

Nailbuster® Sawblade

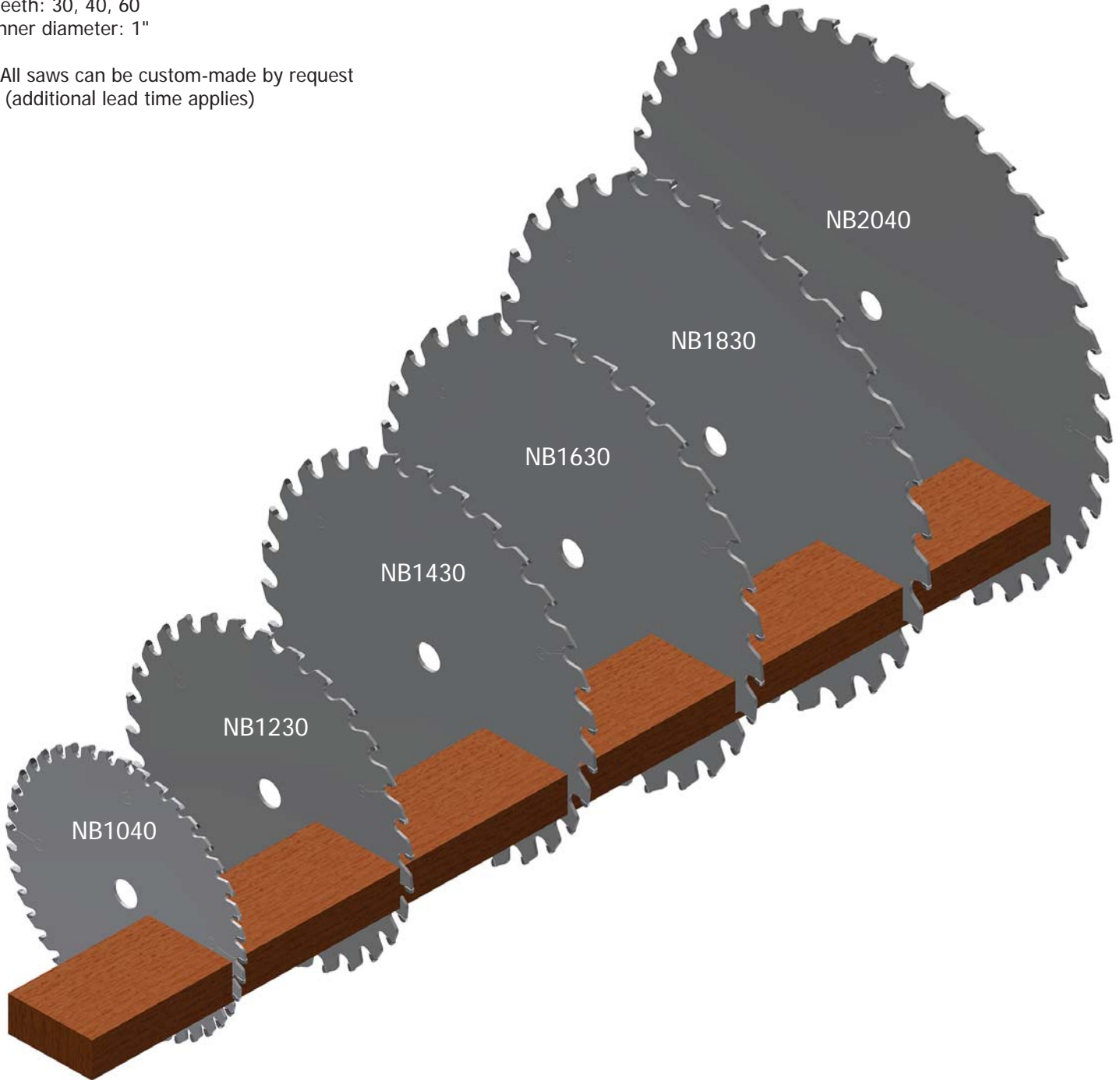
Designed for cross-cutting deck boards and stringers with nails imbedded.

