

Bi-Metal Bandsaw Blades

AHB TOOLING & MACHINERY

RECOMMENDED FEEDS, SPEEDS AND BLADE LIFE - BAND SAW BLADES

Family of Steel	Blade Speed (Ft / Min)	Feed Rate (Sq In / Min)	Blade Life (Sq Inches)	Approximate Cutting Times (Min.)		
				3" Square	6" Square	9" Square
Low-to-Mid Range Carbon & Free Machining Steels	210 - 260	12 - 20	10000 - 18000	0.45	2.25	6.75
Mid Carbon Alloy Materials	170 - 210	9 - 15	6000 - 9000	0.60	3.00	9.00
Tool & Die Steels	110 - 170	3 - 8	2000 - 5000	1.13	6.55	27.00
Stainless Steels	90 - 125	2 - 4	2000 - 4000	2.25	12.00	40.50
Nickel Based Steels	70 - 100	1 - 3	500 - 1900	3.00	18.00	81.00
Aluminum	300 - 400	18 - 25	15000 - 30000	0.36	1.67	4.50

Note: The above recommendations are general parameters provided to assist operators in determining proper feeds & speeds. Actual results may vary. Examples given are using 1 1/4" wide bi-metal bandsaw blade on medium to heavy duty bandsaw machine. Cutting rates could be increased or decreased by 10 - 20% by using narrower or wider saw blades accordingly. A high performance metalworking fluid should be considered on all sawing applications.