How many cuts are needed for breaking in a band?

> # of break-in cuts = $\dfrac{\text{Recommended square inches for break-in}}{\text{Area of work piece}}$

1. Set up band speed at the recommended feet per minute for the material to be cut. Refer to *Cle-Line Speeds for Bi-Metal Band Saw Blades* chart.

2. Reduce feed rate by 50%. Square inches to cut for break-in:

Band Speed (SFPM):	300	250	200	150	100	50
Square inches to cut for break-in:	90	75	60	40	25	10

3. Increase the feed slightly after cutting a distance equal to the width of the blade.

4. Increase the feed again slightly as the blade reaches the halfway point of the cut. Finish the cut without increasing the feed again.

5. Start the next cut with the same feed rate which ended the preceding cut. Increase the feed rate again before reaching the halfway point of the cut.

6. Repeat Step 5 until the blade reaches the required number of square inches per minute as found on the *Cle-Line Speeds for Bi-Metal Band Saw Blades* chart, or 20 minutes of cutting, before increasing feed pressure.
   Note: A minimum of 50 square inches of material should be achieved before you complete the break-in procedure.

Technical Tip:

Number of Cuts for Optimum Blade Break-In

$\dfrac{\text{50 Sq.In. (sq in for break-in)}}{\text{Area of Work piece}}$ = Number of Cuts Required

Determining Time of Cut for Optimum Blade Life

$\dfrac{\text{Area of Workpiece}}{\text{Cutting Rate (sq. in. /min.)}}$ = Time of Cut

See *Cle-Line Speeds for Bi-Metal Band Saw Blades* chart

How To Determine Area of a Round

Diameter squared X .7854 = Area of a Round

Example : 6" round X 6 = 36 X .7854 = 28.27 square inches