Outer diameter: 10", 12", 14", 16", 18", 20"

Teeth: 30, 40, 60

Inner diameter: 1"

*All saws can be custom-made by request
(additional lead time applies)



PROFILE TECHNOLOGY INC.

Custom Engineered Tooling and Machinery

300 Seebold Spur
Fenton, MO 63026
www.profiletech.com

(800) 369-4242 toll free
(314) 965-9111 main
(314) 966-5550 fax
info@profiletech.com





PROFILE TECHNOLOGY INC

300 Seebold SPur
Fenton, MO63026
Info@profiletech.com

Phone: 314-965-9111
800-369-4242
Fax: 314-966-5550

Custom Engineered Tooling
and Machinery

Nailbuster® Sawblade Informational Guide

Profile Technology has been providing our Nailbuster® cross cut saw blades to the Recycling Industry for over 20 years. In that time, we have built blades for most of the different trim saws and several of the chop saws on the market. This includes manual operation trim saws and automated power feed machines.

Since many of these saws were designed prior to the advent of sawing recycled deck boards or stringers with nails, some late model design machines are better suited than others for this type of sawing. There are some unique differences in cutting wood with nails as compared to just cutting new wood. Simply changing out the wood cutting saw blade with a Nailbuster® saw blade may not prove to be the most efficient way to cut your recycled deck boards and stringers.

Regardless of the trim saw you are running, you obviously want to maximize your running time on the saw blade in order to maximize the number of boards you generate for a given set-up. A few tips to help you maximize your machine and saw blade performance are:

FOR HAND OPERATED SINGLE BLADE MACHINES:

1. Train your operators to ease into the cut rather than plunging in at high speed. This allows the cutting teeth to engage the nails while minimizing the over feed into the wood. Over feeding can prematurely wear, crack saw tips, or crack the saw plate.
2. Train your operator to "grade the cut" if possible. In other words, have the operator cut next to a nail rather than through the nail if it does not affect the finished board length. The fewer nails you cut, the longer the Nailbuster® blade will last.
3. Try to run your Nailbuster® blades on a regular maintenance schedule of running 30 to 40 hours between sharpening. For a variety of reasons, running time will vary but most fall within this range of operations between sharpening without excessive damage.

NOTE: By establishing a routine maintenance schedule, you will keep from "over using" your saw blades and keep maintenance costs low (by sharpening more often than replacing blades). Overusing your saw blade may keep the blade on the machine a little longer but as the tips dull they generate more heat which is transferred into the saw plate. The saw plate (like any metal body) has a limit regarding how much heat it can hold before it begins to deform and warp. While the saw plates have expansion slots built into the body to allow for some distortion due to heat if there is too much heat in the plate, the plate warps to a point of failure resulting in hairline cracks in the steel plate.

4. If you have a routine change out program as mentioned above, you can experiment with increasing the running time a day at a time, and measure the change in costs for increased blade repair. If on the other hand you feel you are damaging your blades too often or the blades are getting dull more quickly, you can reduce your cutting time and measure the improvement in blade life and reduced maintenance costs.

FOR POWER FEED TRIM SAWS (SINGLE OR DOUBLE BLADE)

1. Items 3 and 4 above apply here as well.
2. Watch conveyor feed, dog alignment and wear. Improper tension, wear, or alignment can allow boards being cut to twist or turn into the saw blade causing excessive damage to the saw blade prematurely which requires scraping the saw blade due to cracks in the plate.

If you would like assistance increasing your Nailbuster® saw blade productivity or any other carbide tipped saw blade performance or would be interested in our new UPICK™ pick-up and delivery program, please call or email us. UPICK™ provides pick-up and delivery to and from your facility. Call David or John at 800-369-4242 for more information how Profile Technology may be of service to your company.