

ATKINS *Narrow Band* **SAWS**



ATKINS

John Lewis

ATKINS NARROW BAND SAWS

Silver Steel meets the demand for a tough band saw blade with teeth that stay sharp. They are of uniform high quality; properly heat-treated and manufactured.

Teeth Properly Shaped, Set and Filed

Atkins Narrow Band Saw Blades are filed sharp and the burrs are removed from the teeth.

A uniform set produces smooth cut. The backs are well rounded, thus preventing cracks due to work hardening.

Atkins Blades are easy to file.

Selecting the Correct Saw

Band Saw length is determined by the make of machine. To secure the longest possible service per saw, use the longest size the machine will take when the tension adjustment is extended almost to its limit. This enables you to reweld more times than when using short saws.

The right width is limited largely by the work to be done and also by the size of the machine. The sharper the bend to be cut the narrower the saw that must be used.

The correct thickness is very important. Too heavy a blade results in fatigue cracks caused by the rapid bending and straightening of the saw passing over pulleys. The thickness (gauge) of Atkins Narrow Band Saws is easily determined. Use this chart whenever possible:

Saws 6' to 10' long—25 ga. —12" to 20" pulley
 Saws 10' to 15' long—22 ga. —20" to 30" pulley
 Saws 15' to 21' long—21 and 22 ga.—30" to 40" pulley
 Saws over 21' long—20 and 21 ga.
 (depending on width)—40" and over

Tooth spacing is determined by the work being done and the speed of the saw, lineal feet per minute. It is desirable to use as coarse a tooth as possible on any application. If you are using a 4-tooth saw and find in trying a 3-tooth saw that the cut is smooth enough for your purpose, use the 3-tooth saw. It will cut faster. If you file your own saws, a 3-tooth saw has 25% less teeth to set and file than a 4-tooth saw. For the average band saw machine, a 3- or 4-tooth saw is generally satisfactory and effective.

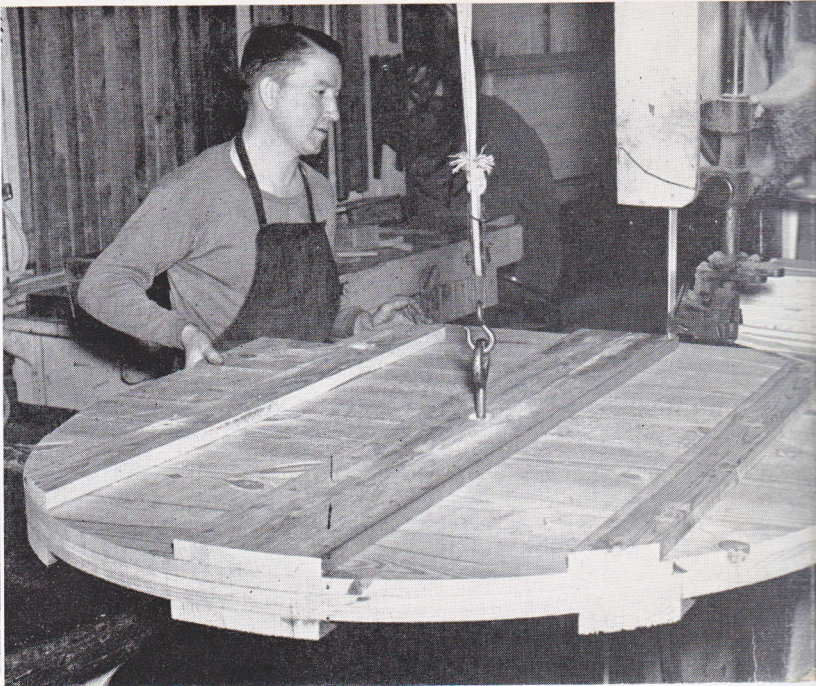
Speed

The speed of a band saw depends upon the machine, diameter of the pulleys, and the width of the saw. Wherever possible follow the speed recommendations of the manufacturer. All things being equal, the faster a saw runs, the faster it will cut. Machine speeds vary from 450 to 900 R.P.M., the higher speeds being more common on the modern machines.

Pulleys	Speed—R.P.M.	Rim Speed feet per minute
14"	600	2200
30"	550 to 900	4300 to 7500
36"	450 to 900	4250 to 8500
42"	450 to 900	5000 to 9000

Ordering Narrow Band Saws

Atkins Narrow Band Saws are packed 250 and 100 foot coils in dispensers—also in cut and electrically welded standard lengths and boxed individually.



Our narrow band saws are made of SILVER STEEL the same as our wide bands and with the same care and precision. In all respects they are of equal quality. If you have not used our narrow band saws we believe that a trial will convince you that they are "The Finest on Earth."

Coil Orders—Unless otherwise specified.

