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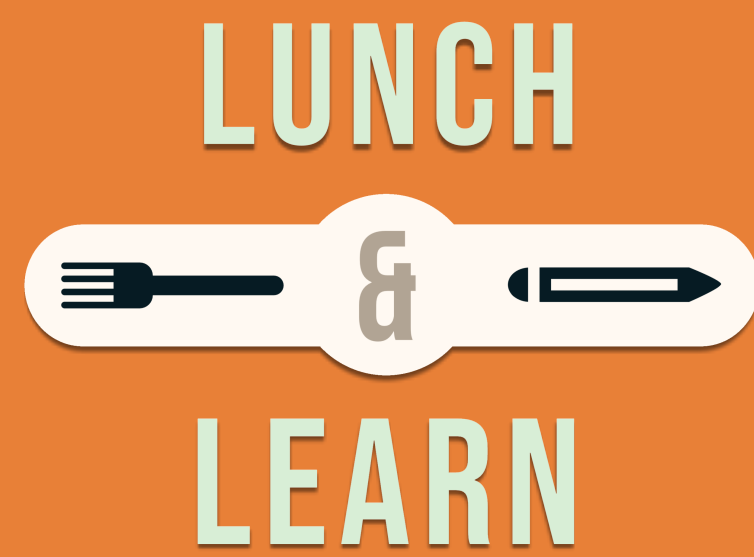
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TROUBLESHOOTING BAND SAWING

A **CUTTING TOOL
ENGINEERING**  webinar



INTRODUCTIONS

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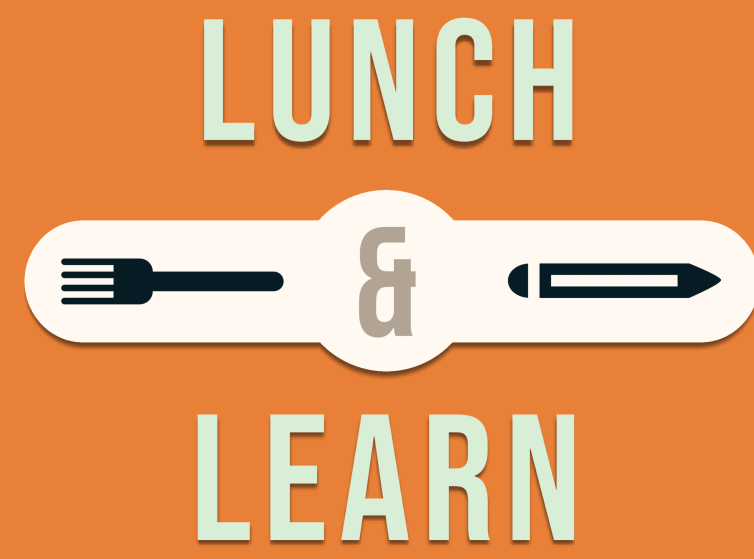


