

# BLADE BREAK-IN

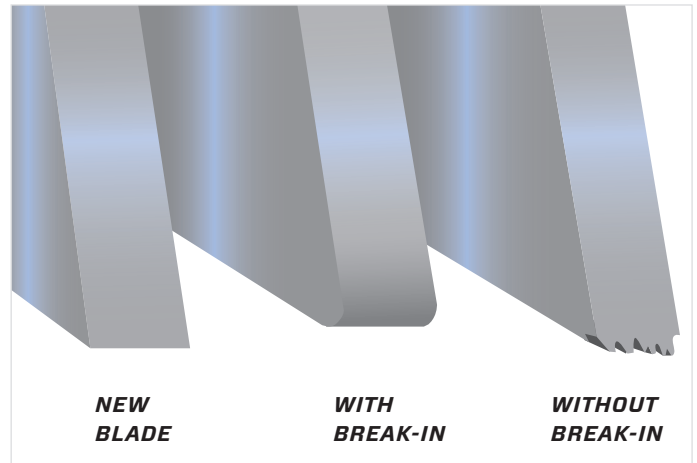
## Getting Long Life from a New Band Saw Blade

### **WHAT IS BLADE BREAK-IN?**

A new band saw blade has razor sharp tooth tips. In order to withstand the cutting pressures used in band sawing, tooth tips should be honed to form a micro-fine radius. Failure to perform this honing will cause microscopic damage to the tips of the teeth, resulting in reduced blade life.

### **Why Break-In a Band Saw Blade?**

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



### **HOW TO BREAK IN A BLADE**

Select the proper band speed for the material to be cut (see chart on page 32)

Reduce the feed force/rate to achieve a cutting rate 20% to 50% of normal (soft materials require a larger feed rate reduction than harder materials)

Begin the first cut at the reduced rate. Make sure the teeth are forming a chip. Small adjustments to the band speed may be made in the event of excessive noise/vibration

During the first cut, increase feed rate/force slightly once the blade fully enters the workpiece

With each following cut, gradually increase feed rate/force until normal cutting rate is reached

**FOR FURTHER ASSISTANCE WITH BREAK-IN PROCEDURES, CONTACT LENOX TECHNICAL SUPPORT**

