

THE M.K. MORSE COMPANY

## **BREAK-IN PROCEDURES**

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

- Formula: # of break-in cuts = <u>Recommended square inches for break-in</u> 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%<br/>Square inches to cut for break-in:<br/>Band Speed (SFPM):300 250 200 150 100 50<br/>Square inches to cut for break-in:907560402510
- STEP 3: Increase the feed <u>slightly</u> 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: 50 Sq.In. (sq in for break-in). Area of Work piece Determining Time of Cut for Optimum Blade Life Area of Workpiece = Time of Cut Cutting Rate (Sq. in./min.) 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