

BI-METAL BAND SAW BLADES

CUTTING DATA

Material	DIN	USA	JIS	Speed m/min	Cutting rate cm ² /min
1.0060	St 60-2	A 572 Gr.65	SM 58	40-70	20-40
1.0401	C15	1016	S 15C	40-70	20-40
1.0503	C45	1045	S 45C	40-74	20-45
1.0570	St 52-3	A 572 Gr.50	SM 490	40-74	20-45
1.1158	Ck25	1025	S25C	40-74	20-45
1.1221	Ck60	1060	S58C	35-74	15-45
1.2080	X210Cr12	D3	SKD 1	15-37	5-18
1.2312	40CrMnMoS 8-6			25-59	10-30
1.2343	X38CrMoV5-1	H11	SKO 6	22-45	10-24
1.2363	X100CrMoV5-1	A2	SKD12	20-42	8-20
1.2379	X155CrVMo12-1	2	SKO 11	15-37	5-18
1.2510	100 MnCrW4	1	SKS 3	26-46	12-24
1.2606	X37CrMoW 5-1	H12	SKD 62	20-46	8-24
1.2714	56 NiCrMoV7	L6	SKT 4	26-46	12-26
1.2842	90 MnCrV 8	2		24-45	12-24
1.3343	s 6-5-2	M2	SKH 51	26-40	12-20
1.3247	S2-20-1-8	M42	SKH 59	26-40	12-20
1.3965	X8CrMnNi 18-8	Nitronic 50		12-32	4-12
1.4006	X10Cr13	410	SUS410	20-34	8-16
1.4028	X20Cr13	420	sus 420J1	26-38	6-20
1.4125	X105CrMo17	440	C SUS 440C	16-37	6-18
1.4301	X5CrNi 18-10	304	sus 304	16-38	6-20
1.4401	X5CrNiMo 17-12-2	316	sus 316	16-36	6-18
1.4462	X2CrNiMoN 22-5-3	2205	SUS 329J3L	16-34	6-14
1.4571	X6 CrNiMoTi17-12 -2	316 Ti	SUS316	16-34	6-14
1.4841	X15CrNiSi 25-20	314	SUH 310	14-32	4-12
1.4864	X12NiCrSi 36-16	330	SUH 330	14-32	4-12
1.4923	X22 CrMoV 12 -1			14-32	4-12
1.4980	X5 NiCrTi 26-15	A286	SUH 660	14-32	4-12
1.5710	36 NiCr6	(X)3140		26-52	12-28
1.5755	31 NiCr14	3415	SNC 815	30-54	14-30
1.6310	20 MnMoNi-5			26-52	12-28
1.6523	20 NiCrMo2	8620	SNCM 220	26-54	14-30
1.6546	40 NiCrMo 2-2	8640	SNCM 240	30-54	10-30
1.6562	40 NiCrMo7	E4340	SNB24-1-5	30-54	10-30
1.6749	23 CrNiMo 7- 4-7			30-54	10-28
1.6985	28 CrMoNiV 4-9			36-58	16-34
1.7147	20 MnCr5	5120	SMnC420H	38-62	18-36
1.7225	42 CrMo4	4140	SCM 440	36-58	16-34
1.7228	50 CrMo4	4150	SCM 445	34-60	16-36
1.7335	13CrMo 4-4	A387 Gr. 12	SFVA F 12	40-64	18-38
1.7707	30 CrMoV9			28-58	16-34
1.8159	50 CrV4	6150	SUP10	32-54	12-30
1.8509	41 CrAlMo 7	A 355 Cl. A	SACM 645	18-45	8-24