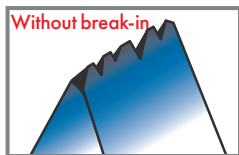
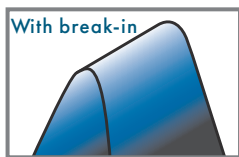
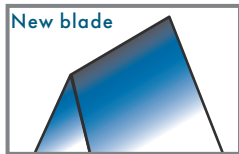


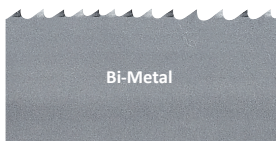
# Blade Break-in

## WHY BREAK-IN A BAND SAW BLADE?

The band saw blade's teeth are razor sharp. In order to withstand the cutting pressures of band sawing, the tooth tip should be honed to form a very small edge radius. If a proper break-in procedure has not been performed and the tooth tips are damaged, the blade life, and performance are reduced significantly.



## BREAKING IN THE BLADE



### Bi-Metal Procedure

1. Reduce feed force during first 20 minutes of cutting to 50% of normal feed.
2. Gradually increase feed force in 4 steps to normal over the course of 10 minutes.
3. Run normal band speed.



### Carbide Tipped T3P / T7P / T3N Procedure

1. Reduce band speed during first 20 minutes of cutting to 70% of normal speed.
2. Reduce feed force during first 20 minutes of cutting to 50% of normal feed.
3. Gradually increase bandspeed and feed force in 4 steps to normal after 10 minutes.