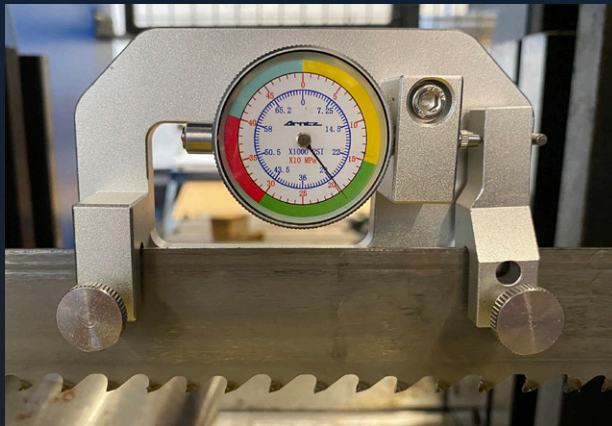


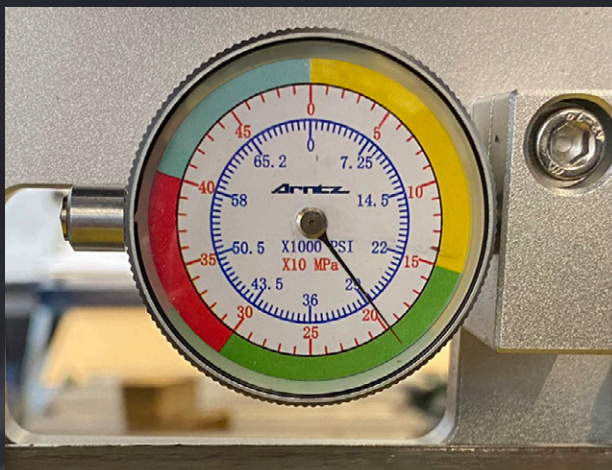
TENSION GAUGE

Operating Instructions



SAFETY NOTE: First check that the machine is switched off.

1. Loosen the tension off the band saw blade.
Keep the tension at a minimum so that the band saw blade remains securely on the wheels.
2. Attach the tension gauge arms onto the back edge of the blade.
Leaving a gap of around 3–4 mm between the edge and the top of the slot.
3. First tighten the knurled screw on the left side and then on the right side.
Ensure the tension gauge is mounted parallel.
4. Set the dial to the zero ("0") position by turning the dial ring.
5. Apply tension to the band saw blade. The dial then shows the corresponding value on the scale.



Optimal Tension Parameter

Blade width	Megapascal	Pounds per square in
20*0,9 mm 3/4 inch	140 –160 MPa	20.000 – 23.000 PSI
27*0,9 mm 1 inch	160 –180 MPa	23.000 – 26.000 PSI
34*1,1 mm 1 1/4 inch	180 –200 MPa	26.000 – 29.000 PSI
41*1,3 mm 1 1/2 inch	200 –240 MPa	29.000 – 35.000 PSI
54*1,3 mm 2 inch	240 –260 MPa	35.000 – 37.000 PSI
54*1,6 mm 2 inch	260 –275 MPa	37.000 – 40.000 PSI
67*1,6 mm 2 5/8 inch	275 –290 MPa	40.000 – 42.000 PSI
80*1,6 mm 3 inch	290 –300 MPa	42.000 – 43.500 PSI