.2300	5.842	48	
1			0.2362	6.000	48	
			0.2400	6.096	48	G18240
		1/4	0.2500	6.350	48	
		1/16	0.0625	1.588	28	G20548
	1"	3/32	0.0938	2.381	28	G20549
		1/8	0.1250	3.175	28	G20550
		5/32	0.1563	3.969	28	G20551
	1		1 (0.7000	1		

STANDARD
TOLERANCES
SAW
DIAMETER:
+.005"
000"
ARBOR HOLE
DIAMETER:
+.0005"
0000"
SIDE RUN-OUT
LESS THAN
.0005"
THICKNESS:
+.0005"
0000"

SOLID CARBIDE THIN SAWS

STANDARD
TOLERANCES
SAW
DIAMETER:
+.005"
000"
ARBOR HOLE
DIAMETER:
+.0005"
0000"
SIDE RUN-OUT
LESS THAN
.0005"
THICKNESS:
+.0005"
0000"

SAW	ARBOR		SAW WIDTH		NO OF	EDP
DIA.	HOLE DIA.	Frac.	Deci.	mm	TEETH	NUMBER
·		1/32	0.0313	0.794	48	G18500
		3/64	0.0469	1.191	48	G18505
		1/16	0.0625	1.588	48	G18510
		3/32	0.0938	2.381	48	G18515
		1/8	0.1250	3.175	48	G18520
2-1/2"	1"	5/32	0.1563	3.969	48	G18525
		3/16	0.1875	4.763	48	G18530
		1/4	0.2500	6.350	48	G18535
		1/16	0.0625	1.588	56	G20552
		3/32	0.0938	2.381	56	G20553
		1/8	0.1250	3.175	56	G20554
		5/32	0.1563	3.969	56	G20555
		1/16	0.0625	1.588	30	G20556
		3/32	0.0938	2.381	30	G20557
		1/8	0.1250	3.175	30	G20558
		5/32	0.1563	3.969	30	G20559
			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
	' 1"		0.0280	0.711	60	G19045
			0.0300	0.762	60	G19050
		1/32	0.0313	0.794	60	G19055
0.0/4//			0.0350	0.889	60	G19060
2-3/4"			0.0394	1.000	60	G19065
			0.0400	1.016	60	G19070
		3/64	0.0469	1.191	60	G19075
			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	0.1250	3.175	60	G19150
			0.1300	3.302	60	G19155

SAW	ARBOR		SAW WIDTH		NO OF	EDP
DIA.	HOLE DIA.	Frac.	Deci.	mm	TEETH	NUMBER
			0.1400	3.556	60	G19160
			0.1500	3.810	60	G19165
	<u> </u>	5/32	0.1563	3.969	60	
			0.1575	4.000	60	
]			0.1600	4.064	60	1
			0.1700	4.318	60	
			0.1800	4.572	60	Ť .
		3/16	0.1875	4.763	60	
2-3/4"	1"		0.1900	4.826	60	
			0.1969	5.000	60	NUMBER G19160 G19165 G19170 G19175 G19180 G19185 G19190 G19195 G19205 G19210 G19215 G19220 G19225 G19230 G19235 G19240 G19245 G20560 G20561 G20562 G20563 G20000 G20005 G20010 G20015 G20025 G20030 G20035 G20030 G20035 G20564 G20565 G20566 G20567 G20568 G20505 G20510 G20515 G20520 G20525
			0.2000	5.080	60	
			0.2100	5.334	60	
		7/32	0.2188	5.556	60	
			0.2200	5.588	60	
			0.2300	5.842	60	j
			0.2362	6.000	60	
			0.2400	6.096	60	
		1/4	0.2500	6.350	60	
		1/16	0.0625	1.588	30	
		3/32	0.0938	2.381	30	l
		1/8	0.1250	3.175	30	
		5/32	0.1563	3.969	30	G20563
	•	1/32	0.0313	0.794	60	
3"	1"	3/64	0.0469	1.191	60	G20005
		1/16	0.0625	1.588	60	
		3/32	0.0938	2.381	60	
]	1/8	0.1250	3.175	60	
		5/32	0.1563	3.969	60	
		3/16	0.1875	4.763	60	
		1/4	0.2500	6.350	60	
		1/16	0.0625	1.588	36	
		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

STANDARD
TOLERANCES
SAW
DIAMETER:
+.005"
000"
ARBOR HOLE
DIAMETER:
+.0005"
0000"
SIDE RUN-OUT
LESS THAN
.0005"
THICKNESS:
+.0005"
0000"

For saw sizes up to 7-1/2" O.D., contact Gaylee Corporation.



