

Horizontal Bandsaw Worksheet

1. Using the “Blade Selection Guide” in the Machinery’s Handbook, determine the best blade pitch when cutting the following:
 - 1” x 4” Rectangle Stock – 4” is the length of cut
 - Blade: _____
2. Using the “Blade Selection Guide” in the Machinery’s Handbook, determine the best blade pitch when cutting the following:
 - 1-1/2 x 1-1/2” Square Stock – 1-1/2” is the length of cut
 - Blade: _____
3. Using the “Blade Selection Guide” in the Machinery’s Handbook, determine the best blade pitch when cutting the following:
 - Ø2” Round Stock – 2” is the length of cut
 - Blade: _____
4. Using the “Blade Selection Guide” in the Machinery’s Handbook, determine the best blade pitch when cutting the following:
 - 1-1/2” x 6” Rectangle Stock:
 - Length of cut: _____
 - Blade: _____
5. Using the “Blade Selection Guide” in the Machinery’s Handbook, determine the best blade pitch when cutting the following:
 - 3/4” Square Stock
 - Length of Cut: _____
 - Blade: _____
6. Using the “Blade Selection Guide” in the Machinery’s Handbook, determine the best blade pitch when cutting the following:
 - Ø2-3/8” Round Stock
 - Length of cut: _____
 - Blade: _____

7. Using the “Band Saw Speed & Feed Rate” chart, determine the cutting rate (in²/min) and band speed (ft/min) for 1018 steel.

○ Cutting Rate: _____

○ Band Speed: _____

8. Using the “Band Saw Speed & Feed Rate” chart, determine the cutting rate (in²/min) and band speed (ft/min) for 41L40 steel.

○ Cutting Rate: _____

○ Band Speed: _____

9. Using the “Band Saw Speed & Feed Rate” chart, determine the cutting rate (in²/min) and band speed (ft/min) for 316 stainless steel.

○ Cutting Rate: _____

○ Band Speed: _____

10. Using the “Band Saw Speed & Feed Rate” chart, determine the cutting rate (in²/min) and band speed (ft/min) for A48 (60 ksi) cast iron.

○ Cutting Rate: _____

○ Band Speed: _____

11. Using the “Band Saw Speed & Feed Rate” chart, determine the cutting rate (in²/min) and band speed (ft/min) for 6061 aluminum.

○ Cutting Rate: _____

○ Band Speed: _____

12. Application #1

- 1-1/2" x 5" Rectangle Stock – 7075 Aluminum:
 - Length of cut: _____
 - Blade: _____
 - Cutting Rate: _____ (Machinery's Handbook)
 - Band Speed: _____ (Machinery's Handbook)
 - Band Speed: _____ (Actual machine setting)
 - Cutting Rate: _____ (Based upon actual machine speed)
 - Cutting Time: _____

13. Application #2

- 1-1/4" x Square Stock – 1137 Steel:
 - Length of cut: _____
 - Blade: _____
 - Cutting Rate: _____ (Machinery's Handbook)
 - Band Speed: _____ (Machinery's Handbook)
 - Band Speed: _____ (Actual machine setting)
 - Cutting Rate: _____ (Based upon actual machine speed)
 - Cutting Time: _____

14. Application #3

- Ø2-1/4" Round Stock – S-7 Steel:
 - Length of cut: _____
 - Blade: _____
 - Cutting Rate: _____ (Machinery's Handbook)
 - Band Speed: _____ (Machinery's Handbook)
 - Band Speed: _____ (Actual machine setting)

- Cutting Rate: _____ (Based upon actual machine speed)
- Cutting Time: _____