

YOUR TIMERS !!!

Luc BATARD's leitmotif for over 30 years, is " A GOOD SAW IS A FAST SAW". Sawing quickly means that the blades are working in good shapes & conditions and therefore they return without distortion, in the same state in which they went out (ie in good condition).

Sawing fast means to produce quickly, to reduce sawing time. Sawing in less time allows for substantial energy savings, freeing up work hours for maintenance or other activities.

Sawing well increases the material yield, to satisfy and retain customers.

Obviously, sawing fast IS sawing GOOD, otherwise we are heading for troubles Bad ratings, saw deviations, breakages blades, creeks

What does "saw fast" MEAN? When can we say that we saw quickly?

Here is a table in which Luc BATARD determines sawing speed that must work bandsaw units in 300 mm log depth (± 50). This is not "feelings". These speeds are based on mathematical and geometric elements. The calculation is simple:

$$\text{sawing speed in m/min} = \frac{\text{Length (m)} \times 60}{\text{Time (sec)}}$$

Columns are empty? Feel free to fill with your own data ...

Wheels diameter	Saw thickness	Hardwood in m/mn	Sawing speed Sawmill	Softwood (whitewood)	Sawing speed Sawmill	Frozen wood in m/mn	Sawing speed Sawmill
1200	12,5/10 mm	40-50		50-60		30-40	
1300	13,7/10 mm	50-60		60-70		40-50	
1400	14,7/10 mm	60-70		80-90		50-60	
1600	16,5/10 mm	180-90		100		70-80	
1800	18,3/10 mm	100		120		90	

Another way of assessing the sawing speed can also be achieved by the saw duration according to the following table:

Log Length	Sawing speed in mm	Sawing time in secondes	Log Length	Sawing speed in mm	Sawing time in secondes	Log Length	Sawing speed in mm	Sawing time in secondes	Log Length	Sawing speed in mm	Sawing time in secondes
2 mètres	50	2,4	2,5 mètres	50	3,00	3 mètres	50	3,60	4 mètres	50	4,80
2 mètres	60	2	2,5 mètres	60	2,50	3 mètres	60	3,00	4 mètres	60	4,00
2 mètres	70	1,7	2,5 mètres	70	2,14	3 mètres	70	2,57	4 mètres	70	3,43
2 mètres	80	1,5	2,5 mètres	80	1,88	3 mètres	80	2,25	4 mètres	80	3,00
2 mètres	90	1,33	2,5 mètres	90	1,67	3 mètres	90	2,00	4 mètres	90	2,67
2 mètres	100	1,2	2,5 mètres	100	1,50	3 mètres	100	1,80	4 mètres	100	2,40
2 mètres	120	1	2,5 mètres	120	1,25	3 mètres	120	1,50	4 mètres	120	2,00

Caution ! There is no questions to put full stroke in one go. To be successful, Some conditions require to be met : cutting conditions, slide bandsaw preparation and architectural settings ...

Your numbers are below expectations ? So you have cap space for significant progression without investment in these difficult times. Go ahead and if you wish, send us your completed table !!!