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FEATURED ARTICLE

CUTTING TOOL ENGINEERING

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ROI

Used correctly, cobots can give shops a quick return

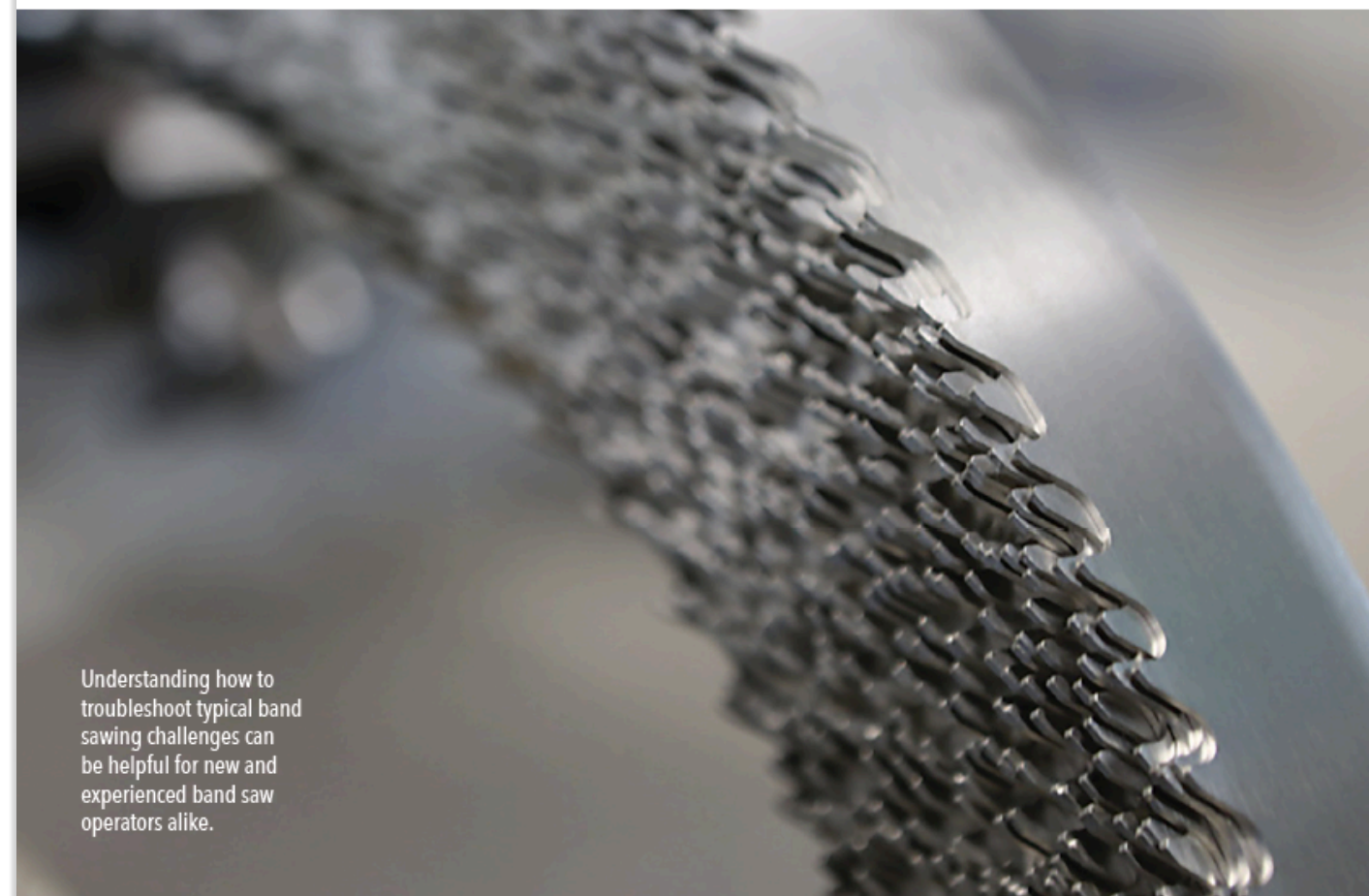
Also in this issue

- > Troubleshooting band sawing
- > Let EDMing do the cutting
- > The evolution of additive manufacturing

May 2023

TROUBLESHOOTING BAND SAWING

Solutions are shared for common challenges.



Understanding how to troubleshoot typical band sawing challenges can be helpful for new and experienced band saw operators alike.

L.S. Stewart

By Jay Gordon

Understanding how to troubleshoot typical band sawing challenges can be helpful for new and experienced band saw operators alike. Although cutting issues vary due to the material characteristics, size and shape, some general guidelines are a useful reference.

In addition to these tips, it is recommended to consult the manufacturer

of your band saw machine and blades for guidance in optimizing sawing operations.

Here are common challenges, their possible causes, results if not addressed and solutions.