"World Class Tooling Through Team-Driven Commitment"



THIN SAWS & CUTTERS

CARBIDE TIPPED THIN SAWS & CUTTERS

Designed and manufactured to your exact specifications.

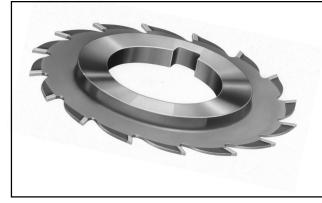
- Carbide Tipped Saws as THIN as .030"
- As THICK as 1.000"
- O.D.'s to 10"
- Tolerances to: +.0010"
 - .0000"
- Modified and Special Saws available, with tighter tolerances when required.



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.



THIN SAWS & CUTTERS



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.

TECHNICAL DATA -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.

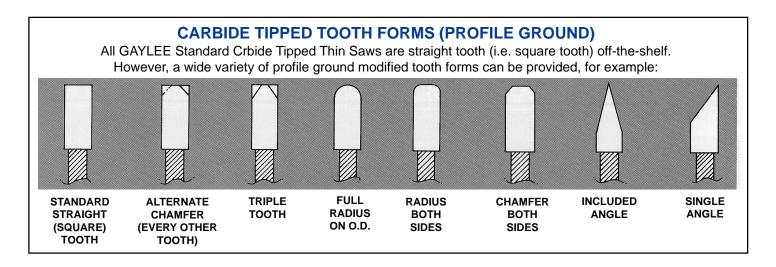
Modified standard cutters usually offer substantial cost savings over specialty manufactured tools. Pricing on modified standard cutters is based on quantities and degree of modifications required. Call GAYLEE to discuss the many modifications possible, depending on your application.

CUTTING WIDTH OR THICKNESS can be adjusted to the exact dimension needed.

- > "GPP" and "GSS" cutters listed on pages 15-18 can be modified to any exact width between .040" and .375". Carbide tipped cutters on other pages of 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/-.0000). 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.



Economical cutters for roughing and short-run cutting of cast iron, non-ferrous metals, and non-metallics.

STANDARD TOLERANCES SAW

DIAMETER: +.015" -.000"

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

SIDE RUN-OUT LESS THAN .0005"

THICKNESS: +.0010" -.0000" 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 run-out) 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. All sizes are normally available from stock for immediate delivery.

NOTE: COARSE-TOOTH CUTTERS are the lowest priced carbide tipped tools made by Gaylee. Cost savings are achieved 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 "GPP" Standard Carbide Tipped Thinsaws on pages 15-16.

Aluminum-Copper-Plastics-Hard Rubber-Bakelite-Fiber

SAW	ARBOR	· · · · · · · · · · · · · · · · · · ·	SAW WIDTH		NO. OF	EDP	
DIA.	HOLE SIZE	Fraction Decimal mm			TEETH	NUMBER	
		1/4	.2500	6.350	4	CNF 3140-1	
3"	1"	5/16	.3125	7.9375	4	CNF 3516-1	
		3/8	.3750	9.525	4	CNF 3380-1	
		3/32	.0938	2.381	6	CNF 4332-1	
		1/8	.1250	3.175	6	CNF 4180-1	
4"	1"	3/16	.1875	4.763	6	CNF 4316-1	
		1/4	.2500	6.350	6	CNF 4140-1	
		5/16	.3125	7.9375	6	CNF 4516-1	
	;	3/8	.3750	9.525	6	CNF 4380-1	
	1.25"	3/8	.3750	9.525	6	CNF 4380-1.25	
6"	1.25"	1/8	.1250	3.175	8	CNF 6180-1.25	
8"	1.25"	1/8	.1250	3.175	10	CNF 8180-1.25	

SAW	ARBOR		SAW WIDTH	NO. OF	EDP	
DIA.	HOLE SIZE	Fraction	Decimal	mm	TEETH	NUMBER
		1/4	.2500	6.350	6	CCI 3140-1
3"	1"	5/16	.3125	7.9375	6	CCI 3516-1
		3/8	.3750	9.525	6	CCI 3380-1
		1/8	.1250	3.175	8	CCI 4180-1
		3/16	.1875	4.763	8	CCI 4316-1
4"	1"	1/4	.2500	6.350	8	CCI 4140-1
		5/16	.3125	7.9375	8	CCI 4516-1
		3/8	.3750	9.525	8	CCI 4380-1
	1.25"	3/8	.3750	9.525	8	CCI 4380-1.25
		1/8	.1250	3.175	12	CCI 6180-1.25
6"	1.25"	3/16	.1875	4.763	12	CCI 6316-1.25
		1/4	.2500	6.350	12	CCI 6140-1.25
i		3/16	.1875	4.763	16	CCI 8316-1.25
8"	1.25"	1/4	.2500	6.350	16	CCI 8140-1.25

