

Ⓟ Vertical Metal Band Saw

Approved Materials

Blade Speed (M/m)

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