



**SAWING PRODUCTS**

*Solutions For All Your Sawing Needs*

For Assistance  
Call the SAM Hotline  
1-888-362-5572 x 12024

# DoALL Band Sawing Recommendations

*Band Speeds in feet per minute (fpm)      Cutting Rates in square inches per minute (sipm)*

Material	1"- 3" Solid		3"- 6" Solid		6"- 12" Solid		Over 12" Solid	
	fpm	sipm	fpm	sipm	fpm	sipm	fpm	sipm
T-1, T-2	130	5.5	130	6.6	100	5.9	85	4.2
T-4, T-5	110	4.4	110	5	85	4.4	85	2.8
T-6, T-8	100	3.3	100	5	85	4.4	85	2.8
T-15	85	3.3	85	4.4	85	4	85	2.4
M-1, M-30, M-34	150	7.7	150	8.8	115	7.9	90	6.6
M-2, M-3, M-41, M-42	110	6.6	110	7.7	85	6.9	85	4.7
M-4, M-10, M-15	90	4.4	90	5	85	4.5	85	2.8
A-2, A-3, A-8, A-9	200	6.6	200	7.7	170	6.9	150	4.7
D-2, D-3	115	5	115	5.5	90	5	85	3.8
D-7	90	3.3	90	4.4	85	4	85	2.4
O-1, O-2	205	8.8	190	11	180	9.9	170	7.6
O-6, O-7	200	11	200	12.7	150	11.4	110	9.5
W-1E,W-1S, W-1R	200	8.4	200	8.8	180	7.9	160	6.6
H-12, H-13, H-21	190	8.8	190	8.8	155	7.9	130	6.6
H-22, H-24, H-25	160	6.6	160	7.7	130	6.9	110	4.7
S-1	190	8.8	190	8.8	160	7.9	130	6.6
S-2, S-5, S-7	150	6.6	150	7.7	110	6.9	85	4.7
L-6, L-7	170	8.8	170	8.8	115	7.9	85	6.6
P-20, P-21	190	8.8	190	8.8	155	7.9	130	6.6
201,202,434,436	115	6.6	115	7.7	85	6.9	85	4.7
303,304,305,501,502	130	7.7	130	8.8	90	7.9	85	6.6
308-310,330,503	85	2.8	85	3.3	85	3	85	1.9
314,316,316L,317	85	2.8	85	3.3	85	3	85	1.9
321-347	115	6.6	115	7.7	90	6.9	85	4.7
410,420,420F	140	6.6	140	7.7	100	6.9	85	4.7
416,430F	180	11	180	12.7	140	11.4	110	9.5
430,446	90	6.6	90	7.7	85	6.9	85	4.7
440A,B,C	110	6.6	110	7.7	85	6.9	85	4.7
440F, 443	130	6.6	130	7.7	100	6.9	85	4.7
17-4PH, 17-7PH	90	6.6	90	7.7	85	6.9	85	4.7
MONEL	100	5	100	5.5	85	5	85	3.8
R MONEL	150	6.6	150	7.7	85	6.9	85	4.7
K MONEL	85	2.8	85	3.3	85	3	85	1.9
HASTELLOY	100	3.3	100	5	85	4.5	85	2.8
INCONEL, X	100	5	100	5.5	85	5	85	3.8
INCONEL 625, 718	85	1.2	85	0.8	85	0.5	85	0.25
Ti-4AL-4Mo	110	2.8	110	2.2	85	2	85	1.9
Ti-140A	90	2.2	90	2.8	85	2.5	85	1.9
Ti-150A	90	2.8	90	2.2	85	2.5	85	1.9
6AL-4V	100	2.8	100	3.3	85	3	85	2.4
99% Pure	90	2.2	90	2.8	85	2.5	85	1.9

*Note: These are approximate values. Adjust band speed and feed pressure as necessary to control harmonics and chip formation.*



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Material	1" - 3" Solid		3" - 6" Solid		6" - 12" Solid		Over 12" Solid	
	fpm	sipm	fpm	sipm	fpm	sipm	fpm	sipm
1008-1013	315	20	295	23	270	20.7	245	18.9
1015-1035	345	21	295	25	295	22.5	265	22.7
1040-1064	225	11.6	205	15.8	190	14.2	170	12.8
1065-1095	225	11.6	200	14.2	155	12.8	125	11.3
1108-1113	325	21	325	25	270	24.5	225	23.1
1115-1132	345	21	325	25	270	22.5	225	22.7
1137-1151	260	13.5	260	17	225	15.3	190	14.7
1212-1213	345	21	345	25	295	22.5	255	22.7
1320-1330	245	14.2	200	17.9	200	16.1	195	14.2
1335-1345	240	12.1	205	14.2	200	12.8	190	11.3
2317	270	10.2	250	11.6	240	10.4	230	9.1
2330-2345	225	8.4	200	10.5	180	9.5	165	7.6
2512-2517	200	8.4	180	10.5	180	9.5	165	7.6
3115-3130	250	10.5	250	12.6	225	11.3	205	9.5
3135-3150	200	12.1	180	14.2	150	12.8	125	11.3
3310-3315	180	8.4	180	10.5	170	9.5	160	7.6
4017-4024	270	12.1	270	14.2	250	12.8	230	11.3
4032-4042	260	12.1	260	14.2	225	9.5	190	11.3
4047-4068	200	10.5	200	12.1	180	12.8	160	9.5
4130-4140	250	12.6	250	16.3	200	12.8	160	12.8
4142-4150	205	10.5	205	12.1	180	10.9	155	9.5
4317-4320	225	10.5	225	12.1	205	10.9	190	9.5
4337-4340	200	9.5	200	12.6	180	11.3	160	8.5
4608-4621	240	10.5	240	12.6	200	11.3	170	9.5
4640	205	10.5	205	12.1	170	10.9	140	9.5
4812-4820	190	8.4	190	10.5	170	9.5	155	7.6
5045-5046	250	12.6	250	16.3	200	14.7	160	12.8
5120-5135	250	12.1	250	14.2	190	12.8	145	11.3
5140-5160	225	9.5	225	10.5	200	9.5	175	8.5
50100-52100	170	8.4	170	10.5	115	9.5	85	7.6
6117-6120	225	10.5	225	12.6	170	11.3	130	9.5
6145-6152	200	8.4	200	10.5	150	9.5	110	7.6
8615-8627	225	10.5	225	12.1	180	10.9	145	9.5
8630-8645	225	10.5	225	12.1	180	10.9	145	9.5
8647-8660	200	8.4	200	9.5	160	8.5	130	7.6
8715-8750	225	10.5	225	12.1	180	10.9	145	9.5
9255-9260	190	8.4	190	8.4	160	7.6	130	6.2
9261-9262	180	6.3	180	6.8	160	6.2	140	4.7
9310-9317	170	6.3	170	6.8	150	6.2	130	4.7
9437-9445	225	8.4	225	10.5	190	9.5	160	7.6
9747-9763	225	8.4	225	10.5	170	9.5	130	7.6
9840-9850	200	10.5	200	12.1	180	10.9	160	9.5

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