

BLADE BREAK-IN

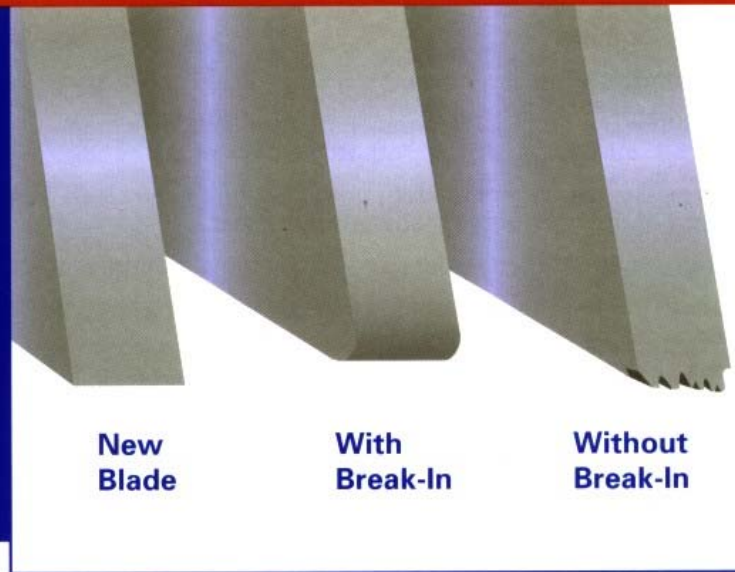
Getting Long Life from a New Band Saw Blade

What is Blade Break-In?

A new band saw blade has razor sharp tooth tips as a result of the forming of the teeth. In order to withstand the cutting pressures used in band sawing, the tooth tip should be honed to form a micro-fine radius. Cutting with high pressure without performing this honing will cause microscopic damage to the tips of the teeth, resulting in loss of blade life.

Why Break-In a Band Saw Blade?

Completing a proper break-in on a new band saw blade will dramatically increase its blade life.



How To Break In a Blade

1. Use the appropriate band speed for the material to be cut (see bi-metal band speed chart on pages 20 and 21).

2. Reduce the feed rate/force control on the saw to achieve a cutting rate approximately 20% to 50% of the normal cutting rate. Mild steels require a larger reduction in cutting rate than more difficult to machine materials.

3. Begin the first cut at the reduced rate (A), making sure that the teeth are forming a chip. Once the blade fully enters the workpiece, the feed rate can be slightly increased (B).

4. Make gradual increases in feed rate/force over several cuts until the normal cutting rate is established (cutting a total of 60 to 118 inches² / 150 to 300 cm²) (C).

Note: During break-in, slight adjustments to band speed may be made in the event of excessive noise or vibration. Once the blade is broken in, the recommended band speed should be used.

