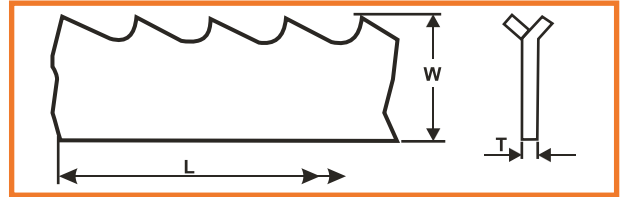




Bandsaw Blades



Metal cutting Bandsaw Blades are Made from Carbon steel.

Metal cutting Bandsaw Rolls are manufactured with 4, 6, 8, 10, 14, 18, 24 TPI., Length 30.50 Mtrs. (100 ft.)

Metal cutting Bandsaw Coiles are manufactured with Raker and wavy set & Length 8' 3" (2515 mm.) 9' 10" (2997 mm), 11' 1/2" (3544mm).

METAL CUTTING BAND SAW BLADE ROLL						
INCHES		MILLIMETERS		LENGTH METERS L	TEETH PER INCH (TPI)	
WIDTH W	THICKNESS T	WIDTH W	THICKNESS T		RAKER SET	WAVY SET
1/4	0.025	6.35	0.63	30.5	10, 14	18, 24
3/8	0.025	9.53	0.63	30.5	6, 8, 10, 14	18, 24
1/2	0.025	12.70	0.63	30.5	6, 8, 10, 14	18, 24
1/2	0.025	12.70	0.63	30.5	6	--
5/8	0.032	15.88	0.80	30.5	6, 8, 10, 14	18, 24
3/4	0.032	19.05	0.80	30.5	4, 6, 8, 10, 14	18, 24
3/4	0.032	19.05	0.80	30.5	6	--
1	0.035	25.40	0.90	30.5	4, 6, 8, 10, 14	18, 24

Packing

- Bulk Packing
- Single Piece Packing
- As per customer requirement



ALLIED INDIA CORPORATION

Metal Cutting Band Saw Blade Selection Chart

Work Thickness In Inches	1/8"	1/4"	1"	2"	1/8"	1/4"	1"	2" & Over
Material to be cut	Pitch T. P. I.				Cutting Speed feet/Minute			
Free machining steel	18	14	10	6	250	200	175	150
Mild Steel	24	14	10	6	250	200	175	150
Carbon Steel	24	14	10	6	250	200	175	150
Annealed Tool & Alloy Steel	24	18	10	6	100	80	60	40
Alloy Construction Steel	24	14	10	8	175	150	125	100
High Speed Steel	24	14	10	8	150	100	75	50
Stainless Steel	24	14	10	8	100	75	50	50
Tubings	24	14	-	-	175	150	--	--
Grey Cast Iron	18	14	10	6	200	150	100	75
Malleable Cast Iron	18	10	8	6	200	175	150	125
Meehanite	18	10	8	6	150	100	75	50
Copper	-	10	8	6	--	1500	1500	1500
Aluminium	18	14	6	6	1800	1400	800	600
Phosphor Bronze	18	10	10	6	1200	900	700	700
Plastic	18	10	8	6	1500	2000	1500	1500
Asbestos	18	10	8	6	4000	3500	3000	3000
Phenolic	18	10	8	6	4500	4000	3500	3000
Paper	18	10	8	6	1500	1500	1500	1500
Rubber (Hard)	18	10	8	6	4000	3800	3000	3000

Feed Rate Chart

Feed Rate : Linear inch per minute						
Work Thickness	1/4"	1/2"	1"	1-1/2"	3"	6"
Carbon Steel	4.50	2.12	1.00	0.62	0.31	0.12
Cold Rolled Mild Steel	9.00	4.00	1.75	1.12	0.50	0.25
Cast Iron	16.00	7.50	3.25	2.12	1.00	0.43
High Carbon, High-Chrome Steel	2.25	1.00	0.50	0.25	0.12	0.03

Trouble Shooting

Problem	Cause	Remedy
1. Teeth Ripping	<ul style="list-style-type: none"> Teeth too coarse Excessive Feed / Load Gullets filling up Vibrating Work Piece 	<ul style="list-style-type: none"> Check if higher TPI saw is required Decrease to recommended pressure/load Check spring tension of blade On vertical machines, the work is hand-fed, Feeding pressure should be moderate and steady. Use thicker cutting oil Clamp and level securely A slight movement of the piece causes the teeth to rip out On vertical machines, as the work is hand-fed, adequate experience and care is required to feed the work with steady pressure, at the same time without causing vibration, Advice screw feed wherever possible.
2. Excessive blade breakage	<ul style="list-style-type: none"> Teeth too coarse Excessive tension Very heavy feed Misaligned guides Very high speed Lack of coolant Weld not annealed 	<ul style="list-style-type: none"> Check if higher TPI saw is recommended. Reduce tension Decrease to recommended pressure/load (15 kg. on Horiz. M/c.) Adjust guides. Decrease to recommended speed. Always use cutting coolant Anneal the weld satisfactorily
3. Early teeth wear	<ul style="list-style-type: none"> Teeth too coarse Very high speed Too light a feed Lack of coolant Cut is binding the blade 	<ul style="list-style-type: none"> Use a finer tooth blade. Decrease to recommended speed Increase to recommended pressure/load Always use cutting oil/coolant Decrease pressure/load
4. Blade twisting	<ul style="list-style-type: none"> Excessive blade tension Guides too close to work 	<ul style="list-style-type: none"> Decrease the tension Widen gap between guides.