

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.

| <u>Material</u> | <u>Specificaiont</u> | <u>Speed Range (sfpm)</u> |
|-------------------------|-----------------------------|----------------------------------|
| 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 |

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|--------------------------------|--|------------|
| 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 |



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|----------------------|---------------------------------------|------------|
| | 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 |
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