

## Blade Speed Chart

This machine is a powerful metal cutting saw and it would have no problem to cut you. You must treat the machine with respect to avoid any injuries.

### **BE CAREFUL! WORK SAFELY!**

- Do not operate any machine until you have read the manual and been instructed on all standard shop safety precautions.
- Keep away from all moving parts including but not limited to the following; saw blade, blade wheels, pulleys, v-belts, motor, etc.
- Never operate the machine unless all guards are in place.
- Machines are designed for use by only one operator; do not let two people work on the machine at the same time.
- Always keep the machine and your work area clean and remove all obstacles.
- Never load, unload stock or remove cut parts from the machine while the blade is running.
- Support long or heavy stock in the front and rear of the machine.
- Always clamp the stock securely before operating the machine.
- When changing the blade always wear gloves and safety glasses. Do not throw the blade into the air to uncoil. If you do not know how to uncoil the blade, get instructions from your blade supplier.
- Do not wear jewelry, gloves, loose clothing, and ties or have long hair unconfined while operating this machine.
- When performing maintenance work on the bandsaw machine always disconnect the power supply.
- Use the proper speeds, feeds and coolant as required.
- Do not let the coolant pump operate dry.
- Do not let the hydraulic level to become low.

The advice should be used as a guide only. All machines are unique so there may be differences. Adjustments to the machine must be only be done by qualified and trained personnel

- The following speeds are only an approximate starting value; contact your blade supplier for details.
- Do not start a new blade in an old cut.
- Do not start cut on a sharp edge if possible.
- Less than 5 teeth and more than 12 in the cut may cause the blade to break or the teeth strip.
- Proper blade break-in procedure will increase the blade life.

Check with your blade supplier for specific instructions.

<b><u>Material</u></b>	<b><u>Specificaiont</u></b>	<b><u>Speed Range (sfpm)</u></b>
Carbon steel	1015, 1018, 1020	300 to 350
	1040, 1045, 1050	190 to 250
	1065, 1075, 1095	150 to 170
Molybdenum Steel	4023, 4032, 4037	230 to 270
	4042, 4047, 4063	180 to 220
Chrome Molybdenum Steel	4120, 4130, 4140	185 to 210
	4320, 4337, 4340	180 to 230



Nickel Chrome Molybdenum Steel	8620, 8630, 8640, 8645, 8650, 8720, 8740, 8742, 8750	175 to 225
	9310, 9314	150 to 175
	9840, 9845, 9850	180 to 220
Nickel Molybdenum Steel	4615, 4620, 4640	210 to 240
	4812, 4815, 4820	175 to 190
Chrome Steel	5120, 5130, 5140	190 to 250
	5046, 5150, 5160	200 to 230
	50100, 51100, 52100	120 to 170
Tool Steel	M4, T4, T5	80 to 110
	M1, M2, M10	120 to 150
	T6, T8, M36	60 to 100
	T1, T2, M3	100 to 130
	T15, M15	50 to 75
	A2, A4, O7	170 to 200
	D2, D3, D4	90 to 120
	O1, O2	180 to 21
	O6	150 to 200
	W1, W2, W3	180 to 220
	H12, H13, H21	160 to 190
	H22, H24	130 to 160
	S1, S2, S5	110 to 180
	L2, L6, L7	120 to 170
Stainless Steel	201, 202, 301, 302, 304	80 to 120
	303, 303F	90 to 130
	308, 309, 310	60 to 80
	330, A286, Inconel	50 to 75
	314, 316, 317	60 to 80
	321, 347, 348	70 to 100
	416, 416F, 430F	110 to 150
	405, 430, 436	60 to 90
	414, 420, 431	50 to 90
	440A, 440B, 440C	70 to 110
	403, 410, 420F	80 to 110
	17-4PH, 17-7PH	60 to 90
Non-Ferrous Metals	Managanese Silicon, Bronze, Red Brass	200 to 300
	Phosphorus Bronze	200 to 250
	Aluminum Bronze, Naval Brass	150 to 200
	Beryllium Copper, Electircal Copper	200 to 275
	Aluminum Silicon, Phosphorus Bronze	125 to 175
	Manganese Bronze, Beryllium Copper (Hard)	90 to 140
	Monel, Inconel, Hastelloy	60 to 150
	4925Aa, 4911, 4926	70 to 110



	4900A, 4901B, 4902	60 o 90
Aluminum	2011, 2017, 6061, 2014, 2024, 7075	300 to 400
Structural Steel	Angles, Channels	200 to 300
Cast Iron	Gray Iron, Ductile Iron	150 to 200
Free Machining Steel	Leadloy	300 to 350
	1115, 1117	275 to 325
	1137, 1149	225 to 260