LIZEN SAW

Metal Sawing Tools & Machines | Technical RFQ Guide

Band Saw Blade Break-in & Life Improvement Guide

Practical setup guide for fewer early tooth failures and more stable band saw blade performance.

English PDF for buyers. Chinese meaning: this is a practical quotation and selection reference, not a final supplier specification sheet.

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How to use this guide

Use this document to prepare RFQ information before asking for quotation.
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• Send material grade, size, machine model, quantity, destination country, and photos when available.

• Final product model, capacity, power, size, coating, packing, and lead time must be confirmed by quotation.

• For distributor or OEM orders, keep the confirmed specification record for repeat purchases.

Why break-in matters

New tooth edges need controlled first cuts. ??????????????????????????

Break-in procedure

Step	Action	Purpose
1	Check blade tension, guide, coolant, clamping	Avoid machine-related failure
2	Use about 50% normal feed pressure for initial cuts	Protect new tooth edges
3	Keep coolant stable and directed into the cut	Reduce heat and tooth wear
4	Increase feed gradually after break-in	Reach normal production
5	Check chip shape and color	Verify speed/feed setting

Common causes of short blade life

Problem	Possible cause	What to check
Tooth stripping	Wrong pitch, high feed, no break-in	TPI, feed pressure, material hardness
Crooked cut	Low tension, worn guide, excessive feed	Guide, tension, blade width
Vibration	Thin wall, wrong pitch, loose bundle	Variable pitch and clamping
Heat marks	Low coolant, speed/feed mismatch	Coolant, blade speed, material

RFQ message template

Field	Buyer should provide
Product	Band saw blade / band saw machine / circular saw machine / circular saw blade
Material	Material grade, hardness if known, solid/tube/profile/bundle condition
Size	Workpiece size, blade size, saw blade diameter, or machine model
Quantity	Trial order quantity, monthly demand, or project quantity
Country	Destination country/port and voltage requirement for machines

Disclaimer: Reference data in this guide is for selection and RFQ preparation. Final specifications must be confirmed by the selected model sheet, quotation, and supplier confirmation before order.