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

✓ Cast Iron ✓ Malleable Iron ✓ Aluminum ✓ Copper
✓ Brass ✓ Other Non-Ferrous Metals ✓ Plastics
✓ Bakelite ✓ Hard Rubber ✓ Composites
✓ Non-Metallics ✓ 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. All sizes listed are normally available from stock for immediate delivery. Contact Gaylee with your requirements.

SAW	ARBOR		SAW WIDTH		NO. OF	EDP
DIA.	HOLE SIZE	Fraction	Decimal	TEETH	NUMBER	
		3/64	.0469	mm 1.191	12	GPP 3364-1
		1/16	.0625	1.588	12	GPP 3116-1
		5/64	.0781	1.984	12	GPP 3564-1
		3/32	.0938	2.381	12	GPP 3332-1
		7/64	.1094	2.7781	12	GPP 3764-1
3"	1"	1/8	.1250	3.175	12	GPP 3180-1
		5/32	.1563	3.969	12	GPP 3532-1
		3/16	.1875	4.763	12	GPP 3316-1
		7/32	.2188	5.556	12	GPP 3732-1
		1/4	.2500	6.350	12	GPP 3140-1
		5/16	.3125	7.9375	12	GPP 3516-1
		3/8	.3750	9.525	12	GPP 3380-1
	1.25"	1/8	.1250	3.175	12	GPP 3180-1.25
•	5/8625"	1/16	.0625	1.588	14	GPP 4116-5/8
		3/64	.0469	1.191	14	GPP 4364-1
		3/64	.0469	1.191	30	GFT 4364-1
		1/16	.0625	1.588	14	GPP 4116-1
		1/16	.0625	1.588	20	GFT 4116-1
		5/64	.0781	1.984	14	GPP 4564-1
		3/32	.0938	2.381	14	GPP 4332-1
		7/64	.1094	2.7781	14	GPP 4764-1
	1 "	1/8	.1250	3.175	14	GPP 4180-1
		1/8	.1250	3.175	20	GFT 4180-1
		5/32	.1563	3.969	14	GPP 4532-1
		3/16	.1875	4.763	14	GPP 4316-1
4"		7/32	.2188	5.556	14	GPP 4732-1
		1/4	.2500	6.350	14	GPP 4140-1
		5/16	.3125	7.9375	14	GPP 4516-1
		3/8	.3750	9.525	14	GPP 4380-1
		3/64	.0469	1.191	14	GPP 4364-1.25
		1/16	.0625	1.588	14	GPP 4116-1.25
		5/64	.0781	1.984	14	GPP 4564-1.25
		3/32	.0938	2.381	14	GPP 4332-1.25
		7/64	.1094	2.7781	14	GPP 4764-1.25
	1.25"	1/8	.1250	3.175	14	GPP 4180-1.25
		5/32	.1563	3.969	14	GPP 4532-1.25
		3/16	.1875	4.763	14	GPP 4316-1.25
	1	7/32	.2188	5.556	14	GPP 4732-1.25
		1/4	.2500	6.350	14	GPP 4140-1.25
		5/16	.3125	7.9375	14	GPP 4516-1.25
		3/8	.3750	9.525	14	GPP 4380-1.25

STANDARD	
TOLERANCES	
SAW	
DIAMETER:	
+.015"	
000"	
ARBOR HOLE	
DIAMETER:	
+.0005"	
0000"	
SIDE RUN-OUT	
LESS THAN	
.0005"	
THICKNESS:	
+.0010"	
0000"	

Cont.