Teeth Stripping

Improper break-in of the blade. An improper break-in leads to chipped teeth, which shorten blade life and possibly lead to tooth stripping. Follow the



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SURFACE GRINDER



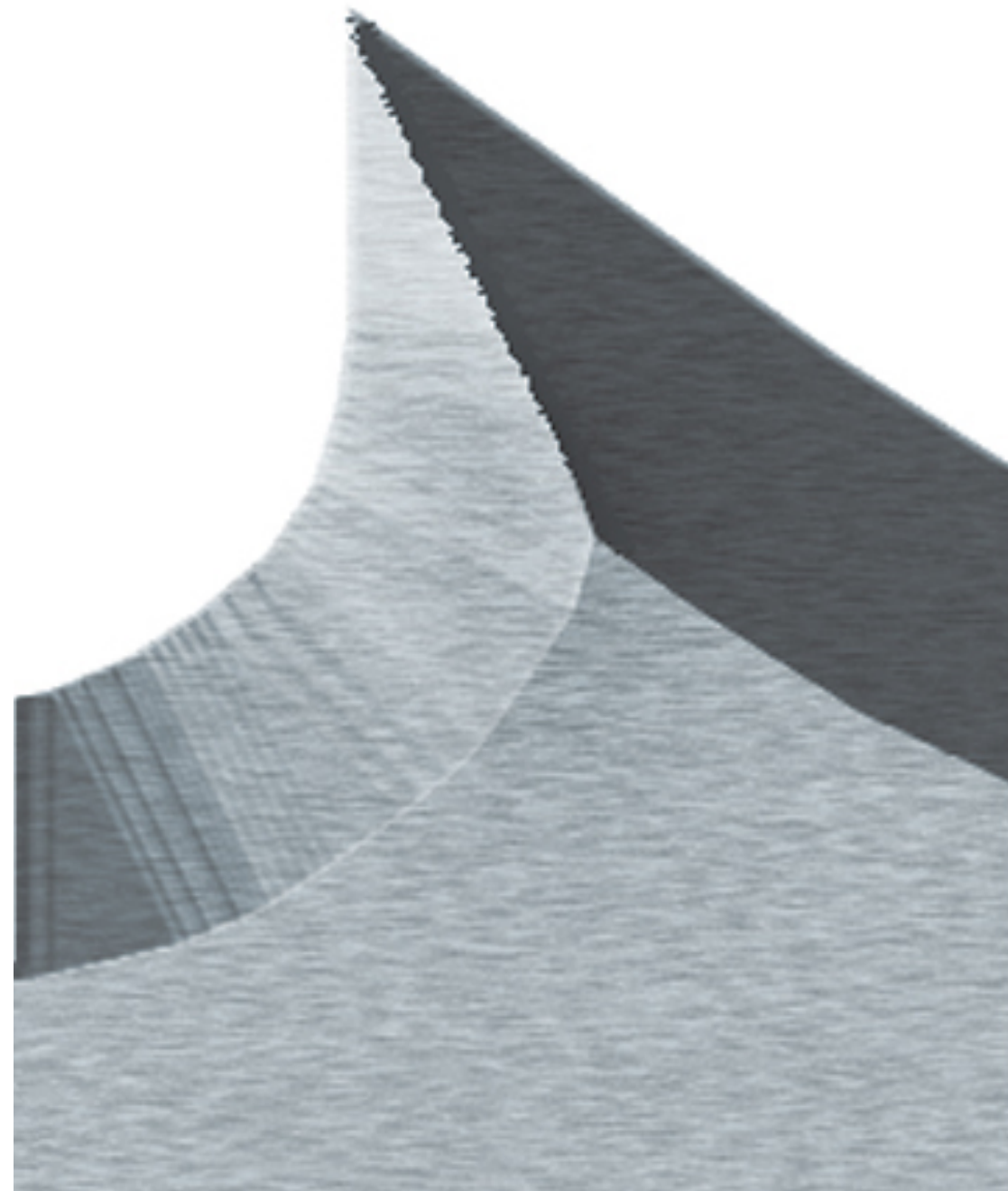


- ✓ The Right Blade for the Job
- ✓ Tooth Pitch – Number of Teeth In The Cut
- ✓ Blade Speed
- ✓ Feed Rate
- ✓ Cutting Fluid
- ✓ Blade Break-In

