SAFE OPERATION & INSTALLATION INSTRUCTIONS

1) OBSERVE BAND SAWING DO'S AND DON'TS
2) RUN BLADES AT RECOMMENDED SPEEDS. FOR CARBON BLADES REDUCE RECOMMENDED SPEEDS BY 50%.

Do: **Break-In New Blades!** Start first cut at recommended speed and reduce feed pressure or feed rate by 50%. After the first 50-100 square inches are cut gradually increase feed pressure or feed rate until recommended levels are attained.

Don't: Start new blade in an existing cut. Narrow kerf from worn previous blade may strip teeth or break the new blade. Avoid starting cuts on sharp edges or corners.

Do: Tension blade properly for straight cuts, longer life. Reduce tension when machine is not in use. Recommended Tension:
BiMetal @ 30,000 PSI Carbon @ 25,000 PSI

Don't: Over or under - tension blades. Excess tension may break blades or damage the machine. Insufficient tension may cause crooked cuts or blade damage.

Do: Use cutting fluids. Cooler, cleaner cutting will dramatically prolong blade life.

Don't: Use fluids for cast iron, bearing bronze or die tool steel.

Do: Vise work tightly.

Don't: Allow moving work pieces to break blade or destroy teeth.

Do: Make sure guides do not touch set teeth.

Don't: Allow teeth to contact guides. Set may be destroyed.

Do: Position guide arms as close to the work as possible.

Don't: Risk blade distortion, crooked cuts or blade failure from wide spacing of guide arms.

Do: Position blade guides so that blade runs straight and freely.

Don't: Position guides where they may alter the path of the blade or bind blade. Blades may break or fail prematurely.

Do: Position blade on machine wheels so that blade back rests against flanges.

Don't: Let blade ride up onto the side of wheel flange. Resulting contact of teeth with wheels may destroy set.

Do: Examine chips formed in cutting. Fine, powdery chips mean insufficient feed pressure. Coarse, heavy burned chips mean excessive feed pressure.

Don't: Increase speeds or feeds for faster cutting without checking chip texture and color.

CARBON

CUTS: Wood, plastic, cork, fiberglass, graphite, aluminum, brass, bronze, cast iron, copper, lead, zinc, mild steel, etc.

BI-METAL

CUTS: Alloy steels, carbon steels, tool steels, stainless steels, air hardening die steels.

TOOTH TYPE

AVAILABLE IN CARBON

AVAILABLE IN BI-METAL

SKIP

FEATURES
- Wide Gullets (Flat)
- 0° Rake Angle
- Equally Spaced Teeth

BENEFITS
- Excellent Cutting for Non-Metallic Applications, (Wood, Plastic, Composition Materials)

HOOK

FEATURES
- Wide Gullets (Round)
- Positive Rake Angle

BENEFITS
- Good Cutting Performance in Discontinuous Chip Forming Materials (Cast Iron)
- General Purpose

STANDARD

FEATURES
- Equally Spaced Teeth
- 0° Rake Angle

BENEFITS
- Wide Range of Applications
- General Purpose

VARIABLE PITCH

FEATURES
- Varying Gullet Depth
- 0° Rake Angle
- Variable Tooth Spacing

BENEFITS
- Improves Blade Life
- Reduces Noise
- Cuts Smoother & More Efficiently
- Wider Range of Applications

VARIABLE PITCH *Positive Rake*

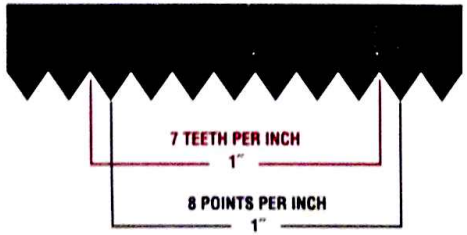
FEATURES
- Varying Gullet Depth
- Variable Tooth Spacing
- Positive Rake Angle

BENEFITS
- Cuts Smoother, Cuts Faster
- Reduces Noise
- Improves Blade Life
- Easier Chip Generation

MEASURING SAW TEETH

Saw Teeth are measured by one of two systems illustrated at right. Each is based on the "inch" scale. Teeth per inch (TPI) indicates the number of teeth between saw gullets.

Points per inch is the European system and measures teeth from tip to tip



Minimum Radius per Blade Width

Blade Width	Minimum Radius
1" / 25mm	7-1/4" / 184mm
3/4" / 19mm	5-7/16" / 138mm
5/8" / 16mm	3-3/4" / 95mm
1/2" / 13mm	2-1/2" / 63mm
3/8" /10mm	1-1/4" / 32mm
1/4" / 6mm	5/8" / 16mm
3/16" / 5mm	3/8" / 10mm
1/8" / 3mm	7/32" / 5.5mm

Materials Thickness 1" / 25mm