

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"
STEEL					
Structural Steel Shapes	A36 A242 A662	330	300	270	250
Carbon Steel	1008 - 1012	370	350	320	290
	1015 - 1035 1513 - 1536	370	350	320	300
	1036 - 1055	260	245	230	210
	1060 - 1080 1541 - 1572	245	230	200	155
	1084 - 1095	220	210	190	145
Free Machining Carbon Steel	1110 - 1118	365	335	335	280
	1137 - 1151	345	295	280	260
	1211 - 1215	435	415	400	350
Manganese Steels	1330 - 1345	260	240	215	195
Molybdenum Steels	4012 - 4024	340	300	285	250
	4027 - 4037	315	285	270	245
	4042 - 4068	275	230	210	190
Chrome - Moly Steels	4118 - 4130	310	275	270	240
	4137 - 4142	290	255	250	225
	4145 - 4161	245	225	210	185
	41L40	315	280	275	250
Nickel- Chrome- Moly Steels	4320 - 4340	265	235	225	180
	8615 - 8622	280	260	240	185
	8630 - 8637	260	240	220	165
	8640 - 8660	250	230	200	155
	9310	210	180	170	150
	9437 - 9445	250	220	210	170
	9747 - 9763	250	230	210	170
	9840 - 9850	240	220	210	170
Nickel - Moly Steels	4615 - 4626	290	270	250	210
	4812 - 4820	240	210	195	175
Chromium Steels	5040 - 5050	295	275	260	230
	5120 - 5135	290	255	245	195
	5140 - 5160	250	235	225	195
	50100 - 52100	210	175	165	125
Chrome Vanadium	6118	270	240	225	170
	6150	250	225	210	175
Silicon Steels	9255 - 9260	220	200	190	160
TOOL STEELS					
Cold Work Tool Steel	A2 A3 A6 A8 A9	235	210	195	175
	A4 A5 A10	180	170	160	140
	A7	100	90	80	70
	D2 D3 D4 D5	110	100	90	80
	D7	100	90	85	75
	O1 O2	235	225	200	185
	O6 O7	220	210	190	140
Hot Work Tool Steel	H10 H11 H12 H13 H14	230	200	190	160
	H19	195	175	165	135
	H21 H22 H23 H24 H25 H26 H42	190	180	160	135
Shock Resistant Tool Steel	S1	230	210	200	160
	S2 S5	175	160	140	120
	S7	160	145	125	105
Special Purpose Tool Steel	L2 L6	210	200	190	175
Water Hardening Tool Steel	W1 - W5	230	210	200	185
High Speed Tool Steel	M1 M2 M6 M7 M42	140	130	120	100
	M3 M4 M10 M30	120	110	100	80
	T1 T2	150	135	120	105
	T4 T5 T6	120	110	100	90
	T15	100	80	70	60