

NEW BLADE WITH RAZOR SHARP TEETH



TOOTH CORRECTLY BROKEN IN



TOOTH INCORRECTLY BROKEN IN



BLADE BREAK-IN

Using the right break-in procedures for a bi-metal blade assures longer blade life, faster cuts for a longer period of time and consistent performance. Conversely, blade life can be significantly compromised if the proper break-in procedures are not followed.

LONGER BLADE LIFE

The teeth on a new band saw blade are razor sharp. To withstand the cutting pressures of band sawing, the tip of each tooth should be honed to create an extremely small radius on its tip.

Easy-to-cut material such as carbon steel and aluminum:

- A. Run the normal surface feet per minute (SFM).
- B. Adjust the feed pressure to about one-half the normal cutting rate for the first few cuts or for 50-100 square inches (323-645 sq.cm).
- C. Increase to the normal cutting rate.
- D. Avoid vibration.

Hard-to-cut materials such as nickel-based alloys like inconel, hardened steels, tool steels and stainless steels:

- A. Run the normal surface feet per minute (SFM).
- B. Adjust the feed pressure to about three-quarters of the normal cutting rate for the first few cuts or for 25-75 square inches (161-484 sq.cm).
- C. Then increase the cutting rate part way to normal for the next few cuts.
- D. Then increase to the normal cutting rate.
- E. Avoid vibration.

BAND SAW SERVICE & SUPPORT

Starrett service technicians are available to tune up and perform preventative maintenance on your production sawing machine using Starrett Band Saw Blades, at no additional cost. They fully review machine condition, blade mounting and operation in detail, making adjustments, as required, to help maintain good sawing and long life for both the machine and blades.

TRAINING

Starrett service technicians can also instruct saw operators on achieving the best performance of blade and machine for your applications. Contact your Starrett Band Saw distributor about arranging a visit to your workplace by a Starrett service technician.



START TO CUT MATERIAL AT REDUCED CUTTING RATE



AFTER BREAK-IN WHEN THE BLADE HAS FULLY ENTERED THE WORK-PIECE, INCREASE THE FEED RATE OVER A SERIES OF CUTS UNTIL THE RECOMMENDED CUTTING RATE IS ACHIEVED

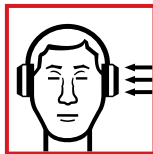
BAND SAW BLADE INSTALLATION GUIDELINES

Always follow the machine manufacturer's instructions and recommendations for blade changes and the safe operation for the band saw machine. The guidelines are not intended to replace the machine manufacturer's instructions or recommendations. The general information contained in the guidelines is intended to assist in the proper installation of band saw blades. Proper blade installation achieves more efficient blade performance. Please contact your machine manufacturer for appropriate procedures for blade changes for your specific machine and your saw blade manufacturer for appropriate cutting recommendations. The L. S. Starrett Co. nor its employees, shall not be held responsible for the accuracy or completeness of these guidelines.

- ▶ Wear gloves when handling band saw blades.



- ▶ Wear eye protection, safety shoes, and hearing protection.

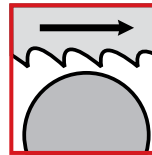


FOLLOW INSTRUCTIONS CAREFULLY

- ▶ Follow all the safety instructions shown in the band saw machine operator's manual and on the machine labels. Recognize and read safety and warning signs such as **Danger**, **Warning** and **Caution**.
- ▶ Follow the saw blade installation instructions for the make and model of the band saw machine.

BASIC BLADE CHANGE GUIDELINES

- ▶ Position saw head to appropriate location to facilitate ease of blade change.
- ▶ Follow required lock out tag out procedures
- ▶ Position chip brush away from saw blade.
- ▶ Relieve saw blade tension and remove blade.
- ▶ Remove any chips from saw guides and band wheels.
- ▶ Select appropriate blade for cutting application. (Refer to saw blade selection chart)
- ▶ Unfold blade properly. **Do Not Throw.** Throwing the blade will result in tooth damage that will reduce saw blade performance. (Refer to unfolding procedure)
- ▶ Install blade with saw teeth pointing in proper direction.



- ▶ Apply appropriate tension to the blade.
- ▶ Be aware of pinch points and keep hands and clothing clear of rotating blade.



- ▶ Adjust guide arms to appropriate positions to workpiece.
- ▶ Adjust blade guides for proper blade support.
- ▶ Adjust chip brush to fully engage saw blade teeth to ensure proper chip removal.
- ▶ Check hydraulic fluid levels if applicable.
- ▶ Ensure appropriate cutting fluid placement and mix ratios as applicable per machine, cutting fluid, and blade manufacturer's recommendations.
- ▶ Break in blade properly before reaching desired cutting rates.