



## CHOOSING BANDSAW BLADES: PRE-FLIGHT CHECKLIST

- Clean your bandsaw's table surface, fence and mitre slots. Apply a good paste wax to keep friction to a minimal.
- Round the back of your blades with a file or honing stone. This removes any manufacturing imperfections and prevents sourcing of the thrust bearings and binding when cutting curves.
- Keep the blade lubricated, no matter what material you are cutting.
- Clear away sawdust buildup on the blade guide bearing and drive components.
- Clear sawdust and debris from the table insert blade guide.
- Always release blade tension at the end of the day.

### FLUTTER TESTING *Flutter testing is essentially the same for all machines.*

- Check the V-belt tension on the motor. Replace if loose.
- Remove the blade guides. ***This is Important!***
- Check the bandsaw tires. Ensure they are in good condition.
- Mount blade and apply manufacturer's recommended tension.
- CLOSE ALL COVERS FOR SAFETY!**
- Start the machine and engage highest cutting speed.



## **FLUTTER TESTING: Spring Tension/Turn Screw Machines**

- Stand at the head of the machine. Very slowly start de-tensioning, half a turn of the turn screw at a time, while keeping an eye on the blade.
- When you see the bandsaw blade start to wobble or flutter, stop there. That's your zero point.
- Now, go to the other way and start adding tension, a quarter at a time, until the flutter stops and the blade stabilizes again.
- Then, add 1/8 to approximately 1/4 of a turn.

## **FLUTTER TESTING: Hydraulic Tension Machines**

- Run the test as above except de-tension by 20-25 pounds at a time. When re-tensioning, and after you remove the flutter, add an extra 50 pounds of pressure.

## **FLUTTER TESTING: Air Bag Tension Machines**

- Again, run the test as above, but de-tension by 15 pounds at a time. After flutter has been removed, add an additional 15 pounds.

*Once you've adjusted the tension, shut off the machine, reinstall the guides and start sawing.*