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METALWORKING & SAFETY PRODUCTS

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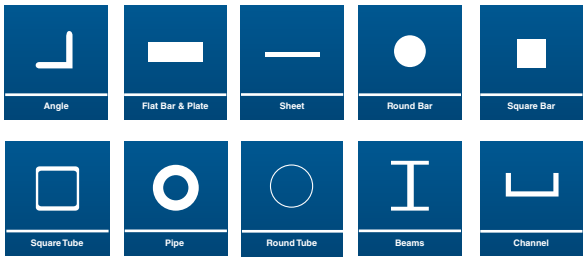
METALWORKING BANDSAW BLADES

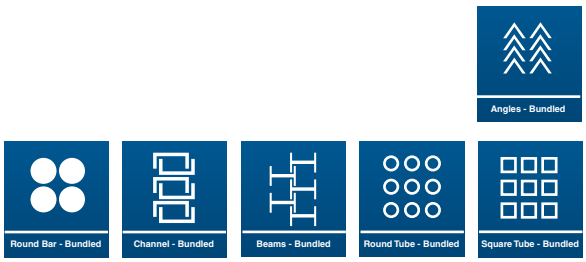
Excision® M42 Cobalt Bandsaw Blades (Regular)

- Versatile Bi-Metal Bandsaw Blade with 8% Cobalt content
- Regular Tooth shape suits a huge range of cutting applications
- Suitable for use on metals with hardness up to 44HRc
- Ideal For: Mild Steel, Stainless Steel, Aluminium, Brass, Copper, Cast Iron, Fibreglass, Wood



Excision® M42 Cobalt Bandsaw Blades (Profile)

- Specialised Bi-Metal Bandsaw Blade with 8% Cobalt content
- Profile Tooth shape suits vibration-susceptible applications such as bundle cutting
- Suitable for use on metals with hardness up to 44HRc
- Ideal For: Mild Steel, Stainless Steel, Aluminium, Brass, Copper, Cast Iron

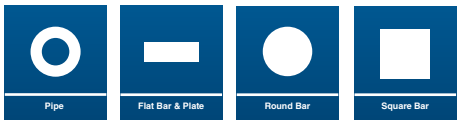


Excision® M51 Cobalt Bandsaw Blades

- Premium Bi-Metal Bandsaw Blade with 10% Cobalt and 10% Tungsten content
- Hook Tooth shape for fast cutting of larger solid sections
- Suitable for use on metals with hardness up to 50HRc
- Ideal For: Mild Steel, Stainless Steel, Aluminium, Brass, Copper, Cast Iron, Titanium, Hardened Steel

Excision® B0 TCT Bandsaw Blades

- Premium Tungsten Carbide Tipped (TCT) Bandsaw Blades
- Triple Chip Tooth geometry for fast and accurate cutting of larger solid sections
- Suitable for use on metals with hardness up to 64HRc
- Ideal For: Mild Steel, Stainless Steel, Aluminium, Brass, Copper, Cast Iron, Titanium, Hardened Steel



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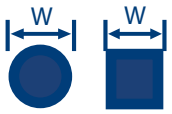
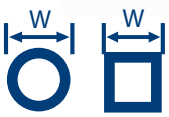
Tooth Pitch Selection Guide (Common Sections)

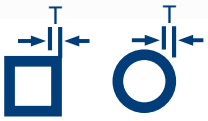
SOLIDS



Solid Width (W)	TPI
Up to 20	10/14
20 - 30	8/12
25 - 35	6/10
30 - 45	5/8
45 - 60	4/6
60 - 80	3/4
80 +	2/3

TUBES





Wall Thickness (T)

Tube Width (W)	0.6	1	1.6	2	2.5	3	4	5	6	7	8	9	10	12	15	20	50
10	14	14	10/14	10/14	10/14	10/14	10/14										
20	14	14	10/14	10/14	10/14	10/14	10/14	8/12	6/10								
25	14	14	10/14	10/14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	5/8				
30	14	14	10/14	10/14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	5/8	4/6			
40	14	14	10/14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6		
50	14	14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6		
60-120	14	14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	4/6	4/6	
130-150	14	14	10/14	8/12	8/12	8/12	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4
150-180	10/14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4	3/4
190-300	10/14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4	2/3
350-400	10/14	10/14	8/12	8/12	6/10	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	3/4	3/4	3/4	2/3
450-500	10/14	8/12	8/12	6/10	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	3/4	3/4	3/4	3/4	2/3

Troubleshooting

Crooked cut
- Dull blade
- Improper break-in
- Guide arms too far apart or out of alignment
- Damaged roller or carbide guides
- Feed rate too heavy or blade speed too slow
- Tooth pitch too fine
- Band tension too low
- Vice clamp out of square

Premature dulling of teeth
- Improper break-in
- Check coolant concentration & flow
- Check chip brush
- Check feed rates & blade speed
- Select proper tooth pitch

Stripping Teeth
- Wrong tooth selection
- Parts not held securely
- Feed rate too high or speed too slow
- Chip brush not working
- Check coolant concentration

Band Breakage
- Worn Guides
- Guide arms set too far apart
- Wrong band tension
- Feed rate too high
- Poor butt weld

Rough Cut
- Band speed too slow & feed rate too high
- Improper break-in
- Dull or damaged teeth
- Check chip brush

Your Blade Details

Blade Material:_____

Blade Size (L x W x T):_____

Blade Teeth (TPI):_____

Blade Speed Guide (Common Materials)

Material Type	Speed (m/min)
Structural Steel	75 - 80
Mild Steel	80 - 90
Stainless Steel (300 Series)	30 - 40
Cast Iron	30 - 50
Aluminium	80 - 180
Hardened Steel	25 - 40

Blade Run In Procedure

- Use normal recommended blade speed and reduce feed pressure by 50% for the first 15 minutes of cutting. Gradually increase feed pressure until correct rate is achieved.
- Remember - Proper running in of your bandsaw blade will greatly improve the cutting life.
- Never run your new blade in an old saw cut.
- Ensure correct tension. Tension to 300N/mm2.
- A poorly tensioned blade leads to premature wear, blade fatigue and eventual blade breakage.
- Maintain the correct cutting fluid. The fluid should wash, cool and lubricate both the blade and the material you are cutting.
- Use Excision® XDP Soluble Cutting Fluid

More details available at www.addler.com.au

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