GAYLEE CARBIDE TIPPED THIN SAWS

Γ	STANDARD
-	TOLERANCES
Γ	SAW
	DIAMETER:
	+.015"
	000"
Γ	ARBOR HOLE
	DIAMETER:
	+.0005"
L	0000"
	SIDE RUN-OUT
	LESS THAN
	.0005"
	THICKNESS:
	+.0010"
L	0000"

SAW	age 15 ARBOR	T	SAW WIDTH		NO. OF	EDP
DIA.	HOLE SIZE	Fraction	Decimal Decimal	mm	TEETH	NUMBER
DIA.	HOLE SIZE	3/64	.0469	1.191	16	GPP 5364-1
		1/16	.0625	1.588	16	GPP 5116-1
		5/64	.0023	1.984	16	GPP 5564-1
			.0781	I	16	E .
		3/32		2.381		GPP 5332-1
	1"	7/64	.1094	2.7781	16	GPP 5764-1
	1"	1/8	.1250	3.175	16	GPP 5180-1
		5/32	.1563	3.969	- 16	GPP 5532-1
		3/16	.1875	4.763	16	GPP 5316-1
		7/32	.2188	5.556	16	GPP 5732-1
		1/4	.2500	6.350	16	GPP 5140-1
		5/16	.3125	7.935	16	GPP 5516-1
5"		3/8	.3750	9.525	16	GPP 5380-1
		3/64	.0469	1.191	16	GPP 5364-1.25
		1/16	.0625	1.588	16	GPP 5116-1.25
		5/64	.0781	1.984	16	GPP 5564-1.25
		3/32	.0938	2.381	16	GPP 5332-1.25
		7/64	.1094	2.7781	16	GPP 5764-1.25
		1/8	.1250	3.175	16	GPP 5180-1.25
		5/32	1563	3.969	16	GPP 5532-1.25
	1.25"	3/16	.1875	4.763	16	GPP 5316-1.25
	1.29	7/32	.2188	5.556	16	GPP 5732-1.25
		1/4	.2500	6.350	16	GPP 5140-1.25
		5/16				
			.3125	7.9375	16	GPP 5516-1.25
		3/8	.3750	9.525	16	GPP 5380-1.25
		3/64	.0469	1.191	18	GPP 6364-1
		1/16	.0625	1.588	18	GPP 6116-1
		5/64	.0781	1.984	18	GPP 6564-1
		3/32	.0938	2.381	18	GPP 6332-1
		7/64	.1094	2.7781	18	GPP 6764-1
		1/8	.1250	3.175	18	GPP 6180-1
	1"	5/32	.1563	3.969	18	GPP 6532-1
		3/16	.1875	4.763	18	GPP 6316-1
		7/32	.2188	5.556	18	GPP 6732-1
	*	1/4	.2500	6.350	18	GPP 6140-1
		5/16	.3125	7.9375	18	GPP 6516-1
6"		3/8	.3750	9.525	18	GPP 6380-1
_		3/64	.0469	1.191	18	GPP 6364-1.25
		1/16	.0625	1.588	18	GPP 6116-1.25
		5/64	.0781	1.984	18	GPP 6564-1.25
	N.,	3/32	.0938	2.381	18	GPP 6332-1.25
		7/64	.1094	2.7781	18	GPP 6764-1.25
	1 25"	1/8		}		
	1.25"		.1250	3.175	18	GPP 6180-1.25
		5/32	.1563	3.969	18	GPP 6532-1.25
		3/16	.1875	4.763	18	GPP 6316-1.25
		7/32	.2188	5.556	18	GPP 6732-1.25
		1/4	.2500	6.350	18	GPP 6140-1.25
		5/16	.3125	7.9375	18	GPP 6516-1.25
		3/8	.3750	9.525	18	GPP 6380-1.25
		1/8	.1250	3.175	24	GPP 8180-1.25
8"	1.25"	5/32	.1563	3.969	24	GPP 8532-1.25
_		3/16	.1875	4.763	24	GPP 8316-1.25
		1/4	.2500	6.350	24	GPP 8140-1.25
	1.00"	1/4	.1250	3.175	72	GFT 1180-1.00
	1.00	1/8	.1250	3.175	32	GPP 1180-1.25
10"			1 1/30	. 3.173	ا عد	・ ソファン・ロック・レング・
10"	1.25"	3/16	.1875	4.763	32	GPP 1316-1.25

CARBIDE TIPPED THIN SAWS

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

✓ CUTTING STAINLESS STEELS - AISI TYPES 200 - 350

(AUSTENITIC STAINLESS STEELS)

Note: For stainless steels other than AISI Types 200 through 350, we recommend using "STL" Cutters on page 19.

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. All sizes are normally available from stock for one-day delivery.

