

Blade Break-in Procedure

A new band saw blade has razor sharp tooth tips as a result of forming the teeth. In order to withstand the cutting pressures used in band sawing, the tooth tips should be honed to form a micro-fine radius. Cutting with high pressure without honing causes microscopic damage to the tooth tips, resulting in a shorter blade life.

Completing a proper break-in procedure on a band saw blade will increase blade life.

To get long life from a new band saw blade – follow this procedure:

Use the appropriate band saw speed for the material to be cut.	Run saw at 75%
Reduce the feed rate (force on the saw) to achieve a cutting rate of approximately 20% to 50% of the normal cutting rate. Mild steel blades (carbon steel) require a greater reduction in feed rate.	Feed rate 20% - 50%
Begin the first cut at the reduced rate, making sure the teeth are forming sawdust chips. Once the blade fully enters the log or workpiece, the feed rate can be slightly increased.	Increase feed rate to 50%
Make gradual increases in the feed rate (force on the saw) over several cuts until the normal feed rate is established (something like 3-4 ft. per minute depending on width of cut and wood hardness).	Gradually increase feed rate to 100%

During break-in, adjustments to band speed may be made in the event of excess noise, blade vibration or blade chatter. Once the blade is broken in, use 50% to 100% blade speed depending upon on width of cut and wood hardness. Insure the sawdust in made up of wood chips, not light dust.

