

BI-METAL PRODUCT SELECTION CHART

HIGH PRODUCTION

↑ PERFORMANCE	Aluminum	Low Carbon Steels	High Carbon Steels	Alloy Steels	Bearing Steels	Mold Steels	Stainless Steels	Tools Steels	Titanium Alloys	Nickel-Based Alloys	
								CONTESTOR GT® M-51 Superior Life – Large Block Applications			
								CONTESTOR GT® Superior Life – Standard Applications			
	LXP® Ideal at High Cutting Rates										
		Rx®+ Ideal for Structurals/Bundles									
← EASY MACHINABILITY → DIFFICULT											

GENERAL PURPOSE

↑ PERFORMANCE	Carbon Steels	Light Alloy Steels	Mold Steels	Tools Steels	Stainless Steels
	CLASSIC® 3/4" and Wider Blades				
	DIEMASTER 2® 1/2" and Narrower Blades				
← EASY MACHINABILITY → DIFFICULT					

For Ordering Assistance
please visit us at
BandSawBladesDirect.com
or call (888) 527-5548

BI-METAL SPEED CHART PARAMETERS

These figures are a guide to cutting 4" (100mm) material with a bi-metal blade and flood sawing fluid:

Adjust Band Speed for Different Sized Materials

Material:	Band Speed:
1/4" (6mm)	Chart Speed + 15%
3/4" (19mm)	Chart Speed + 12%
1-1/4" (32mm)	Chart Speed + 10%
2-1/2" (64mm)	Chart Speed + 5%
4" (100mm)	Chart Speed
8" (203mm)	Chart Speed - 12%

- Reduce band speed 15% when using *MICRONIZER®* lubricants.
- Reduce band speed 30%–50% when sawing without fluid.
- Reduce band speed 50% when sawing with carbon blades.

For Heat Treated Materials

DECREASE Band Speed:	When Cutting Harder Material:	
	Rockwell	Brinell
0%	Up to 20	226
5%	22	237
10%	24	247
15%	26	258
20%	28	271
25%	30	286
30%	32	301
35%	36	336
40%	38	353
45%	40	371