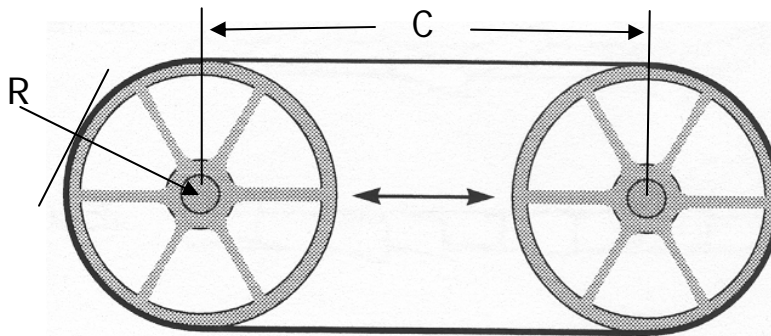


How to Choose the Correct Length of Blade

1. Put the adjustable band wheel in the middle of the adjustment.
2. Measure the distance between the centers of the band wheels. Label this Measurement "C". (see diagram)
3. Determine the radius of the upper and lower band wheels. Label these measurements "R1" & "R2". (see diagram)
4. Apply the following formula to obtain the correct length for the band saw blade.

$$(R1 \times 3.1416) + (R2 \times 3.1416) + 2 \times C = \text{Length of Band Saw Blade (inches)}$$



Guide Lines for successful Band Saw Operation in Metal

- ◆ Select the correct blade for the application.
- ◆ Tension the blade to the machine specifications.
- ◆ Break in the blade by running it at 1/2 the rate for the first 50 to 75 square inches.
- ◆ Set the feed rate and blade speed according to the size and material being cut.
- ◆ Adjust the coolant flow so that it enters the cut and flows with the chips.
- ◆ Check the chips coming out of the cut to see how they are formed.
- ◆ Thin or short chips indicates the need for more feed pressure
- ◆ Heavy, Dark blue chips means too much feed pressure.
- ◆ Loose, curled chips means that the correct feed pressure has been reached.
- ◆ Band speed should be set ac-
- ◆ Check machine guide blocks and bearings periodically to insure that they run tight and true.
- ◆ Change the blade as it becomes worn or damaged.

