

Blade Break-In Instructions

This machine is a powerful metal cutting saw and it would have no problem to cut you. You must treat the machine with respect to avoid any injuries.

BE CAREFUL! WORK SAFELY!

- Do not operate any machine until you have read the manual and been instructed on all standard shop safety precautions.
- Keep away from all moving parts including but not limited to the following; saw blade, blade wheels, pulleys, v-belts, motor, etc.
- Never operate the machine unless all guards are in place.
- Machines are designed for use by only one operator; do not let two people work on the machine at the same time.
- Always keep the machine and your work area clean and remove all obstacles.
- Never load, unload stock or remove cut parts from the machine while the blade is running.
- Support long or heavy stock in the front and rear of the machine.
- Always clamp the stock securely before operating the machine.
- When changing the blade always wear gloves and safety glasses. Do not throw the blade into the air to uncoil. If you do not know how to uncoil the blade, get instructions from your blade supplier.
- Do not wear jewelry, gloves, loose clothing, and ties or have long hair unconfined while operating this machine.
- When performing maintenance work on the bandsaw machine always disconnect the power supply.
- Use the proper speeds, feeds and coolant as required.
- Do not let the coolant pump operate dry.
- Do not let the hydraulic level to become low.

The advice should be used as a guide only. All machines are unique so there may be differences. Adjustments to the machine must be only be done by qualified and trained personnel

- The following speeds are only an approximate starting value; contact your blade supplier for details.
- Do not start a new blade in an old cut.
- Do not start cut on a sharp edge if possible.
- Less than 5 teeth and more than 12 in the cut may cause the blade to break or the teeth strip.
- Proper blade break-in procedure will increase the blade life.

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Blade break-in is very important if the maximum blade life is going to be achieved. Blade break-in procedure is similar to a lapping action on the blade teeth removing the sharp edges.

The following steps should be followed for break in procedure.

1. Select the proper speed for the material to be cut.
2. Cut at 25% of the normal feed setting for 10 minutes.
3. Increase feed rate to 50% of normal setting and cut for 10 minutes.
4. Increase feed rate to 75% of normal setting and cut for 10 minutes.
5. Increase feed rate to 100% of normal setting and cut.

Check with your blade supplier for specific instructions.