SAW	ARBOR		SAW WIDTH		NO. OF	EDP	NO. OF	EDP
DIA.	HOLE SIZE	Fraction	Decimal	mm	TEETH	NUMBER	TEETH	NUMBER
		3/64	.0469	1.191			12	GSS 3364
		1/16	.0625	1.588			12	GSS 3116
		5/64	.0781	1.984			12	GSS 3564
		3/32	.0938	2.381	8	CSS 3332	12	GSS 3332
		7/64	.1094	2.7781			12	GSS 3764
3"	1"	1/8	.1250	3.175	8	CSS 3180	12	GSS 3180
	1 1	5/32	.1563	3.969			12	GSS 3532
		3/16	.1875	4.763	8	CSS 3316	12	GSS 3316
		7/32	.2188	5.556			12	GSS 3732
		1/4	.2500	6.350	8	CSS 3140	12	GSS 3140
		5/16	.3125	7.9375	8	CSS 3516	12	GSS 3516
		3/8	.3750	9.525	8	CSS 3380	12	GSS 3380
	1.25"	1/8	.1250	3.175			12	GSS 3180-1.25
	5/8"625"	1/16	.0625	1.588			14	GSS 4116-5/8
,		3/64	.0469	1.191			14	GSS 4364-1
		3/64	.0469	1.191			30	GFS 4364-1
		1/16	.0625	1.588			14	GSS 4116-1
		1/16	.0625	1.588			20	GFS 4116-1
		5/64	.0781	1.984			14	GSS 4564-1
		3/32	.0938	2.381	10	CSS 4332-1	14	GSS 4332-1
		7/64	.1094	2.7781			14	GSS 4764-1
	1"	1/8	.1250	3.175	10	CSS 4180-1	14	GSS 4180-1
<u> </u>	+ 5	1/8	.1250	3.175			20	GFS 4180-1
		5/32	.1563	3.969			14	GSS 4532-1
		3/16	.1875	4.763	10	CSS 4316-1	14	GSS 4316-1
4"		7/32	.2188	5.556			14	GSS 4732-1
		1/4	.2500	6.350	10	CSS 4140-1	14	GSS 4140-1
		5/16	.3125	7.9375	10	CSS 4516-1	14	GSS 4516-1
		3/8	.3750	9.525	10	CSS 4380-1	14	GSS 4380-1
		3/64	.0469	1.191		·	14	GSS 4364-1.25
		1/16	.0625	1.588			14	GSS 4116-1.25
		5/64	.0781	1.984			14	GSS 4564-1.25
		3/32	.0938	2.381			14	GSS 4332-1.25
		7/64	.1094	2.7781			14	GSS 4764-1.25
	1.25"	1/8	.1250	3.175			14	GSS 4180-1.25
		5/32	.1563	3.969			14	GSS 4532-1.25
		3/16	.1875	4.763			14	GSS 4316-1.25
		7/32	.2188	5.556			14	GSS 4732-1.25
		1/4	.2500	6.350			14	GSS 4140-1.25
		5/16	.3125	7.9375			14	GSS 4516-1.25
		3/8	.3750	9.525	10	CSS 4380-1.25	14	GSS 4380-1.25

STANDARD
TOLERANCES
SAW
DIAMETER:
+.015"
000"
ARBOR HOLE
DIAMETER:
+.0005"
0000"
SIDE RUN-OUT
LESS THAN
.0005"
THICKNESS:
+.0010"

-.0000"

Cont.

CARBIDE TIPPED THIN SAWS

STANDARD **TOLERANCES** SAW DIAMETER: +.015" -.000" ARBOR HOLE DIAMETER: +.0005" -.0000" SIDE RUN-OUT LESS THAN .0005" THICKNESS: +.0010" -.0000"

