SPEED SELECTION GUIDE

FOR USE WITH BI-METAL BANDSAW BLADES (FOR CARBON BLADES REDUCE SPEED BY 50%)

MATERIAL	MATERIAL DESIGNATION	BAND SPEED (SFPM)			
		MATERIAL THICKNESS			
		Under 1"	1"- 3"	3" - 6"	Over 6"
STAINLESS STEELS					
Austenitic Stainless Steel	201 202 304 304L 304N 305	135	120	120	85
	308 309 309S 310 314 316 316L	95	85	85	65
	31BF 316N 317 330				
	321 347 348	130	115	110	80
	18-18-212	110	95	90	60
	NITRONIC 32 33 40 50 60	70	65	60	50
Martensitic Stainless Steel	403 410 420 420F	165	150	140	100
	440 ABC	120	110	100	85
	501 502	160	150	140	120
Ferritic Stainless Steel	405	130	130	120	110
	430F	180	160	150	130
	442 444 446	120	100	90	70
Free Machining Stainless Steel	303 303PB 303SE	165	145	140	95
	415 416SE	230	205	190	165
	420F 430F	180	160	150	140
	440F	190	170	160	130
Precipitation Hardening Stainless Steel	15-5PH 17-4PH 17-7PH AM350 AM355 PH1 3-8MO	105	95	80	50
NICKEL ALLOYS					
Iron Base	A286 Incoloy 800-801	125	105	90	65
	RA330 Incoloy 825	80	75	70	60
Nickel Base	Hastelloy B B-2 C C-22 C-276 C-4 F G G-2 G-3 G-30 N S W X	95	75	70	60
	Incoloy 802 804	115	95	90	
	Inconel 600 718	90	75	60	30
	Monel 400 401	110	85	75	
	Rene 41 Udimet 500	90	80	60	50
	Waspalloy	100	90	70	50
Cobalt Base	Astroloy M WF-11	85	75	65	50
Titanium Alloy	Ti-2Al-11Sn-5Zr-1mO Ti-5Al-2.4Sn Ti-6Al-2Sn-4Zr-2Mo	95	85	75	65
	Ti-6Al-4V	90	80	70	60
	Ti- 7Al-4Mo Ti-8Al-1Mo-1V	85	75	65	55
	Commercially Pure	100	90	80	60
CAST IRONS					
Gray Iron	Class 20			230	
	Class 40			180	
	Class 60			100	
Ductile Iron	60-40-18			240	
	80-55-06			160	
	120-90-02			90	
ALUMINUM ALLOY	Most			500	
COPPER ALLOYS					
Commercially pure	101	265	245	235	215
Berylliurn Cu	172	265	245	235	215
Leaded Cu	187	420	395	375	335
Red Brass	230	275	255	245	220
Cartridge Brass	260	275	255	245	220
Free Cutting Brass	360	515	470	450	405
Naval Brass	464	275	255	245	220
Commercial Bronze	222	265	245	235	215
Phosphor Bronze	510	265	245	235	215
Aluminum Bronze	623	300	280	265	240
Silicon Bronze	872	275	255	245	220