



Metal Shop

Approved Materials

Material \ Thickness (in)	Sawing Speed (M/min) for Specified Material & Thickness				
	<1/4	1/4-1	1-3	3-6	6+
Steel (High Carbon)	70	60	60	45	45
Steel (Free Cutting)	60	45	40	30	30
Iron Plate (Thick)	45	30	20	20	20
Cast Iron	45	40	30	25	20
Aluminum (6061,6063)	1500	1220	1065	915	770
Bronze (Magnesium)	125	75	40	25	20
Bronze (Leaded Commercial)	915	610	450	305	150
Bronze (Commercial)	150	105	60	30	20
Brass (Free Cutting)	1220	915	610	450	300
Brass (Forging)	610	460	335	245	150
Brass (High Leaded)	1065	825	565	410	260
Brass (Leaded)	610	460	275	215	150
Brass (Low Leaded)	455	305	150	60	20
Copper (Leaded)	765	550	360	240	120
Copper (Cadmium)	90	60	30	25	20
Rubber	460	155	90	60	45
Plastics	1500	1065	765	550	455