	m page 17							1
SAW	ARBOR		SAW WIDTH		NO. OF	EDP	NO. OF	EDP
DIA.	HOLE SIZE	Fraction	Decimal	mm	TEETH	NUMBER	TEETH	NUMBER CCC FOCA 1
		3/64	.0469	1.191			16	GSS 5364-1
		1/16	.0625	1.588			16	GSS 5116-1 GSS 5564-1
		5/64	.0781	1.984	12	CSS 5332-1	16 16	GSS 5364-1
		3/32	.0938	2.381	12	000 0002-1	16	GSS 5564-1
	1"	7/64	.1094	2.7781	40	CCC 5100 1		1
	•	1/8	.1250	3.175	12	CSS 5180-1	16	GSS 5180-1
		5/32	.1563	3.969	10	CCC 5216 1	16 16	GSS 5532-1 GSS 5316-1
		3/16	.1875 .2188	4.763	12	CSS 5316-1	16 16	GSS 5732-1
		7/32 1/4	.2500	5.556 6.350			16	GSS 5732-1
		5/16	.3125	7.9375			16	GSS 5516-1
5"								
5"		3/8	.3750	9.525		-	16 16	GSS 5380-1 GSS 5364-1.25
		3/64	.0469	1.191				
		1/16	.0625	1.588			16	GSS 5116-1.25 GSS 5564-1.25
		5/64	.0781 .0938	1.984 2.381			16 16	GSS 5304-1.25
		3/32 7/64	.1094	2.7781			16	GSS 5764-1.25
	1.05	!		ì				
	1.25"	1/8	.1250	3.175			16	GSS 5180-1.25
		5/32	.1563	3.969			16 16	GSS 5532-1.25 GSS 5316-1.25
		3/16	.1875	4.763 5.556			16	GSS 5732-1.25
		7/32 1/4	.2188	6.350			16	GSS 5732-1.25
		5/16	.2500 .3125	7.9375			16	GSS 5516-1.25
			1					
		3/8	.3750	9.525			16 18	GSS 5380-1.25 GSS 6364-1
		3/64 1/16	.0469 .0625	1.191 1.588			18	GSS 6304-1
		5/64	.0023	1.984			18	GSS 6564-1
		3/32	.0938	2.381			18	GSS 6332-1
		7/64	.1094	2.7781			18	GSS 6764-1
	1"	1/8	.1250	3.175		,	18	GSS 6180-1
	•	5/32	.1563	3.969		1	18	GSS 6532-1
		3/16	.1875	4.763		1	18	GSS 6316-1
		7/32	.2188	5.556			18	GSS 6732-1
		1/4	.2500	6.350			18	GSS 6140-1
		5/16	.3125	7.9375			18	GSS 6516-1
6"		3/8	.3750	9.525	1		18	GSS 6380-1
		3/64	.0469	1.191			18	GSS 6364-1.25
		1/16	.0625	1.588			18	GSS 6116-1.25
		5/64	.0781	1.984			18	GSS 6564-1.25
		3/32	.0938	2.381			18	GSS 6332-1.25
		7/64	.1094	2.7781			18	GSS 6764-1.25
	1.25"	1/8	.1250	3.175	14	CSS 6180-1.25	18	GSS 6180-1.25
	1.20	5/32	.1563	3.969	''		18	GSS 6532-1.25
		3/16	.1875	4.763	14	CSS 6316-1.25	18	GSS 6316-1.25
		7/32	.2188	5.556			18	GSS 6732-1.25
		1/4	.2500	6.350	14	CSS 6140-1.25	18	GSS 6140-1.25
		5/16	.3125	7.9375			18	GSS 6516-1.25
		3/8	.3750	9.525			18	GSS 6380-1.25
		1/8	.1250	3.175	 		24	GSS 8180-1.25
8"	1.25"	5/32	.1563	3.969			24	GSS 8532-1.25
		3/16	.1875	4.763			24	GSS 8316-1.25
	1	1/4	.2500	6.350			24	GSS 8140-1.25
	1.00"	 		· 	 	+	72	GFS 1180-1.00
40"		1/8	.1250	3.175				
10"	1.25"	1/8	.1250	3.175			32	GSS 1180-1.25
	J.,	3/16	.1875	4.763	<u> </u>	<u> </u>	32	GSS 1316.125

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

✓ STEEL CUTTING APPLICATIONS

Note: On Stainless Steel AISI Types 200 thru 350: Order "GSS" cutters on pages 17-18. For all other types of Stainless Steel, order "STL" cutters from this page.

STEEL CUTTING Gaylee 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. All sizes are normally available from stock for immediate delivery.

