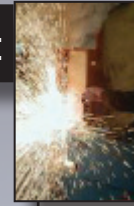# High Production Bandsaw Blade Welding Facility

3 Fully Automatic High Production Blade Welding Machines:

- The Fastest, Most Accurate & Consistent machines in the industry
- Zero Set-Up time from 3/16" wide blades up to 3-1/8" Wide
- Over 400 blades custom welded to length daily & shipped throughout North America
- Orders Shipped Same Day!!!

Technical Support:

- We provide the absolute best bandsawing technical support in the industry
- Application solutions to optimize efficiency
- Troubleshooting support
- Preventative Maintenance support

Our Blade Coil Inventory:

- About $500,000 in Coil Stock
- Carbon Steel Flexback & Hardback
- Meat Cutting, Bandknife
- Bimetal Matrix & M42
- Carbide Tipped & Carbide Grit
- 3/16" Wide to 3-1/8" Wide
- The most comprehensive range of tooth pitches to select from for same day shipping

Automatic Cut To Length Machine:

- PLC Automatic Cut To Length Machine
- Capable of Automatically cutting to length up to 600 blades per hour
- Assures extreme precision & consistency of length & tooth match
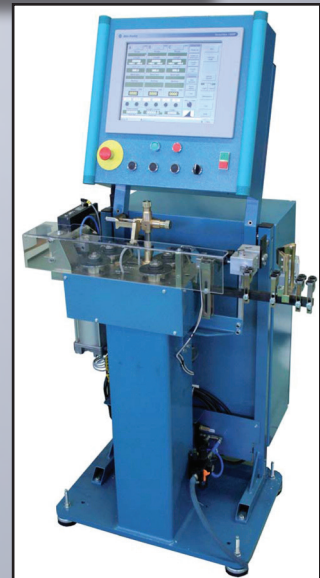
Our Winnipeg Welding Facility is the Largest, Most State of the Art in Western Canada!

The Best Blade Lines On The Market:

AMADA

EDGE MANUFACTURING

MORSE — THE M.K. MORSE COMPANY

SIMMONS

KASCO CORPORATION

SPENCE Manufacturing

'Your Industrial Tool Specialist'

89 Merit Cres.
Winnipeg, MB. R2P 2W5
Ph: (204) 633-6603 or (800) 694-4021
Fax: (204) 694-6058
sales@spencemanufacturing.com
www.spencemanufacturing.com

Tooth Selection Charts

Rectangular Solids (Use Width) & Round Solids (Use Diameter)

Inches	Teeth Per Inch (Rectangular Solids)	Teeth Per Inch (Round Solids)
0		
.1	14/18	14/18
.2	14/18	14/18
.3	10/14	10/14
.4	8/12	8/12
.5	8/12	8/12
.6	6/10	8/12
.7	6/10	6/10
.8	5/8	6/10
.9	5/8	6/10
1	5/8	5/8
1-1/4	5/8	5/8
1-1/2	4/6	5/8
1-3/4	4/6	5/8
2	4/6	4/6
2-1/4	4/6	4/6
2-1/2	4/6	4/6
2-3/4	4/6	4/6
3	3/4	4/6
3-1/4	3/4	4/6
3-1/2	3/4	4/6
3-3/4	3/4	3/4
4	3/4	3/4
5	2/3	3/4
6	2/3	3/4
7	2/3	3/4
8	2/3	2/3
9	2/3	2/3
10	2/3	2/3

- **RECTANGULAR SOLIDS: (USE WIDTH)**
- **ROUND SOLIDS: (USE DIAMETER)**

Pipe Tubing Structurals (Use Wall Thickness)

Wall Thickness	Teeth Per Inch	Wall Thickness
1/16		0.06
1/8	10/14	0.13
	8/12	
3/16	6/10	0.19
1/4	6/10	0.25
5/16	5/8	0.31
3/8	5/8	0.38
7/16	5/8	0.44
1/2	5/8	0.50
9/16	4/6	0.56
5/8	4/6	0.63
11/16	4/6	0.69
3/4	4/6	0.75
13/16	4/6	0.81
7/8	4/6	0.88
15/16	3/4	0.94
1	3/4	1.00
1-1/8	3/4	1.13
1-1/4	3/4	1.25
1-3/8	2/3	1.38
1-1/2	2/3	1.50

PIPE TUBING STRUCTURALS (USE WALL THICKNESS)

Band saw tooth size is determined by the size and type of material to be cut and the desired finish. Select a pitch based on the chart to the left. Find material dimension on chart and move right for appropriate teeth per inch.

For angle, tubing, pipe, and other structural shapes, find the wall thickness in size column & move right for tooth size

Cutting speed - Structurals Rule of thumb:

When cutting structurals use a cutting speed of
250-325 S.F.M. Wet
200-250 S.F.M. Dry

BLADE BREAK-IN EXTREMELY IMPORTANT!

The extremely sharp tooth points and edges of new, unused blades must be broken in before applying full feed pressure to the blade. A good analogy is that of writing with a freshly sharpened wooden pencil.

RECOMMENDED PROCEDURE

- *Maintain proper blade speed for the material to be cut.*
- *Reduce blade feed pressure or feed rate by 50% for the first 50 to 100 square inches of material cut.*
- *Gradually increase feed pressure or feed rate after break-in to full pressure or rate.*