

		Materials		Band Speed	
		Type	Grade	FPM	MPM
Aluminum/ Non-Ferrous	Aluminum Alloys	2024, 5052, 6061, 7075		300+	8+5
	Copper Alloys	CDA 220		210	65
		CDA 360		295	90
		Cu Ni (30%)		200	60
		Be Cu		160	50
	Bronze Alloys	AMPCO		180	55
		18 AMPCO 21		160	50
		AMPCO 25		110	35
		Leaded Tin Bronze		290	90
		Al Bronze 865		150	45
Mn Bronze		215	65		
932		280	85		
Brass Alloys	937		250	75	
	Cartridge Brass, Red Brass (85%) Naval Brass		220 200	65 60	
Carbon Steels	Leaded, Free Machining Low Carbon Steels	1145		270	80
		1215		325	100
		12L14		350	105
	Low Carbon Steels	1008, 1018		270	80
		1030		250	75
	Medium Carbon Steels	1035		240	75
		1045		230	70
	High Carbon Steels	1060		200	60
		1080		195	60
		1095		185	55
Structural Steel	Structural Steel	A36	250	75	
Alloy Steel	Mn Steels	1541		200	60
		1524		170	50
	Cr-Mo Steels	4140		225	70
		41L50		235	70
		4150H		200	60
	Cr Alloy Steels	6150		190	60
		5160		195	60
	Ni-Cr-Mo Steels	4340		195	60
		8620		215	65
		8640		185	55
E9310		160	50		
Bearing Steel	Cr Alloy Steels	52100	160	50	
Mold Steel	Mold Steels	P-3		180	55
		P-20		165	50
Stainless Steel	Stainless Steels	304		115	35
		316		90	25
		410, 420		135	40
		440A		80	25
		440C		70	20
	Precipitation Hardening Stainless Steels	17-4 PH		70	20
		15-5 PH		70	20
Free Machining Stainless Steels	420F		150	45	
	301		125	40	
Tool Steel	Low Alloy Tool Steel	L-6		145	45
	Water-Hardening Tool Steel	W-		145	45
	Cold-Work Tool Steel	D-2		90	25
	Air-Hardening Tool Steels	A-2		150	45
		A-6		135	40
		A-10		100	30
	Hot Work Tool Steels	H-13		140	40
		H-25		90	25
	Oil-Hardening Tool Steels	O-1		140	40
		O-2		135	40
	High Speed Tool Steels	M-2, M-10		105	30
		M-4, M-42		95	30
		T-1		90	25
T-15		60	20		
Shock Resistant Tool Steels	S-1		140	40	
	S-5, S-7		125	40	
Titanium Alloy	Titanium Alloys	CP Titanium		85	25
		Ti-6Al-4V		65	20
Nickel Based Alloy	Nickel Alloys	Monel® K-500		70	20
		Duranickel 301		55	15
	Iron-Based Super Alloys	A286, Incoloy® 825		80	25
		Incoloy® 600		55	15
		Pyromet X-15		70	20
	Nickel-Based Alloys	Inconel® 600, Inconel® 718, Nimonic 90		60	20
		NI-SPAN-C 902, RENE 41		60	20
		Inconel® 625		80	25
Hastalloy B, Waspalloy Nimonic 75, RENE 88		55 50	15 15		
Other	Cast Irons	A536 (60-40-18)		225	70
		A536 (120-90-02)		110	35
		A48 (Class 20)		160	50
		A48 (Class 40)		115	35
		A48 (Class 60)		95	30