SAW	ARBOR		SAW WIDTI		NO. OF	EDP	NO. OF	EDP	NO. OF	EDP
DIA.	HOLE SIZE	Fraction	Decimal	mm	TEETH		TEETH	NUMBER	TEETH	1
		3/64	.0469	1.191	1		122111	HOMBER		
		1/16	.0625	1.588	•		12	MST 3116-1	16	STL 3364-1
		5/64	.0781	1.984			'2	W313110-1	16	STL 3116-1
		3/32	.0938	2.381			12	MST 3332-1	16	STL 3564-1
•		1/8	.1250	3.175			12	MST 3332-1	16	STL 3332-1
3"	1"	5/32	.1563	3.969			12	MST 3532-1	16 16	STL 3180-1 STL 3532-1
		3/16	.1875	4.763			12			
		7/32	.2188	5.556	Ī		12	MST 3316-1	16	STL 3316-1
		1/4	.2500	6.350	6	CST 3140-1			16	STL 3732-1
		5/16	.3125	7.9375	6	CST 3516-1			16	STL 3140-1
	:	3/8	.3750	9.525	6	CST 3316-1				
		1/16	.0625	1.588	-	031 3360-1	14	MOT 4440.4		071 1115
		3/32	.0938	2.381			14	MST 4116-1	20	STL 4116-1
	-1"	1/8	.1250	3.175	8	CST 4180-1	14	MST 4332-1	20	STL 4332-1
	-	3/16	.1875		l			MST 4180-1	20	STL 4180-1
4"		1/4	.2500	4.763 6.350	8	CST 4316-1	14	MST 4316-1	20	STL 4316-1
•						CST 4140-1			20	STL 4140-1
		5/16 3/8	.3125	7.9375	8	CST 4516-1				
		1/8	.3750	9.525	8	CST 4380-1				
		3/16	.1250	3.175					20	STL 4180-1.25
	1.25"	1/4	.1875 .2500	4.763 6.350		CCT 4440 4 05			20	STL 4316-1.25
	1120	3/8			8	CST 4140-1.25			20	STL 4140-1.25
		1/16	.3750	9.525	8	CST 4380-1.25				
	1"	3/32	.0625 .0938	1.588 2.381				MST 5116-1	24	STL 5116-1
	•	1/8						MST 5332-1	24	STL 5332-1
5"		3/16	.1250 .1875	3.175 4.763				MST 5180-1	24	STL 5180-1
Ĭ					4		16	MST 5316-1	24	STL 5316-1
	1.25"	3/32 1/8	.0938	2.381 3.175				·	24	STL 5332-1.25
	0	3/16							24	STL 5180-1.25
			.1875	4.763				MST 5316-1.25		STL 5316-1.25
*	1"	1/16 3/32	.0625	1.588 2.381			I	MST 6116-1		STL 6116-1
i	•							MST 6332-1		STL 6332-1
		1/8	.1250	3.175				MST 6180-1	28	STL 6180-1
6"		3/16 1/16	.1875	4.763				MST 6316-1		STL 6316-1
			.0625	1.588				MST 6116-1.25		STL 6116-1.25
	1.25"	3/32	.0938	2.381	,	OOT 0465 : 5=		MST 6332-1.25		STL 6332-1.25
	1.20	1/8	.1250	3.175		CST 6180-1.25		MST 6180-1.25		STL 6180-1.25
ļ		3/16	.1875	4.763	i	CST 6316-1.25	Į.	MST 6316-1.25	1	STL 6316-1.25
		1/4	.2500	6.350		CST 6140-1.25	18	MST 6140-1.25	28	STL 6140-1.25
8"	1.25"	3/16	.1875	4.763	j	CST 8316-1.25				
U	1.25	1/4	.2500	6.350	16	CST 8140-1.25				

TOLERANCES
CAVA
SAW
DIAMETER:
+.015"
000"
ARBOR HOLE
DIAMETER:
+.0005"
0000"
SIDE RUN-OUT
LESS THAN
.0005"
THICKNESS:
+.0010"
0000"

MODIFIED & SPECIAL THIN SAWS AND CUTTERS

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 tools. In addition, modified standard cutters usually offer substantial cost savings over specially manufactured tools. Prices of modified and special cutters are quoted on quantities required.



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

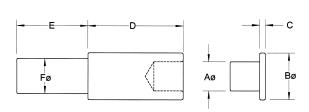
If your application requires a modified or special cutter, as much information as possible concerning your application should be supplied:

✓ Saw Diameter ✓ Number of Teeth ✓ Keyway Dimension
✓ Work Material ✓ Depth of Cut ✓ Tolerance Required
✓ Form to be Generated ✓ Arbor (Hole) Size ✓ Slot Width ✓ Hub Width
✓ Hub Diameter ✓ Machine Used ✓ Rockwell Hardness
✓ Present Cutter Used ✓ Results Being Obtained With Present Cutter
✓ Speed(s) RPM ✓ Feeds (SFM,CPI and/or IPR)

✓ Special Tooth Configuration
✓ Are Saws To Be Used In Gang Configuration

A FAX of a sketch showing your part and/or the saw now in use would be most helpful in making our recommendations. Include any notes or comments pertinent to the application at hand.

