

Vernon-Vanier Abrasive Saw Cut Time Calculations

Assume: **0.0328 Cu. In. per Second Removal**
 0.156 Inch Blade Thickness

<u>Pipe Size</u>	<u>O.D.</u>	<u>Wall Thickness</u>	<u>Time (in seconds)</u>	Vanier	
				<u>Calculated Time to Cut</u>	<u>Estimated Times to Cut to Bevel</u>
				<u>Time (seconds)</u>	<u>Time (seconds)</u>
2" S40	2.375	0.154	5.1	5	3
2-1/2" S40	2.875	0.203	8.1	7	3
3" S40	3.500	0.216	10.6	10	4
4" S40	4.500	0.237	15.1	15	5
5" S40	5.563	0.258	20.5	20	7
6" S40	6.625	0.280	26.6	30	10
8" S40	8.625	0.322	40.0	45	15
10" S40	10.750	0.365	56.7	60	30
12" SSTD	12.750	0.375	69.5	90	35
14" SSTD	14.000	0.375	76.5	120	40
16" SSTD	16.000	0.375	87.7		
18" SSTD	18.000	0.375	98.9		
20" SSTD	20.000	0.375	110.1		
24" SSTD	24.000	0.375	132.6		