1/8"	3/16"	1/4"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"
23x8	22x7	22x5	22x5	21x5	21x4	21x4	20x4	20x3	20x3

Width	Standard Gauge	Standard Points per Inch	Standard Number of Teeth per Inch	Approx. Weight (lbs.) per 100 Feet
1/8"	22	8	7	1.05
	25	7	6	1.05
3/16"	21	4	3	1.57
	21	5	4	1.57
	22	7	6	1.57
	25	7	6	1.57
1/4"	21	4	3	2.35
	21	5	4	2.35
	21	6	5	2.35
	22	5	4	2.35
	22	6	5	2.35
	22	7	6	2.35
	25	7	6	2.35
	25	7	6	2.35
3/8"	21	4	3	3.52
	21	5	4	3.52
	21	6	5	3.52
	22	5	4	3.52
	22	6	5	3.52
	25	6	5	3.52
1/2"	19	3	2	5.36
	20	4	3	5.36
	21	4	3	5.36
	21	5	4	5.36
	21	6	5	5.36
	22	3	2	5.36
	22	4	3	5.36
	22	5	4	5.36
	22	6	5	5.36
	25	6	5	5.36
5/8"	19	3	2	6.70
	21	3	2	6.70
	21	4	3	6.70
	21	5	4	6.70
	22	5	4	6.70
	25	5	4	6.70
3/4"	19	3	2	8.05
	20	4	3	8.05
	21	3	2	8.05
	21	4	3	8.05
	21	5	4	8.05
	22	4	3	8.05
1"	22	5	4	8.05
	25	5	4	8.05
	20	3	2	11.75
	20	4	3	11.75
	20	5	4	11.75
	21	3	2	11.75
	21	4	3	11.75
	21	5	4	11.75
1 1/4"	22	5	4	11.75
	20	3	2	14.71
	20	4	3	14.71
	20	5	4	14.71
1 1/2"	20	3	2	17.63
1 3/4"	20	3	2	20.57
2"	20	3	2	23.09



Points or Teeth?

The illustration herewith shows clearly the difference between "points per inch" and "teeth per inch." When ordering narrow band saws always specify the number of points per inch. There is always one more point per inch than there are teeth.

Electrically Welded

Years ago Atkins undertook to improve the brazing technique for narrow band saws. The final results of research and actual use has culminated in an electric weld that today is the acme of perfection. When you buy an Atkins Band Saw you can be assured of the finest weld possible to be made in this type of saw. The weld of an Atkins Band Saw will stand the gaff.

Rubber Bands for Band Wheels

Rubber bands are made shorter and wider than the circumference and width of the wheel, by a standard scale, providing for about 20% stretch in circumference and 10% in width and thickness, which should make them fit properly, and adhere to the wheel, with a light application of glue or cement when properly applied.



Diam. of Wheel	Width of Face	Thickness	I.C.
20"	1 1/2"	3/16"	50 3/8"
22"	1 1/2"	3/16"	56"
24"	1 1/2"	3/16"	60"
26"	1 1/2"	3/16"	66"
26"	2"	3/16"	66"
28"	1 1/2"	3/16"	71"
30"	1 1/2"	3/16"	77"
30"	1 3/4"	3/16"	77"
30"	2"	3/16"	77"
32"	1 1/2"	3/16"	80"
32"	1 3/4"	3/16"	80"
32"	2"	3/16"	80"
34"	2"	3/16"	85"
36"	1 1/2"	3/16"	91"
36"	1 3/4"	3/16"	91"
36"	2"	3/16"	91"
38"	2"	3/16"	95"
42"	2"	3/16"	108"
42"	2 1/2"	3/16"	108"

How **ATKINS** Band Saws are Packed



This is the sturdy, familiar, wooden case used to pack Wood, Butcher, and Metal Cutting narrow band saws in standard 250 feet coils. Any length of the coil may quickly be removed. The number of feet remaining in the case is always shown on the front as well as the specification of the contents.



Individual band saws cut to length are packed in this newly designed carton, which is made in four sizes to hold saws of various lengths and widths. Length, width, gauge, and other details are shown on the side. Ten bandsaws of same specifications are packed in a convenient corrugated shipping or storage container.

ATKINS Straight Rectangular Blades

These comprise Doctor Blades, Fountain Blades, Gin Roller Blades, Scraper Blades, Dry Mill Blades and others used in many industries, such as Graphic Arts, Food, etc.

They are made of a superior quality Carbon Steel, expertly and uniformly hardened and tempered throughout. Ground flat over all and nicely polished. The long edges are ground absolutely parallel. Every care is used in the manufacturing of these blades to see that you get the very best.

These sizes listed are those most in demand and are made in the following lengths:

Inches, 40, 42, 44, 46, 48, 50, 52, 54, 56, 58, 60, 62, 64, 66, 68, 70

Widths and thicknesses as follows:

2½" wide x .022	.028	.035	.049	.065
.083				
3" wide x .022	.028	.035	.049	.065
.083	.125			
3½" wide x .022	.028	.035	.049	.065
.093	.125			
4" wide x .022	.028	.035	.049	.065
.093	.125	.187		
5" wide x .035	.049	.065	.093	.125
.187	.250			
6" wide x .065	.093	.125	.187	.250
7" wide x .0625	.0937	.125	.1875	.25
7½" wide x .0625	.0937	.125	.1875	.25
8" wide x .0625	.0937	.125	.1875	.25
8½" wide x .0625	.0937	.125	.1875	.25
9" wide x .0625	.0937	.125	.1875	.25
9½" wide x .0625	.0937	.125	.1875	.25
10" wide x .0625	.0937	.125	.1875	.25

We are in position to produce any of these blades with holes or open or loop slots; also blued blades.

The above sizes are the most popular but any size such as longer or shorter length, width or thickness, can be had promptly. If the size you are interested in is not listed, let us have your specifications and the opportunity to quote you without obligation on your part.

E. C. ATKINS AND COMPANY
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