

RECOMMENDED SPEEDS & CUTTING RATES		SINE WAVE BLADE					
Stock Dimensions	From 1" to 3"		From 3" to 6"		Over 6"		
Tooth Pitch	8-12, 6-10, 5-8		5-8, 4-6, 3-4		3-4, 2-3, 1.5-1.9, 1.1-1.4, 8-1.0		
Material	Blade Speed (SFPM)	Cutting Rate (SIPM)	Blade Speed (SFPM)	Cutting Rate (SIPM)	Blade Speed (SFPM)	Cutting Rate (SIPM)	
Stainless Steels:							
201, 202, 302, 304	120	2 - 4	120	2 - 4	120	2 - 4	
303, 303F	135	3 - 4	130	4 - 5	125	4 - 5	
308, 309, 310, 330	80	1 - ½	75	2 - 3	75	2 - 3	
314, 316, 317	120	2 - 3	120	2 - 4	115	2 - 3	
321, 347	115	2 - 3	110	2 - 4	110	2 - 3	
410, 420, 420F	145	2 - 3	140	2 - 3	125	2 - 3	
416, 430F	150	4 - 5	150	4 - 5	150	3 - 4	
430, 446	95	3 - 4	90	3 - 4	90	3 - 4	
440 A,B,C	95	2 - 4	90	3 - 4	90	3 - 4	
440F, 443	90	2 - 4	90	3 - 4	90	3 - 4	
17-4PH, 17-7PH	90	2 - 4	90	3 - 4	90	3 - 4	
A-7	90	1 - 2	90	2 - 3	90	2 - 3	
H-12/H-13/H-21	115	3 - 4	110	3 - 4	110	3 - 4	
H-22/H-24/H-25	115	2 - 4	110	3 - 4	110	2 - 3	
High Speed Tool Steels:							
T-1, T-2	130	2 - 3	110	2 - 4	90	2 - 3	
T-4, T-5	110	1 - 2	100	2 - 3	80	1 - 2	
T-6, T-8	100	1 - 2	80	1 - 2	80	1 - 2	
T-15	70	1	65	1 - 2	65	1 - 2	
M-1	130	3 - 4	120	3 - 4	110	3 - 4	
M-2, M-3	110	2 - 4	100	3 - 4	100	2 - 3	
M-4, M-10	90	1 - 2	80	1 - 3	80	1 - 2	
HIGH Nickel Alloys:							
Hastelloy A	110	1 - 2	100	2 - 3	90	2 - 3	
Hastelloy B	100	1 - 2	100	1 - 3	90	1 - 2	
Hastelloy C	90	1	90	1 - 2	90	0 - 1	
Monel	90	1 - 3	90	1 - 3	90	1 - 2	
R Monel	110	2 - 3	110	2 - 4	110	2 - 4	
K Monel	90	1	90	1½ - 2	90	1	
Inconel	100	1 - 3	95	3 - 4	95	1 - 3	
Inconel X	65	1	65	1 - 1½	65	1	
Rene 41	80	1	80	1 - 2	80	1 - 2	
Udimit	80	1	80	1 - 2	80	1 - 2	
Waspalloy	80	1	80	1 - 2	80	1 - 2	
Titanium	100	1 - 1½	100	2 - 3	100	2 - 3	