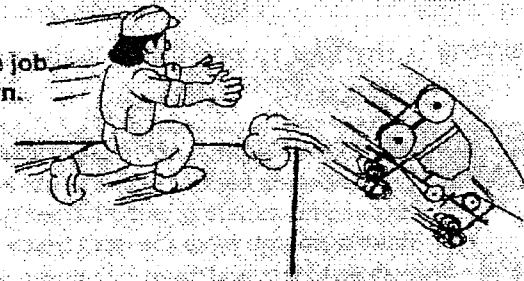


# WIRE SAWING

**Safety** - is the key to profitable wire sawing.

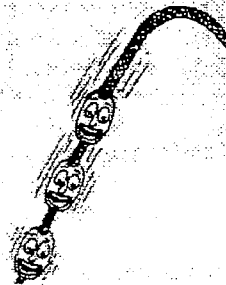
- \* Rope off the area in front of and behind and even below the job.
- \* Secure the saw. It must be anchored and not weighted down.
- \* Always keep the wire guard in place and in good condition.
- \* Inspect the wire frequently for damage, frayed sections, missing beads, flat spots or weak connection points.
- \* Always keep all parts of your body away from the wire.
- \* Avoid getting in a direct line with the wire.



**Wire Twist** - The number of twists in the wire is critical for maximum bead life. Start with one twist for every three feet of wire. Increase the number of twists per the chart below. These additional twists will assure that the beads wear round and give maximum life. While twisting this is a good time to look for flaws in the cable such as broken strands.

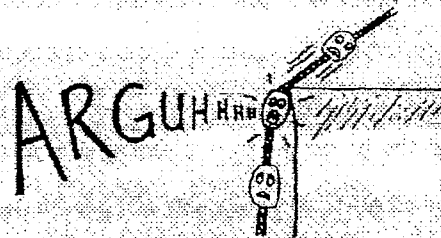
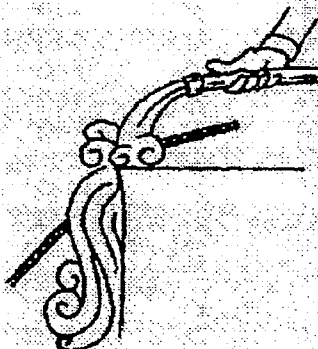
RECOMMENDED WIRE TWIST					
Wire Length	Wire Diameter	Wire Diameter	Wire Diameter	Wire Diameter	Wire Diameter
	.440"	.425"	.410"	.395"	.380"
25'	8	9	10	11	12
50'	17	19	21	23	25
75'	25	28	31	34	37
100'	33	36	40	44	48

**Wire Speed** - is critical to good wire life. This table notes the correct wire speed for various flywheel diameters.



WIRE SPEED VS FLYWHEEL DIAMETER	
Flywheel Diameter	RPM
24"	600-750
30"	475-600
36"	400-500

**Beginning and Ending** - Starting and finishing a cut produces the most strain on the wire. Give the wire a radius to start on. Don't start on a sharp edge.



**Water** - should be introduced at the beginning of the cut and contained throughout the cut. Vertical cuts should be directed as to allow the water to flow with gravity.

## **Wire Sawing Safety**

- Read all manuals before use
- Never alter saw in any way unless approved by manufacturer
- Make sure there are safety stops at each end of track
- Always inspect equipment especially rollers and bearings
- Always set controls to the side of operation no less than half the length of wire
- Always put cages up in the path that the wire is traveling

## **Wire Sawing Procedures**

- Before starting make sure everything is secure
- All equipment should be cleaned daily
- Inspect all wire saw equipment after every use
- When moving hand equipment with extreme caution
- If there are any bent or warped parts do not use until they are replaced
- Always make sure pulley system is safe and secure