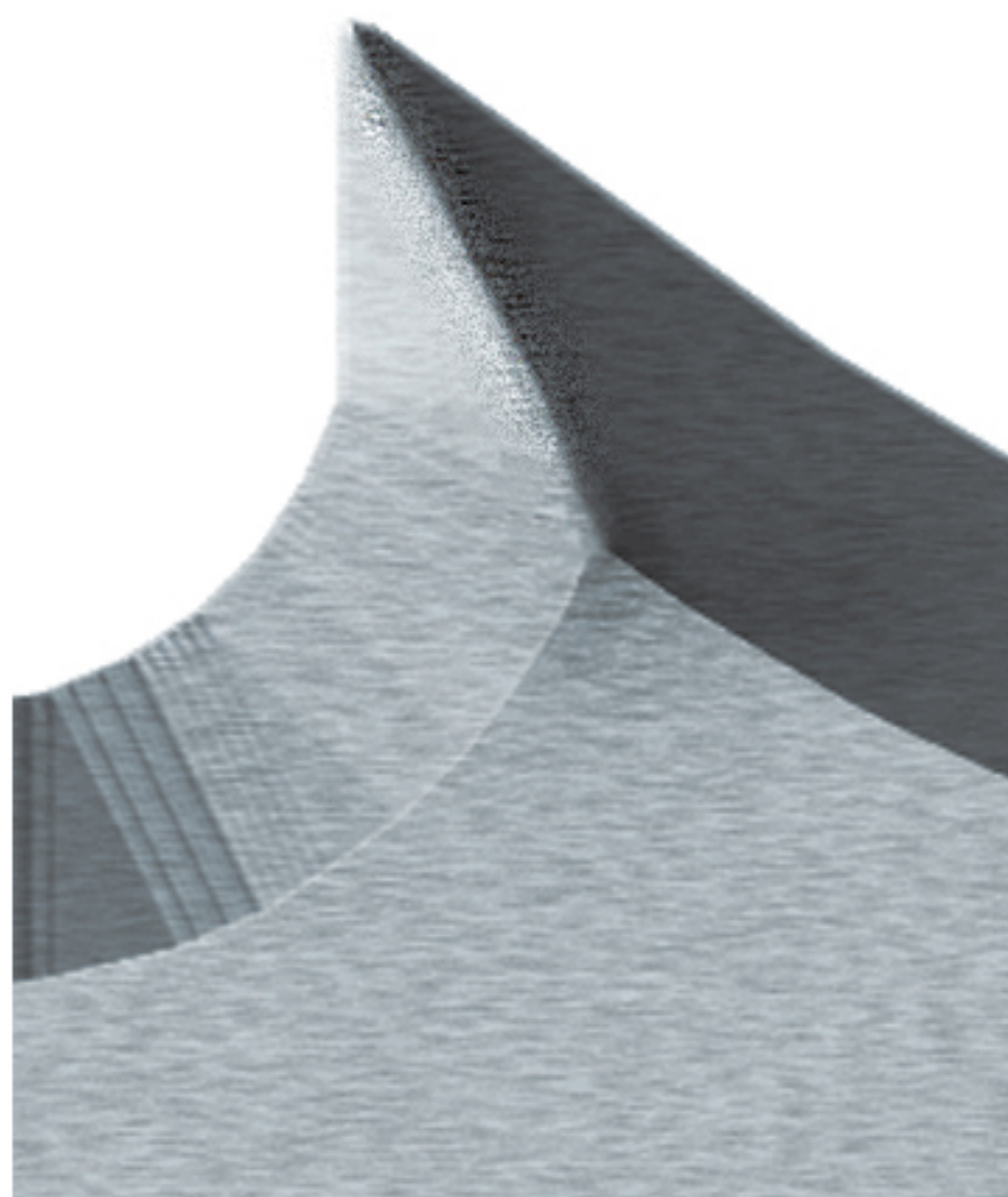
When everything is right, a band saw blade will cut lots of good quality parts, consistently!!

