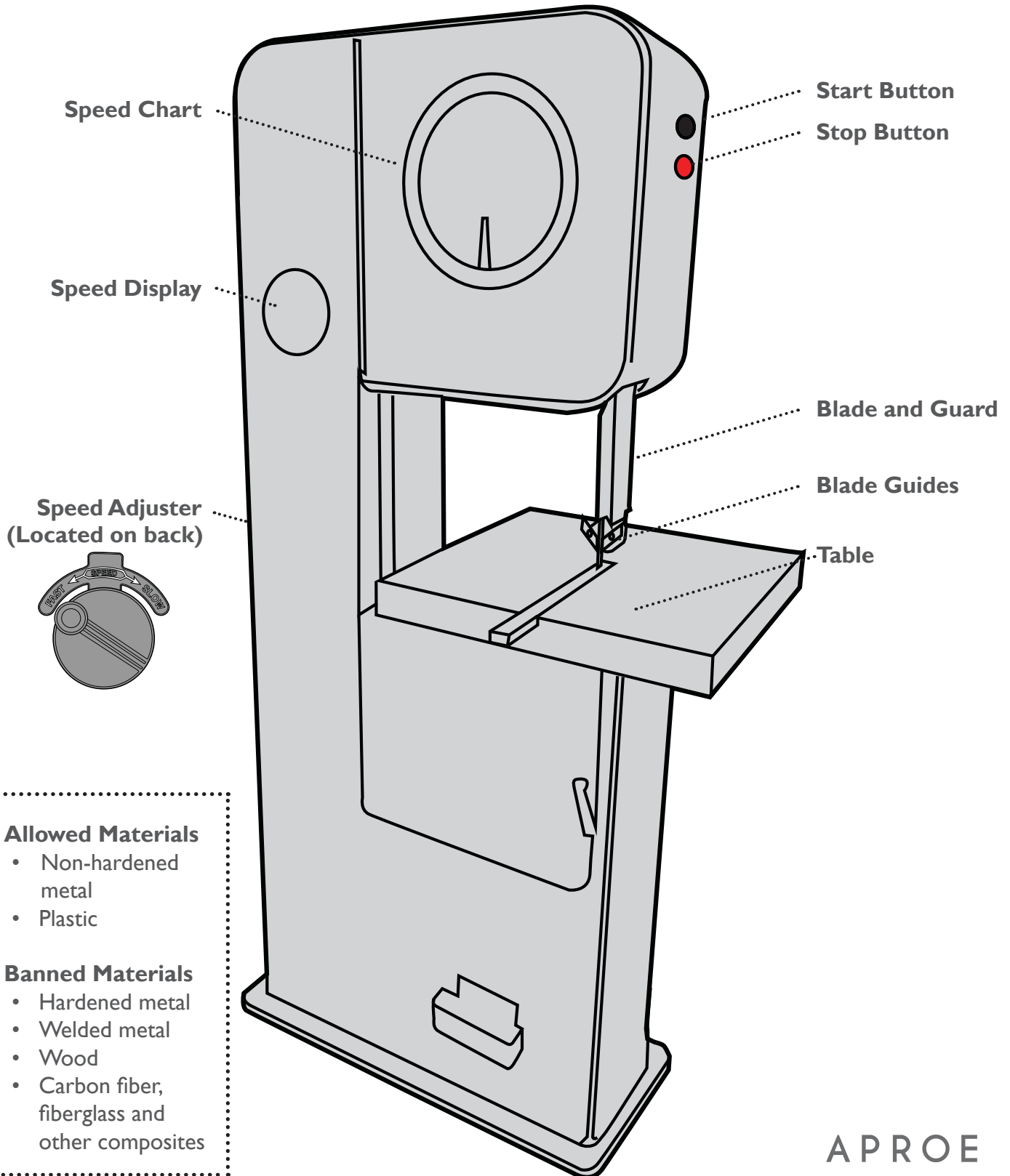


Vertical Metal Bandsaw

Major Parts and Controls



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Vertical Metal Bandsaw

Major Safety Concerns



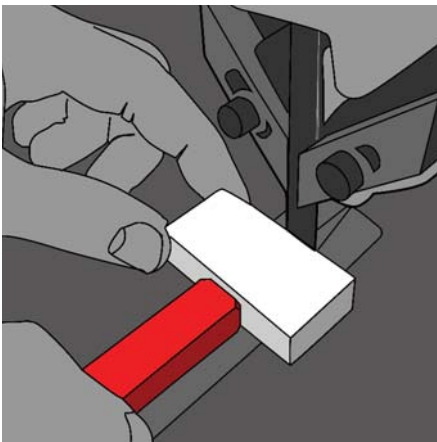
* **Keep fingers away from the blade.**



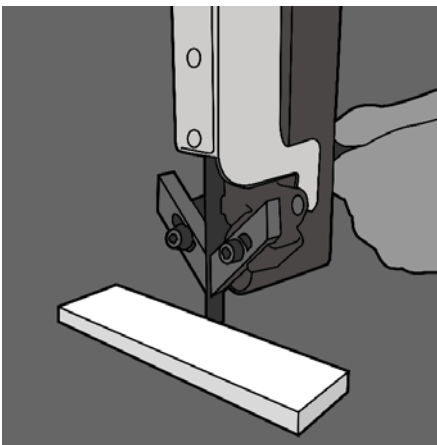
Protect your eyes from flying chips.



