

BREAK-IN PROCEDURES

Question: How many cuts are needed for breaking in a band?

Formula: # of break-in cuts = $\frac{\text{Recommended square inches for break-in}}{\text{Area of work piece}}$

STEP 1: Set up band speed at the recommended feet per minute for the material to be cut. Refer to M. K. Morse cutting chart.

STEP 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

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

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

STEP 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.

STEP 6: Repeat Step 5 until the blade reaches the required number of square inches* per minute as found on the M. K. Morse Speed & Feed 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.**

HELPFUL HINTS

Number of Cuts for Optimum Blade Break-In

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

Determining Time of Cut for Optimum Blade Life

$\frac{\text{Area of Workpiece}}{\text{Cutting Rate (Sq. in. /min.)}} = \text{Time of Cut}$
See M. K. Morse Speed & Feed 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