- What should be taken into consideration about the number of teeth per inch (blade pitch)?
- What is the optimal number of teeth to have in the cut at any time?
- How do we determine the right tooth profile to use?
- How do we determine the right blade feeds and speeds?
- How does cutting fluid factor into my sawing process?

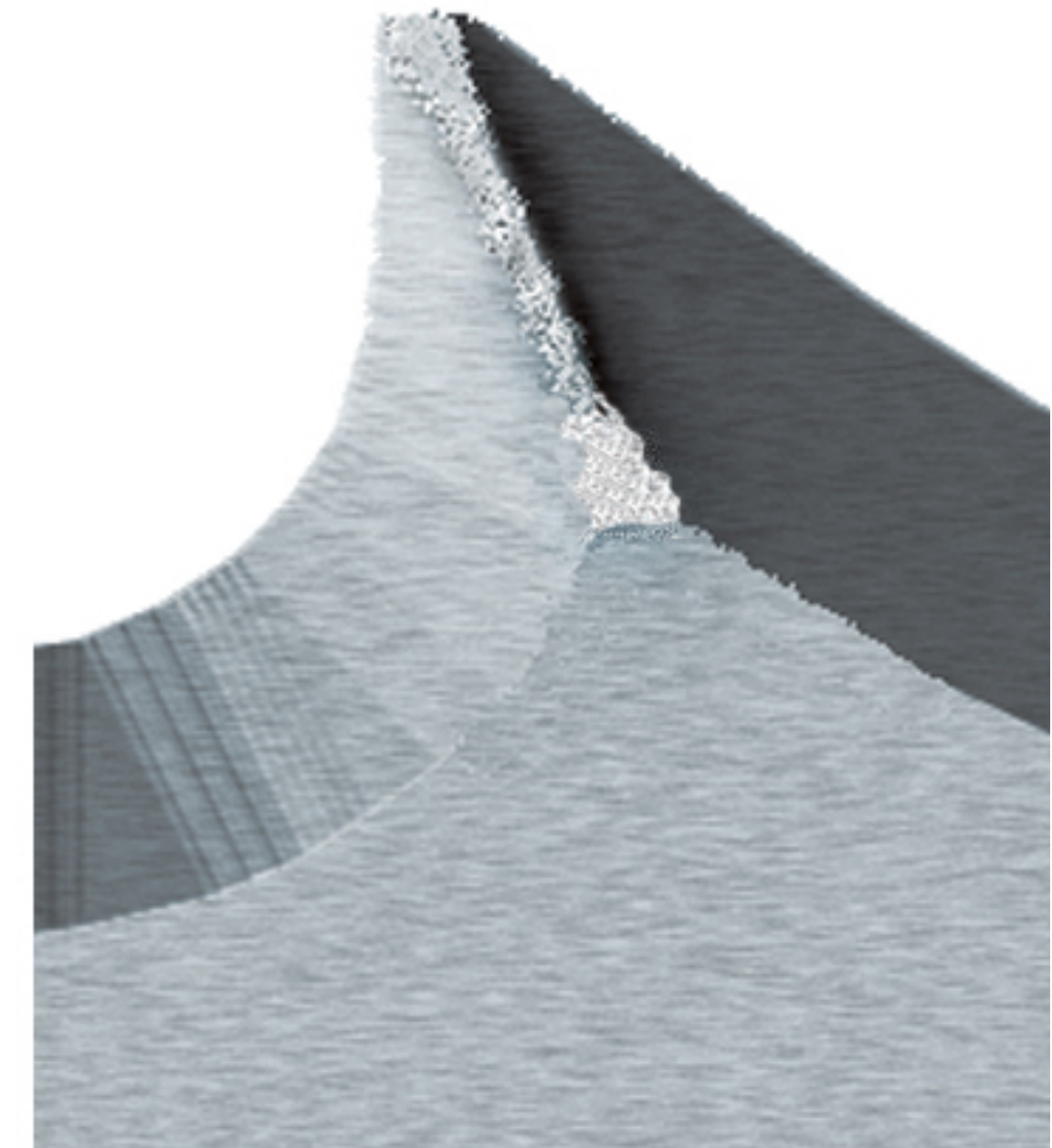
- Is it necessary to break in a band saw blade?
- What changes are you looking for in the blade to know when it's broken in sufficiently?



