

# Custom Saw Bodies and Solid Tooth Blades

The following section covers the basic dimensions of your custom saw body.

## \*Diameter

Peerless makes saw bodies from just under 4" through just under 40" diameter. Custom saw bodies are made to the exact diameter ordered, unless the customer instructs us differently. Stock inventory is normally made at 1/16" less than nominal size, however some sizes are listed special to match specific machines.

Standard diameter tolerance on our laser cut bodies is +/- .010". If required, some products can be turned to tighter tolerances, per your request.

## \*Thickness

Saw bodies and saw blades can be supplied in several different thickness styles:

- Flat Ground, where the bodies measure the same thickness at all points.
- Thin Rimmed, where the rim is ground thinner than the hub area of the body.
- Hollow Ground, where the outer rim and hub are the same thickness, but the body is ground thinner, usually starting just below the periphery, to allow body clearance beneath the tooth.

## Flat Ground

The maximum thickness of laser cut bodies is usually about .250", however, tooth count and design will dictate the real limit, per your specs. The minimum thickness of any particular body is determined by its diameter. Your friends at Peerless can discuss these minimums on application.

Standard saw bodies are surface ground flat to a tolerance of +/- .002". Tighter tolerances of +/- .001" or even, +.000"/-.001" are available upon request.

Thickness is commonly discussed in one of four measurement scales:

1. Inch decimals in three digits: for example: .083" (Most common for flat ground saw bodies.)

2. Saw Gauges (Birmingham or Stubs): 14 gauge (.083") (common in steel tooth blades that are set and sharpened.) Here, we show a list of the Birmingham gauge scale, most commonly used in the American saw blade industry.

3. Inch Fractions: 1/16" (Common in H.G. Metal Cutting Saw Blades)

4. Metric, described in millimeters: 3.2mm (converted to .126" inch decimal)

However your thickness is described, we will usually convert the size to inch decimals. Unless instructed differently, we will make the body to the exact diameter you specify and the standard tolerance, as listed below.



### Birmingham Gauge (Thickness) Scale

Gauge	Decimal
1	.300"
2	.284"
3	.259"
4	.238"
5	.220"
6	.203"
7	.180"
8	.165"
9	.148"
10	.134"
11	.120"
12	.109"
13	.095"
14	.083"
15	.072"
16	.065"
17	.058"
18	.049"
19	.042"
20	.035"
21	.032"
22	.028"
23	.025"
24	.022"
25	.020"
26	.018"
27	.016"
28	.014"
29	.013"
30	.012"

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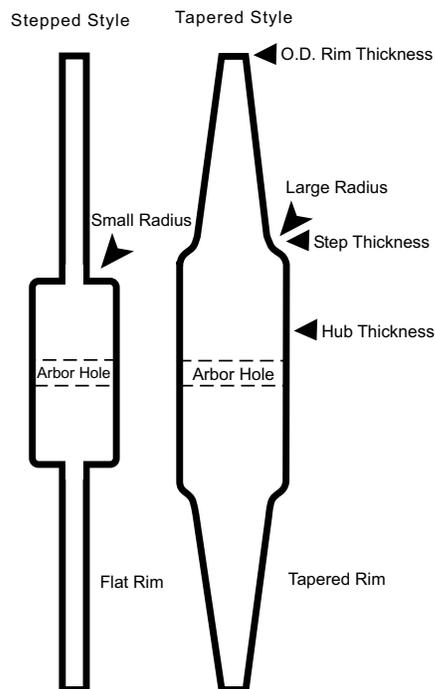
### Thin Rimmed Saws for Tips

Thin kerf requirements are met with Peerless thin rimmed saw bodies. When ordering "Stepped Style" thin rimmed bodies, we need to know the following:

1. Specify the hub thickness (.120"), followed by rim thickness (.083") and hub diameter and side. For example: .120" hub, .083" rim, 6-1/2" left hand hub.

2. Hub side: If you wish the rim to be ground thin on both sides, order "double hub". If the rim is to be on one side only, you must specify left or right. These sides are determined by holding the body vertical, with the face of the teeth turning over the top, toward you. Another method is when the blade is lying down flat on a bench before you, the left side is on top when the blade is turning clockwise, right is on top when the blade is turning counter-clockwise. Example: .120" hub / .083" rim, 6-1/2" left hand hub.

"Tapered Style" thin rimmed bodies require the same data, plus additional information as illustrated in the drawings below.



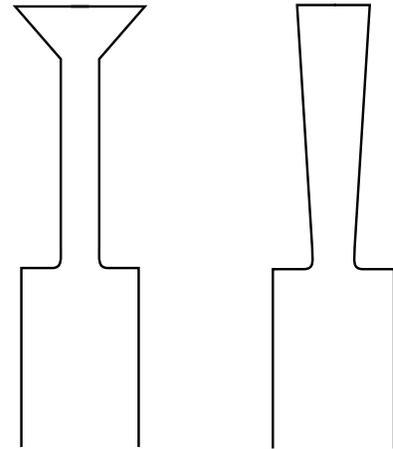
### Polish, Plating & Surface Treatments

Peerless saw bodies are ground to a smooth, consistent surface finish. We can also provide a premium polished finish to approximately 17 RMS, per your request. We can also provide surface treatments, like Chrome plating, Nickel Boron coating or TIN coating. "Blue", "Gold" & "True Blue" finishes result from final stress relieving when requested.

### Hollow Ground

Special hollow ground and reverse thin rim bodies are available upon request.

Standard options for hollow ground bodies are as follows:



Gouge or Mitre Style

Straight Taper Style

1. Gouge or Mitre Style has all of the relief ground in the first 1/2" depth from the outside diameter. On steel tooth blades, this style gives the most relief clearance possible. One drawback is that as the diameter is reduced by sharpening, side clearance is reduced, also.

2. Straight Taper Style has a gradual clearance relief, steadily reducing all the way to the hub. This style doesn't give as much relief just below the teeth, but does allow consistent relief as the body is sharpened and the diameter is reduced.