

Recommended Cutting Parameters

Work materials		Band dimension(mm)					
		Work length (mm)					
		27 × 0.95	34 × 1.07	41 × 1.3	54 × 1.6	67/80 × 1.6	
		Condition					
		Work length (mm)					
		200	250	300	500	600	
Structural steels	SS *** SM *** STKM ***	Cutting speed(m/min)	70 ~ 80	60 ~ 70	50 ~ 60	45 ~ 50	40 ~ 50
		Cutting rate(cm ² /min)	50 ~ 60			50 ~ 60	
Cast-hardening steels Automatic steels	S * * C SUM ** SNCM ***	Cutting speed(m/min)	65 ~ 80	55 ~ 70	50 ~ 65	40 ~ 55	40 ~ 55
		Cutting rate(cm ² /min)	45 ~ 55			45 ~ 55	
Alloy steels	SCr *** SCM ***	Cutting speed(m/min)	55 ~ 70	50 ~ 65	45 ~ 60	40 ~ 55	40 ~ 55
		Cutting rate(cm ² /min)	40 ~ 50			40 ~ 50	
Bearing steels, Spring steels, Tool steels, Tempered steels	SUJ *** SUP *** SKS *** NAK ***	Cutting speed(m/min)	40 ~ 55	40 ~ 55	35 ~ 50	30 ~ 45	30 ~ 45
		Cutting rate(cm ² /min)	30 ~ 40			25 ~ 35	
Mold steels, High-speed steels	SKD ** SKH **	Cutting speed(m/min)	35 ~ 45	30 ~ 45	25 ~ 40	25 ~ 40	20 ~ 35
		Cutting rate(cm ² /min)	20 ~ 30			20 ~ 30	
Stainless steels, Heat-resistant steels	SUS *** SUH *** SKT ***	Cutting speed(m/min)	30 ~ 45	30 ~ 45	25 ~ 40	25 ~ 40	20 ~ 35
		Cutting rate(cm ² /min)	20 ~ 30			20 ~ 30	
Nickel based alloys	Inconel Hastelloy Waspalloy	Cutting speed(m/min)	20 ~ 27	15 ~ 20	12 ~ 18	8 ~ 15	8 ~ 15
		Cutting rate(cm ² /min)	7 ~ 20			5 ~ 15	
Aluminum alloys, Aluminum cast alloys	A * * * * AC * * * ADC **	Cutting speed(m/min)	80 ~ 150 (500 ~ 2000)	80 ~ 150 (500 ~ 2000)	80 ~ 150 (500 ~ 2000)	60 ~ 80	60 ~ 80
		Cutting rate(cm ² /min)	70 ~ 1500			70 ~ 1500	
Copper alloys	C * * * *	Cutting speed(m/min)	60 ~ 90 (100 ~ 150)	60 ~ 90 (100 ~ 150)	60 ~ 90 (100 ~ 150)	40 ~ 60	40 ~ 60
		Cutting rate(cm ² /min)	40 ~ 50			30 ~ 40	
Graphitic carbon		Cutting speed(m/min)	70 ~ 90 (200 ~ 500)	70 ~ 90 (200 ~ 500)	70 ~ 90 (200 ~ 500)	50 ~ 70	50 ~ 70
		Cutting rate(cm ² /min)	45 ~ 60			40 ~ 50	
Structural		Cutting speed(m/min)	50 ~ 80	50 ~ 80	50 ~ 80	45 ~ 65	45 ~ 65
		Cutting rate(cm ² /min)	40 ~ 70			30 ~ 50	

The cutting Parameters suggested above are general guidelines. Fine tuning these parameters according to the work material, Type of Saw Blade and Sawing machine will result in best outcome.