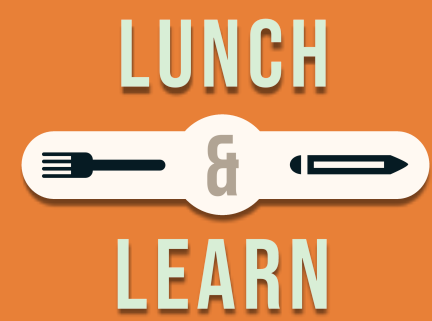
**NEW BLADE WITH
RAZOR SHARP TEETH**



**TOOTH CORRECTLY
BROKEN IN**



**TOOTH INCORRECTLY
BROKEN IN**



QUESTIONS



- What materials are considered the most challenging to cut, and what are the challenges?
- And in what industries do we generally see these materials?



- What factors are involved in selecting the right band saw blade for a particular application?



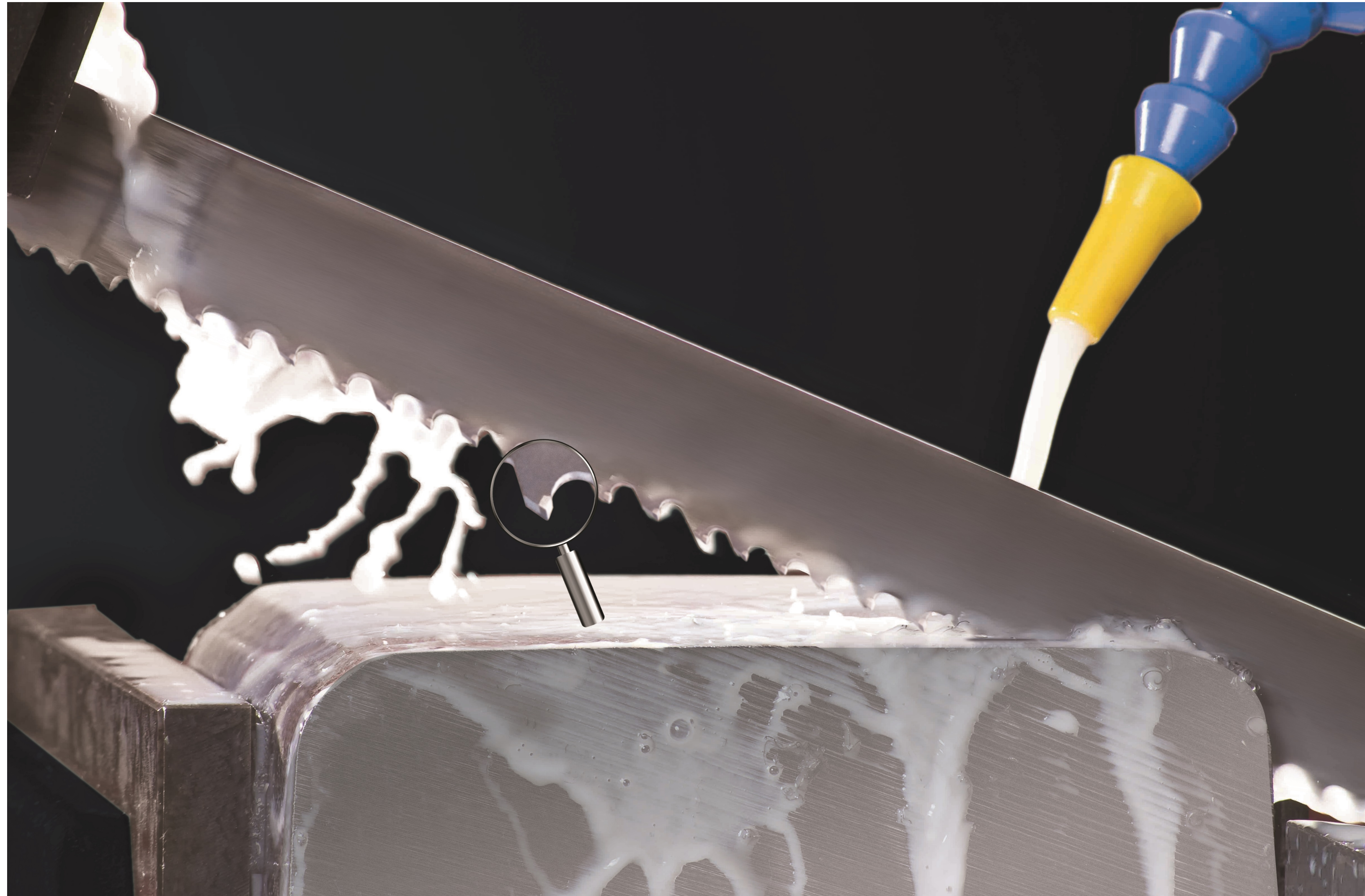
QUESTIONS



- When is a bi-metal blade the best option?



QUESTIONS



- When should carbide-tipped blades be selected?



QUESTIONS



- We have four fixed speeds on our saw. Are there other ways to compensate when we don't have an exact match for the recommended speed?
- What's the proper choice for a vertical band saw blade for all-around use in a small shop to avoid constant blade changes?