Avoid loose clothing and other items that could be caught on moving equipment.



Use a push stick when cutting small pieces.



Lower the blade guard to within 1/4" of your work.



Always wear safety glasses.



Always wear short sleeves, pull back hair and remove any item that dangles (lanyards, jewelry, watches).

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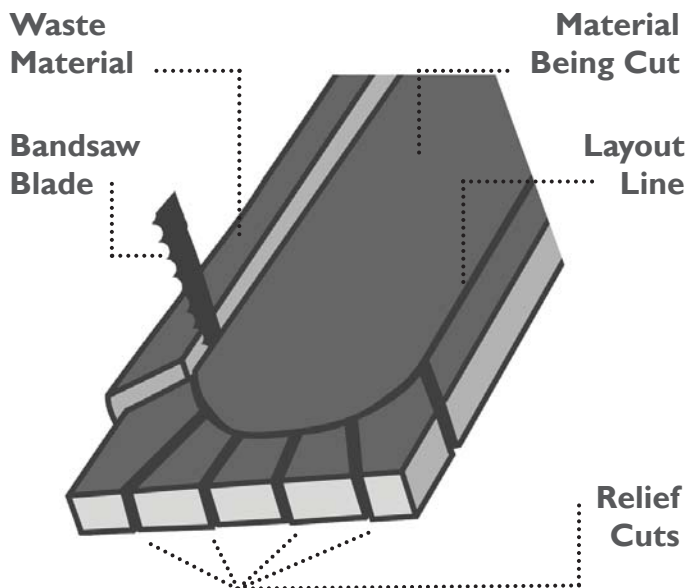
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* Yellow icons created for and property of Autodesk

Cutting Theory

The number of *teeth per inch* (TPI) of a blade will change how it cuts. More teeth will result in a slower, but smoother cut. Fewer teeth will leave a rougher edge, but cut faster.

Shop policy recommends a minimum of 3 teeth in the material being cut, at all times. Contact Shop Staff for blade changes.



Making Curved Cuts

Blades have a minimum cut radius depending on the width of the blade

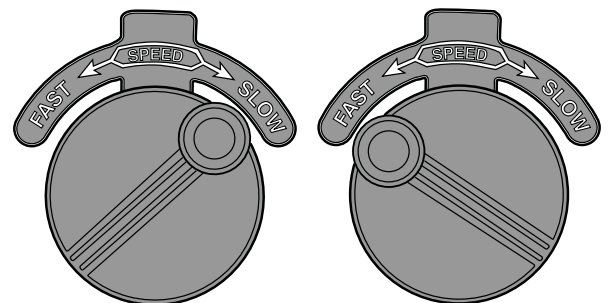
- Forcing a blade to make too tight of a radius will result in friction that heats the work and blade, causing damage to both.
- Make *relief cuts* to create a small radius.

Changing Blade Speed

Use the chart on the front of the saw to determine the correct blade speed.

The saw must be running before changing speed.

Turn the speed adjuster handle until the display shows the correct speed.



Making Straight Cuts

Every bandsaw has some amount of *drift*.

- While cutting straight with the blade, it will pull to one side or the other.
- Adjust the angle of your work to make a straight cut.

Vertical Metal Bandsaw

Hands On

Area and Machine Preparation

1. Clean and clear the table.
2. Make sure there is sufficient room around the saw for your workpiece.
3. Have a push stick ready and within easy reach.
4. Adjust the blade guard height.
 - The height of the blade guide should be about $\frac{1}{4}$ " above your material.
 - The blade guard covers the blade and helps reduce the chance of injury.

Properly adjust the blade guard every time.

Making the Cut

1. Turn on the blade and wait for the saw to come up to speed.
2. Adjust the blade speed.
3. Slowly push the material into the blade.
 - Experience will help you determine the correct speed for the material, thickness, blade type and other variables.
4. Keep at least one hand or a clamp on the material; never completely let go.
5. Stay in control of the material until it is past the back of the blade.
6. Turn off the blade, and wait for it to stop moving.

Do not clean off the table with your hand while the blade is moving.

Cleanup

1. Wait for the blade to stop moving.
2. Brush off the table.
3. Lower the blade guard all the way down.
4. Clean up the area.
5. Put scraps in the recycle bin and reusable pieces in the correct storage rack.
6. Sweep the floor.

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