

CARBIDE TIPPED BLADE SOLUTIONS

KICK YOUR PRODUCTIVITY UP A NOTCH!

Carbide tipped band saw blades provide significant advantages in a wide variety of applications. Speak with your local Starrett representative to receive a personalized cost savings analysis of your processes and get applicable solutions which save money, fix bottlenecks and increase throughput.



ADVANZ™ MC7

The number one choice for high production and aerospace alloys.

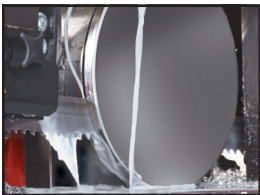
- Extremely long lifespan and low wear due to progressive four tooth grind
- High cutting efficiency provides a great cost per cut ratio



ADVANZ™ MC5

Excellent for production applications, hard steels, and alloys.

- Fast cutting without sacrificing surface finish
- Longer lasting with proprietary tooth geometry, distributing chip load more effectively



ADVANZ™ TS

Versatile all-around blade which offers all the benefits of carbide, without limitations.

- Excellent cost per cut ratio on every material that enters your facility
- Excellent for tough materials which standard bi-metal blades cannot cut



ADVANZ™ CS

Designed with the hardest exteriors in mind.

- Ideal for induction hardened chrome shafts, linear bearing shafts and case hardened materials to HRc 65
- Excellent longevity due to shock and wear resistant technology



ADVANZ™ FS

The most effective blade for cutting gates, risers, castings, fiberglass, masonite, plastics or other abrasive materials.

- Engineered to keep teeth from stripping, even in the most demanding materials
- Exceptional shock resistance for intermittent cutting

Dramatically improve your blade life in hard to cut alloys and increase tooth penetration without added feed pressure. AMP technology makes your blade rock through the cut, improving contact area. Ask your Starrett Saw Specialist if AMP is right for your unique application.



RECOMMENDED CUTTING SPEEDS

Material Type		Band Speed SFPM	Feed Rate SIPM
Induction/Case Hardened Steels	Use CS	295 - 325	1
Free Machining Steels	1212 / 1214	325 - 525	20 - 25
Alloy Steel	1035/1045	295 - 395	15 - 20
	4140	230 - 295	10 - 15
	4340	230 - 295	8 - 10
Ball Bearing Steels	52100	230 - 295	10 - 15
Spring Steels	6150	215 - 280	10 - 15
Unalloyed Tool Steels	W1	215 - 280	7 - 9
Cold Work Tool Steels	D3	130 - 160	4 - 6
	D2	130 - 160	4 - 6
	O1	195 - 260	8 - 10
	O2	150 - 180	7 - 9
Tool Steels (Hot Work)	H 13	195 - 260	7 - 10
	L 6	160 - 230	8 - 10
High Speed Steels	M 2	160 - 195	5 - 8
	M 42	145 - 200	7 - 9
	T 1	145 - 200	7 - 9
Stainless Steels	304	230 - 260	6 - 8
	316	200 - 250	6 - 8
	420	260 - 325	6 - 8
	17-4, 15-5	140 - 160	3 - 4
Nickel Alloys	Inconel 718, 600	80 - 100	2-2.5
	Waspalloy, Hastelloy	70 - 90	2-2.5
	Inconel 625	75 - 100	2-2.5
	Rene 88, 75	75 - 85	2-2.5
	Monel K500	80 - 110	2 - 3
	Incoloy 840	90 - 100	2
Tempered Steels	Rc. 30/35	250 - 300	10 - 15
	Rc. 35/40	200 - 250	7 - 10
	Rc. 40/45	150 - 175	4 - 6
Cast Iron	Class 30	175 - 200	4 - 5
	Ductile 65 - 45 - 12	180 - 245	4 - 5
Titanium	Titanium	140 - 170	4-7
	Ti-6Al-4V	140 - 160	4-7
Copper Alloys (Use MC5)	110	300	4 - 7
	Cu Ni (30%)	180 - 220	4 - 7
Bronze Alloys	Ampco 18	130 - 200	2 - 3
	Ampco 25	110 - 130	1 - 2
Brass (Use MC5)	260	250	4-6
	360	300	4-6
Aluminum Bronze		200	3-4
Most Aluminum (Use MC5)		3000	>8