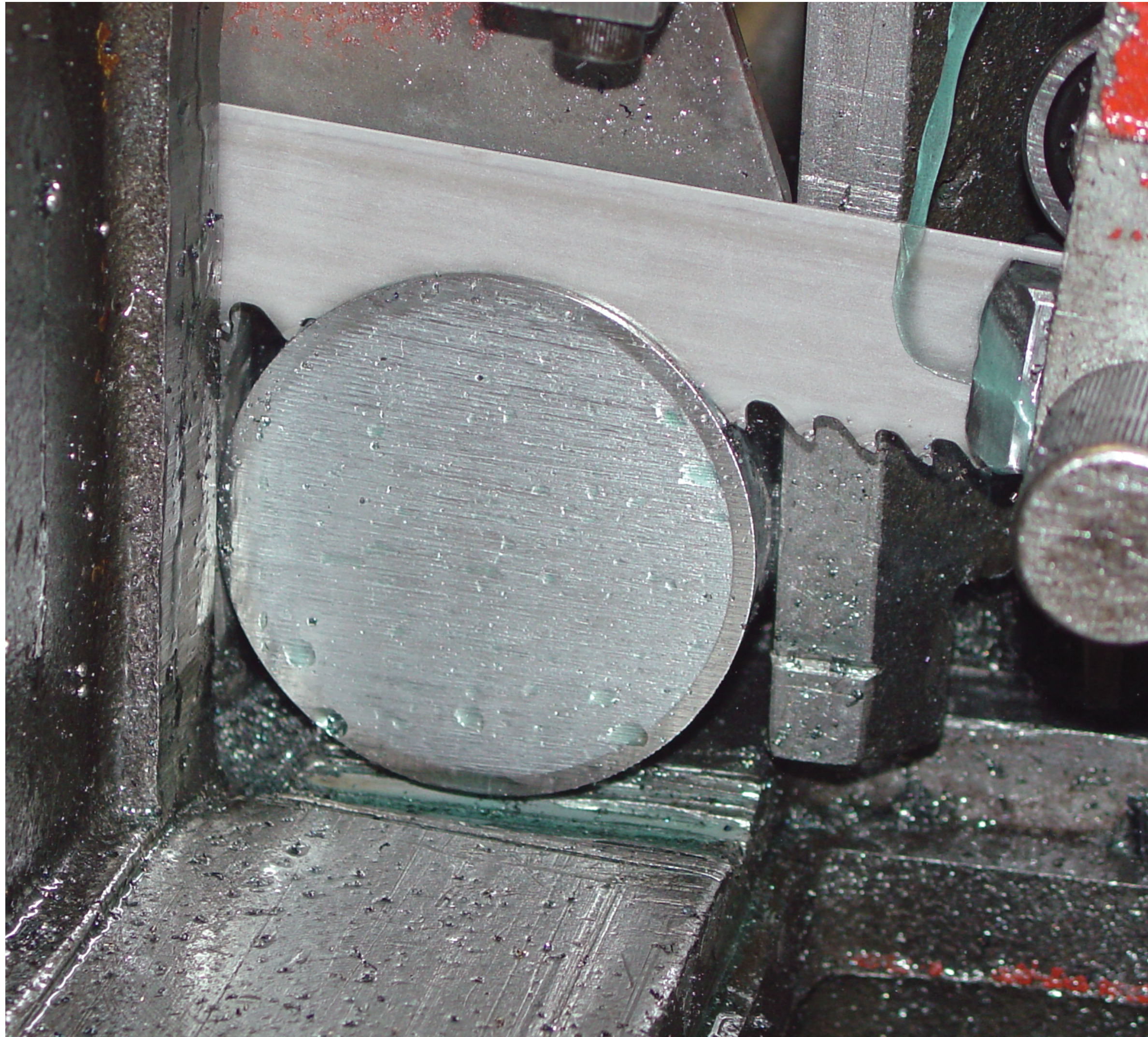


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QUESTIONS

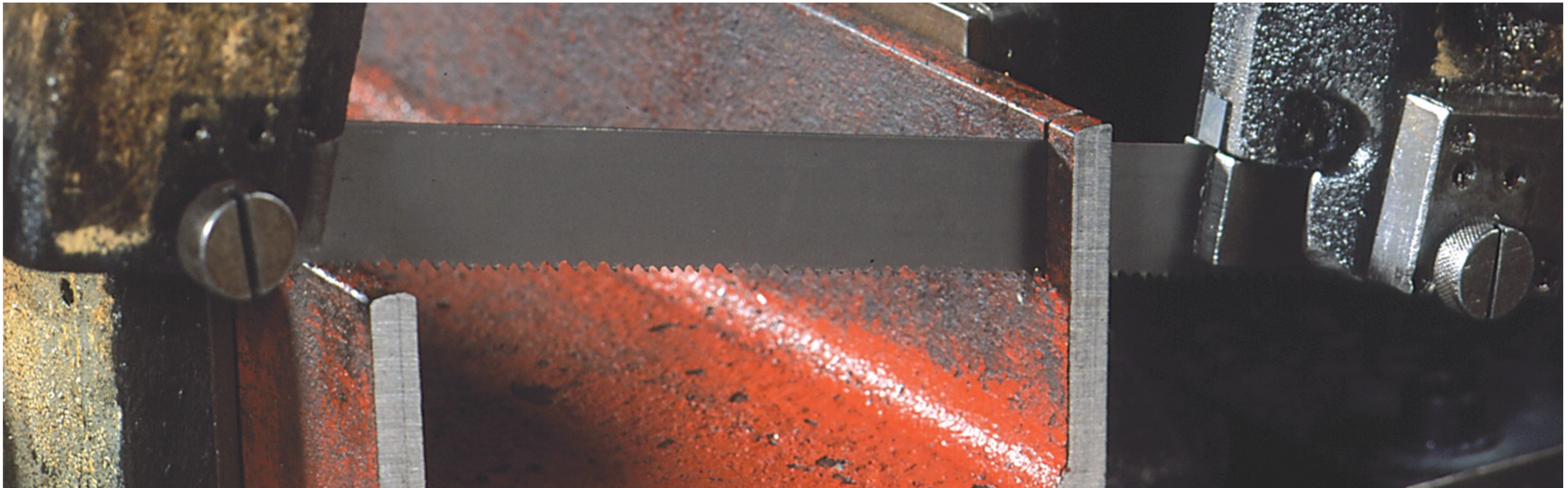


- Technology makes it easier to be more precise. But do you have any advice for being the most precise on more manual/older saws?



- What's a good blade for cutting chrome-plated induction hardened round?

- How does a new operator get up to speed, and what are the basics you recommend every operator know before cutting?





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