



Speeds and Feeds Carbide Tipped Band Saw Blades

Type of Material	Dim (FPM)	Speed (FPM)	Feed (IPM)	Cutting Time (h:min:sec)	Cutting Rate (sq/min)
INCONEL 718					
	4	79	0.33	0:12:01	1.03
	6	79	0.33	0:18:15	1.55
	8	79	0.33	0:24:10	2.07
17-4PH					
	4	82	0.38	0:10:23	1.21
	6	82	0.38	0:15:34	1.82
	8	82	0.38	0:20:46	2.42
WASPALLOY					
	4	79	0.33	0:12:10	1.03
	6	79	0.33	0:18:15	1.55
	8	79	0.33	0:24:20	2.07
P021					
	4	135	0.84	0:04:45	2.65
	6	135	0.84	0:07:07	3.97
	8	135	0.84	0:09:30	5.29
TITANIUM (T40)					
	4	148	0.77	0:05:11	2.42
	6	148	0.77	0:07:47	3.63
	8	148	0.77	0:10:23	4.84

Important Note:

Suggest reducing speed & feed around 10% every time you reduce widths (1-½" bands around 90% of 2" bands, 1-¼" bands around 90% of the 1-½" bands, etc.).

You **SAW** it here!



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