GAYLEESTUB ARBORS FOR SAWS



EDP#	SAW ID	Α	В	С	D	Е	F
GRA250	1/4"	.250	.500	.080	1.000	1.700	.500
GRA375	3/8"	.375	.625	.080	1.180	1.700	.500
GRA500	1/2"	.500	.750	.095	1.370	1.700	.500
GRA625	5/8"	.625	1.000	.122	1.500	2.030	.750
GRA100	1"	1.000	1.500	.160	1.750	2.030	.750
GRA125	1-1/4"	1.250	1.750	.220	2.000	2.030	.750

- High accuracy, general purpose slitting/sawing applications.
- Vibration absorbing design.
- Weldon shanks.





- Deep sleeve design allows extra support and less slippage of saw/cutter.
- Hardened and ground to .002" concentricity. Tighter tolerances (to .0004") available.

SURFACE FEET PER MINUTE (SFM) RECOMMENDATIONS* FOR CUTTING VARIOUS MATERIALS USING CIRCULAR CARBIDE SAWS

*These are general recommendations on SFM rates, and may vary from application to application.

We do not assume any liability in the following recommendations which are basicly suggestions on where to start.

If you have questions regarding speeds and feeds when using Gaylee saws, contact Gaylee Corp. directly.

Material To Be Cut: Cast Iron - Annealed - Scale Removed

	Cast Iron Class*			
	20 to 30	<u>35-50</u>	60 to 80	
Cutter Material				
C2 CARBIDE	250-500 SFM	200-450 SFM	150-350 SFM	
COATED CARBIDE	300-700 SFM	250-550 SFM	200-450 SFM	

NOTE: *"Cast Iron Class" refers to the material PSI; i.e. 30 is a minimum of 30,000 PSI. Class 60 and 80 (80,000 PSI) are nodular (ductile) cast irons which are distinguished by a spheroidal graphite and higher ductility. Reduce descaling cuts by 50%. Avoid "as cast" milling operations. Cutting fluids are required for these SFM speeds.

Material To Be Cut: I	Brass & Bronze						
Cutter Material	Annealed Cast Brass	Cold <u>Drawn Bar</u>	Free <u>Cutting Bar</u>	Manganese <u>Bronze</u>			
C2 CARBIDE COATED CARBIDE	500-900 SFM 750-1500 SFM	400-800 SFM 500-1000 SFM	100-150 SFM 800-1200 SFM	250-400 SFM 350-500 SFM			
Material To Be Cut: Aluminum Alloys							
Cutter Material	As Cast	Cast and <u>Heat Treated</u>	2024 T6 <u>6061 T6</u>	7075 T6			
C2 CARBIDE COATED CARBIDE	1200-2000 SFM 1500-2500 SFM	1000-1800 SFM 1250-2250 SFM	1000-1800 SFM 1250-2250 SFM	800-1500 SFM 1000-1875 SFM			

Material To Be Cut: Steel & Steel Alloys

APPROXIMATE BRINELL (BHN) HARDNESS REFERENCE CHART					
STEEL ALLOYS BHN	STAINLESS STEELS	BHN			
1018-1020 120-140	303	155-165			
1045-1050 180-225	302-304	160-175			
C12L14 155-160	316	160-175			
C1215 165-170	321	145-155			
STRESSPROOF 250-260	347				
6150 190-205	410				
8620 HR 170, CR 220	416				
52100 220-225	440C				
4130 255-265	15-5	310-350			
4140 HR 190, CR 240, HT 290	17-4				
4340 HR 230, CR 250, HT 340	17-7				

Material Hardness: BHN / Rc (use above chart as reference).

	150-200 BHN	205-230 BHN/	231-258 BHN/	264-301 BHN/	311-400 BHN/
	<u>13 Rc</u>	<u>14-21 Rc</u>	21-26 Rc	<u>27-32 Rc</u>	33-43 Rc
Cutter Material C2 CARBIDE COATED CARBIDE	250-450 SFM	225-425 SFM	200-400 SFM	150-350 SFM	125-250 SFM
	400-600 SFM	300-400 SFM	250-500 SFM	200-400 SFM	150-300 SFM

www.newmantools.com tel 1-800-465-1384 fax 1-800-605-2442

THESE HIGH PRECISION GAYLEE THIN SAWS & CUTTERS ARE DISTRIBUTED BY:

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