

BANDFILE GUIDE (CONTINUED).

Embedded swarf should be periodically removed to prevent the workpiece being scored. This problem can be reduced by a light application of tallow or chalk. Care must be taken to avoid kinking the backing band in storage and for this reason, the bandfile should be stored in its original container when not in use.

ABRASIVE BAND GUIDE.

Fig.5 shows the abrasive band guide (Part No.SP393) set up on a machine. One inch wide abrasive bands are available in 40,80 or 120 grit and are ideal for a large variety of small finishing and deburring operations.

To set up the abrasive band guide :-
Remove the saw blade, blade guides, and table insert. Assemble abrasive band guide into the same holes as used to locate the blade guides. Mount the abrasive band on the bandwheels, with the joint of band overlap (on the abrasive side) to face upwards from the table. Apply tension as for a $\frac{1}{4}$ " wide saw blade. Align face of guide to back of band. Use highest blade speed available.

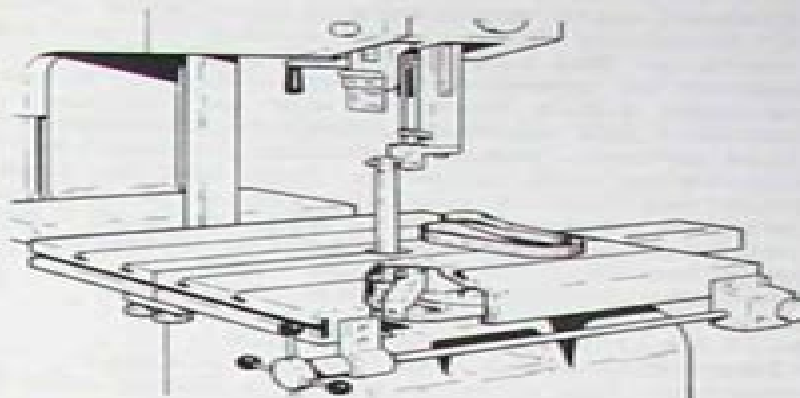


Fig.5.

CONTOUR WORK HOLDING KIT.

Fig.6 shows the contour work holding kit (Part No.PK64A) in use on a machine. The mechanical advantages offered by the hand feed mechanism of the sliding table can be used to some advantage in die making. The die block cannot be clamped to the work table in the usual way if contour sawing is involved as manipulation of the workpiece is necessary. In this instance, the table motion can be transferred by roller chain passing both around the workpiece and a jockey wheel attached to the rack cover at the rear of the table. By this method, the workpiece is steered by one hand and feed is applied by the other. Hold circular workpiece by wrapping the chain directly around the job. To prevent the chain slipping, saw a small slot in the periphery of the workpiece and insert a small piece of saw blade so as to engage with the chain.

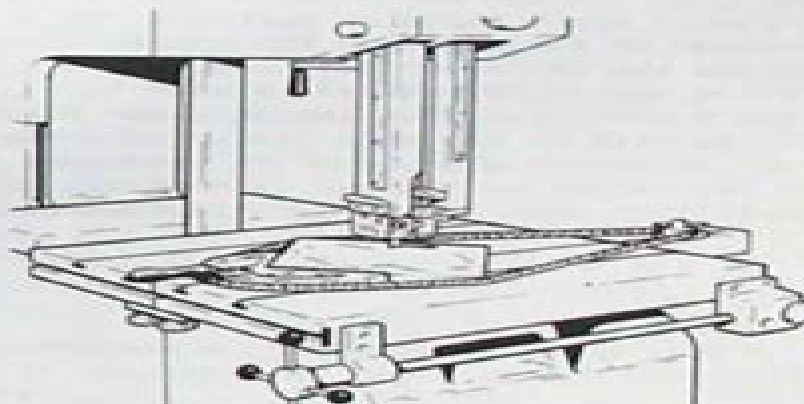


Fig.6.

Bandsaw Startrite Operation And Maintenance Manual

Ying Liu



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Table of Contents Bandsaw Startrite Operation And Maintenance Manual

1. Understanding the eBook Bandsaw Startrite Operation And Maintenance Manual
 - The Rise of Digital Reading Bandsaw Startrite Operation And Maintenance Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Bandsaw Startrite Operation And Maintenance Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Bandsaw Startrite Operation And Maintenance Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Bandsaw Startrite Operation And Maintenance Manual

- Personalized Recommendations
- Bandsaw Startrite Operation And Maintenance Manual User Reviews and Ratings
- Bandsaw Startrite Operation And Maintenance Manual and Bestseller Lists
- 5. Accessing Bandsaw Startrite Operation And Maintenance Manual Free and Paid eBooks
 - Bandsaw Startrite Operation And Maintenance Manual Public Domain eBooks
 - Bandsaw Startrite Operation And Maintenance Manual eBook Subscription Services
 - Bandsaw Startrite Operation And Maintenance Manual Budget-Friendly Options
- 6. Navigating Bandsaw Startrite Operation And Maintenance Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Bandsaw Startrite Operation And Maintenance Manual Compatibility with Devices
 - Bandsaw Startrite Operation And Maintenance Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Bandsaw Startrite Operation And Maintenance Manual
 - Highlighting and Note-Taking Bandsaw Startrite Operation And Maintenance Manual
 - Interactive Elements Bandsaw Startrite Operation And Maintenance Manual
- 8. Staying Engaged with Bandsaw Startrite Operation And Maintenance Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Bandsaw Startrite Operation And Maintenance Manual
- 9. Balancing eBooks and Physical Books Bandsaw Startrite Operation And Maintenance Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Bandsaw Startrite Operation And Maintenance Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Bandsaw Startrite Operation And Maintenance Manual
 - Setting Reading Goals Bandsaw Startrite Operation And Maintenance Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Bandsaw Startrite Operation And Maintenance Manual

- Fact-Checking eBook Content of Bandsaw Startrite Operation And Maintenance Manual
- Distinguishing Credible Sources

13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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