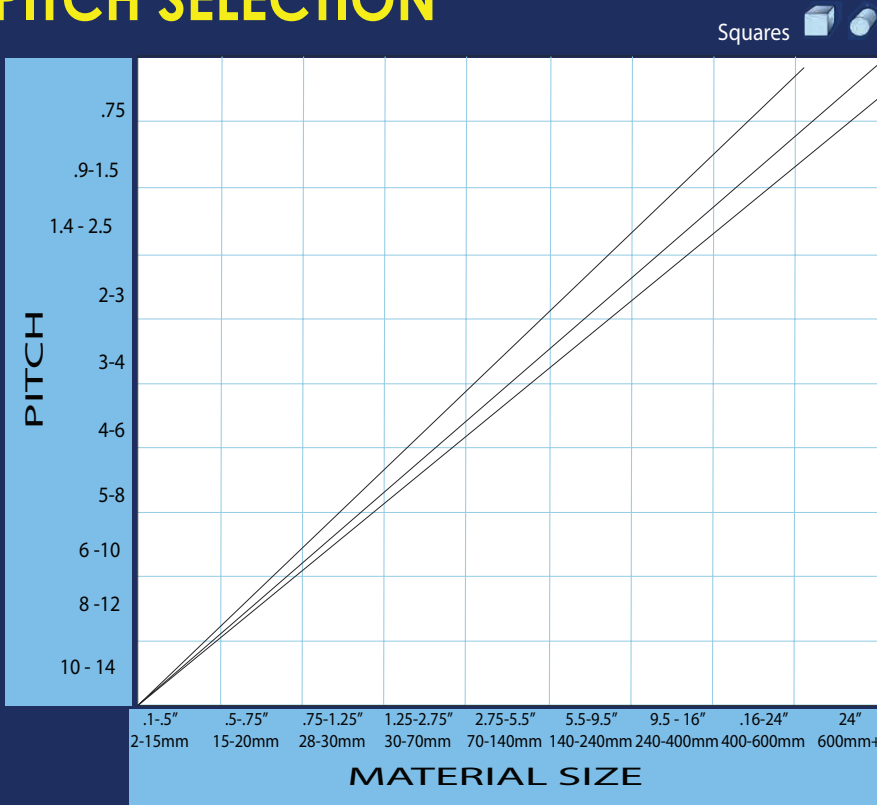


PITCH SELECTION



Squares Rounds
Structural



BREAKING IN THE BAND SAW BLADE

The blade break-in procedure dresses and strengthens new, Ultra sharp teeth. Proper break-in can increase band life by 25% - 50%.

Always break-in a new blade:

- Saw at the recommended band speed.
- Cut at 1/2 the normal feed rate. (Cuts should take twice as long)
- Cut for 20 minutes, then increase feed force in steps until you attain the normal cutting rate.

To ensure penetration in very tough work-hardening materials, you will need to apply more feed force and cut as a faster rate than described above.

SAWING AFTER BREAK-IN

After break-in, as the blade gradually dulls, you will need to periodically increase the feed force to maintain cutting rate. When the blade is too dull and the feed force too high, excessive band deflection will cause the blade to cut out of square.

CHIP CHARACTERISTICS

Chip Form								
Condition	Thick, hard & short	Thick, hard & brittle	Thick, hard & springy	Thin, hard & springy	Thin, curly & springy	Thin, straight & springy	Powdery	Thin, tightly curled
Color	Blue or Brown	Blue or Brown	Silver or Light Straw	Silver	Silver	Silver	Silver	Silver
Band Speed	Reduce	Reduce	OK	Increase	OK	OK	Reduce	OK
Feed Rate	Reduce	Reduce	Reduce Slightly	Reduce	OK	Increase	Increase	Reduce