

BANDSAW SPEEDS AND FEEDS FOR BI-METAL BLADES

Material Size	Up to 25mm (1")		From 25 to 76mm (1-3")		From 76-150mm (3-6")		Over 150mm (6")	
Suggested tooth pitch	8/12,10/14		5/8, 6/10, 8/12		3/4, 4/6, 5/8		1.1/1.4, 1.5/1.9, 2/3, 3/4	
	Blade Speed	Cutting Rate	Blade Speed	Cutting Rate	Blade Speed	Cutting Rate	Blade Speed	Cutting Rate
	(SFPM)	(SIPM)	(SFPM)	(SIPM)	(SFPM)	(SIPM)	(SFPM)	(SIPM)
Carbon Steel:								
1008-1013	250	8-10	275	9-12	280	12-15	250	9-12
1015-1018	250	8-10	275	9-12	250	12-15	230	12-15
1048-1065	200	5-7	200	5-7	175	5-10	150	5-10
1065-1095	200	4-6	200	5-7	150	6-8	120	6-8
Free Machining Steels								
1108-1111	300	9-11	330	12-14	275	13-15	220	11-14
1112-1113	300	8-11	330	11-13	275	12-15	220	12-15
1115-1132	300	7-10	330	10-13	275	13-16	220	11-14
1137-1151	275	6-8	250	8-10	250	8-11	200	7-10
1212-1213	300	8-10	320	11-13	300	13-15	255	11-14
Manganese Steels:								
1320-1330	250	5-7	250	5-8	200	8-11	175	7-10
1335-1345	250	5-7	225	5-7	200	7-9	175	5-8
Nickel Steels:								
2317-	270	4-5	270	4-6	250	5-7	230	4-6
2330-2345	220	2-3	220	3-5	190	3-5	170	3-5
2512-2517	200	2-3	200	3-5	160	4-6	150	4-6
Nickel Chrome Steels:								
3115-3130	260	4-6	260	5-7	230	5-7	225	5-7
3135-3150	220	4-6	200	4-7	180	5-7	160	4-6
Molybdenum Steels:								
4017-4024	300	3-5	270	4-7	250	6-8	220	5-8
4032-4042	300	3-5	270	4-7	250	6-8	230	5-8
4047-4068	250	3-5	220	4-6	200	5-7	180	3-5
Chrome Moly Steels:								
4130-4140	280	4-6	250	5-8	250	8-10	220	6-8
4142-4150	230	3-5	200	4-6	200	5-7	170	4-6

H-12, H-13, H-21	150	2-4	125	3-5	125	2-4	125	2-4
H-22, H-24, H-25	150	1-3	125	1-3	125	1-3	125	1-3
Shock Resisting Tool Steels:								
S-1	220	2-4	180	3-5	165	3-5	150	2-4
S-2, S-5	170	1-3	150	2-4	120	2-4	100	1-3
Special Purpose Tool Steels:								
L-6	200	2-4	180	3-5	170	3-5	150	2-4
L-7	200	2-4	180	3-5	150	3-5	100	2-4
Stainless Steels:								
201, 202, 302, 304	120	2-4	100	2-4	100	2-4	100	1-3
303, 303F	140	2-4	120	2-4	100	3-5	100	2-4
308, 309, 310, 330	90	1	70	1	60	2	60	1
314, 316, 317	90	1	80	1	70	2	60	1
321, 347	130	1-3	110	1-3	100	2-4	80	1-3
410, 420, 420F	150	1-3	130	1-3	120	2-4	100	1-3
416, 430F	200	3-5	180	4-6	170	5-7	150	4-6
430, 446	100	1-3	90	2-4	80	2-4	80	1-3
440 A.B.C	120	1-3	100	1-3	90	2-4	70	1-3
A-7	100	1-3	100	1-3	120	2-4	100	1-3
17-4PH, 17- 7PH	100	2-3	90	2-4	80	3-4	80	2-3
Beryllium Copper:								
BHN-100-120	350	4-6	300	5-7	275	6-8	225	5-7
BHN-220-250	250	2-4	225	3-5	200	4-6	175	3-5
BHN-310-340	200	1-2	160	1-2	140	2-3	100	1-2
Nickel Based Alloys:								
Monel	100	1-2	100	1-2	80	1-2	60	1
R Monel	140	2-3	140	2-4	125	2-4	75	2-3
Inconel	110	1-2	100	1-3	80	1-3	80	1-2
Inconel X	90	1	80	1	70	1	60	1
Hastelloy A	120	1-2	100	1-2	85	1-2	75	1-2
Hastelloy B	110	0-1	100	1-2	90	1-2	75	0-1
Hastelloy C	100	0-1	90	0-1	70	0-1	60	0-1
Rene 41	90	1	90	1	90	1-2	90	1-2
Udimit	100	1	90	1-2	90	0-1	90	1-2
Waspalloy	90	1	90	1-2	90	1-2	90	1-2
Titanium	100	1-2	100	2-3	100	2-3	100	2-3

Titanium Alloys:								
TI-4AL-4MO alpha beta alloy	100	0-1	90	0-1	80	0-1	70	0-1
TI-14OA 2CR- 2MO	100	0-1	90	0-1	80	0-1	60	0-1
TI-150A	100	0-1	90	0-1	80	0-1	60	0-1
MST-6AL-4V	100	0-1	90	0-1	80	0-1	60	0-1
99% pure titanium	100	0-1	90	0-1	80	0-1	60	0-1