6 Key steps

to getting the most out of your blade

1. Choose the right blade

Use the tooth selection chart on the back of this sheet to give you the correct blade for your job, aim to have 5-8 teeth in the material at all times

2. Ensure the bandsaw machine is cleaned thoroughly before putting the blade on.

Clean the drive and Idler wheels to remove all swarf, the blade needs to sit comfortably on these wheels

- Clean the guide bearings, and ensure they are moving freely
- If your machine has carbide guides, ensure that these are cleaned and aren't too worn out

3. Set up the blade guides correctly

- Adjust the back and side guides to ensure the blade is sitting tight and all vibration is removed where possible

4. Tension the blade correctly

- Get as much tension as possible, a good rule of thumb, is that when placing your palm on the blade and pushing down you should get a maximum of 1mm of movement

5. Run the blade in and use the correct Feeds and Speeds

- For the first 20-30 minutes of cutting run the blade at normal band speed, but only half the down-feed pressure, before gradually increasing to the full speed
- A simple feed and speed chart is on the reverse of this brochure

6. Use a high quality coolant

- Use a coolant that performs 3 key roles
  - i. Cools the cutting tip
  - ii. Lubricates the cutting tip
  - iii. Washes the swarf away
- Ensure that you mix the coolant correctly and keep it clean for the best results.

Helpful Tips

Excision®
Dependable Precision

Dependable Precision GUARANTEED

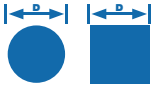
Metal Cutting Tips

Tooth Selection For metal cutting bandsaw blades

NORMAL TOOTH (N)

PROFILE TOOTH

TCT TOOTH

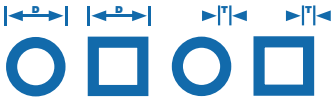


SOLIDS

SOLIDS

Vari-Pitch Toothing	
Material Diameter (D) mm	Teeth Per Inch
0-5	18
4-8	14
2-15	10/14
8-20	8/12
16-30	6/10
25-40	5/8
35-70	4/6
60-120	3/4
80-200	2/3
120-400	1.5/2
250+	1.1/1.6
400+	0.75/1.25

TCT Toothing (Materials over 50 HRc)	
Material Diameter (D) mm	Teeth Per Inch
50-120	3/4
100-250	2/3
150-400	1.5/2
350-600	1.1/1.6
500+	0.85/1.15



TUBES AND RHS

TUBES AND RHS

Tube Width (W)mm	Wall Thickness (T)															
	1	1.6	2	2.5	3	4	5	6	7	8	9	10	12	15	20	50
10	14	10/14	10/14													
20	14	10/14	10/14	10/14	8/12											
25	14	10/14	10/14	10/14	8/12	8/12										
30	14	10/14	10/14	10/14	8/12	8/12	6/10									
40	14	10/14	10/14	10/14	8/12	8/12	6/10	5/8	5/8	5/8						
50	14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	5/8						
60-120	14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4	
130-150		10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4	3/4
150-180			10/14	8/12	6/10	6/10	5/8	4/6	4/6	4/6	4/6	4/6	4/6	3/4	3/4	3/4
190-300					6/10	6/10	5/8	4/6	4/6	4/6	4/6	4/6	4/6	3/4	3/4	2/3
350-400										4/6	4/6	3/4	3/4	3/4	3/4	2/3
450-500										4/6	4/6	3/4	3/4	3/4	3/4	2/3

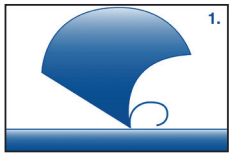
Band Speed for Bimetal

MATERIAL	IN M/MIN
Construction Steel / Machining Steel	80 - 90
Case Hardened Steels / Steels for hardening and tempering	45 - 75
Non-Alloy, Tool Steels / Roller Bearing Steels	40 - 60
Alloyed Tool Steels / High Speed Steels	30 - 40
Rust Resistant Steels	20 - 35
Heat Resistant Steels / High Temp, Alloy Steels	15 - 25

For more detailed information or different types of bandsaw blades check out our website: excision.com.au or phone us 1800 633 448.

Sawing Basic Troubleshooting

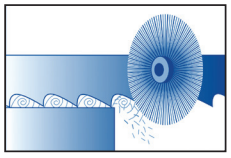
Feed Rate



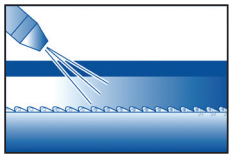
a. Feed rate too light.
b. 'Rubs' the tooth dull.

a. Feed rate too heavy.
b. Premature tooth wear.
c. Teeth wear too fast and break off

a. Recommended feed rate.
b. Optimum life



BRUSHES
Brushes aid in the **cleaning** of chips from the gullet of the band. This creates less tendency to strip teeth and creates smoother cut surfaces.



COOLANT
Should **Wash, Cool, Lubricate** the blade as well as the material being cut. We recommend to useXDP **1000 or XDP 2000 -** refer to page 38-40.

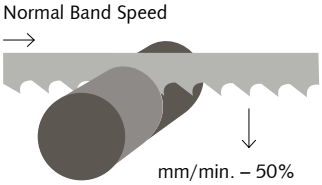
Part number:
8900000030

TENSION
Ensure correct tension. Tension to 300N/mm². A poorly tensioned blade leads to premature wear, blade fatigue and eventual blade breakage.

Bimetal Bandsaw Blade Run In Procedure

The life of an Excision Bi-Alfa bimetal bandsaw blade can be increased significantly by following the recommended running-in procedure. A new saw blade benefits from a short period of cutting at reduced cutting feed rate. Use normal recommended band speed and reduce feed pressure by 50%. After approximately 500cm² of cross sectional area or 15 minutes has been sawn, the feed rate should be gradually increased to maximum. The best material to run-in an Excision blade is round mild steel bar, about 80mm diameter, depending on the tooth pitch.

highly recommended to increase blade life



HARE&FORBES MACHINERYHOUSE
www.machineryhouse.com.au