AUSTRALIA
PATENTS ACT 1990

PATENT REQUEST : STANDARD PATENT

I/We being the person(s) identified below as the Applicant(s), request the grant of a patent to the person(s) identified below as the Nominated Person(s), for an invention described in the accompanying standard complete specification.

Full application details follow:

[71/70] Applicant(s)/Nominated Person(s):

The L. S. Starrett Company

of

121 Crescent Street, Athol, Massachusetts, United States of America

[54] Invention Title:

Variable height, high performance, bandsaw blade and method of manufacture therefor

[72] Name(s) of actual inventor(s):

Ralph STODDARD

[74] Address for service in Australia:

DAVIES COLLISON CAVE, Patent Attorneys, 1 Little Collins Street, Melbourne, Victoria, Australia. Attorney Code: DM

Basic Convention Application(s) Details:


881,182 United States of America US 11 May 1992

DATED this FIFTEENTH day of APRIL 1993

[Signature]

a member of the firm of DAVIES COLLISON CAVE for and on behalf of the applicant(s)
AUSTRALIA
PATENTS ACT 1990
NOTICE OF ENTITLEMENT

We, The L. S. Starrett Company, the applicant/Nominated Person named in the accompanying Patent Request state the following:-

The Nominated Person is entitled to the grant of the patent because the Nominated Person derives title to the invention from the inventor by assignment.

The Nominated Person is entitled to claim priority from the basic application listed on the patent request because the Nominated Person is the assignee of the applicant in respect of the basic application, and because that application was the first application made in a Convention country in respect of the invention.

DATED this FIFTEENTH day of APRIL 1993

[Signature]

a member of the firm of
DAVIES COLLISON
CAVE for and on behalf of the applicant(s)

(DCC ref: 1584460)
1. A bandsaw blade having
   a repeating tooth pattern,
   each set tooth of each tooth pattern of said
   repeating tooth patterns having a set which has a
   monotonically non-decreasing functional relationship to
   the height of said tooth, and
   a first tooth of each repeating tooth pattern
   having a tooth height which varies from a beginning of
   said pattern to an end of said pattern, said tooth height
   at the end of the repeating pattern being between about
   fifteen and twenty thousandths of an inch greater than
   the tooth height at the beginning of the repeating
   pattern.

   comprising the steps of
   cutting repeating patterns of teeth, the height of
each tooth increasing monotonically through said repeating pattern, the height difference through a pattern being between fifteen and twenty thousandths of an inch, and

setting selected ones of said teeth, said set being a monotonically increasing function of the tooth height.
NAME OF APPLICANT(S):

The L. S. Starrett Company

ADDRESS FOR SERVICE:

DAVIES COLLISON CAVE
Patent Attorneys
1 Little Collins Street, Melbourne, 3000.

INVENTION TITLE:

Variable height, high performance, bandsaw blade and method of manufacture therefor

The following statement is a full description of this invention, including the best method of performing it known to me/us:-
Background of the Invention

The invention relates generally to high performance bandsaw blades and in particular, to those bandsaw blades which have variable height, pitch, and set.

A typical measure of bandsaw blade performance is the throughput in comparison to the price paid for the blade and/or the equipment needed for running it. Over the past two decades, many different approaches to high performance bandsaw blades, for example blades used in cutting stainless steel and the like, have been developed. One particular method employs a cammed back edge which provides a "surging" of the blade during cutting. The back edge in effect causes the blade to move relative to and into the metal being cut. Another approach provides for "surging" of the blade as the back edge of the blade varies to provide an undulating surface which causes the blade to oscillate about an imaginary pivot point centered between the rollers pressing on and guiding the back edge.

While these methods represent advances over blades used decades ago, they typically require either major readjustment of the bandsaw blade equipment, the use of entirely new equipment since the older equipment is not adaptable to the new blades, major and substantial additional costs in manufacturing the blades (the cost being absorbed as the performance of the blade increases), or blades which are highly specialized and are accordingly expensive to operate and use.

It is therefore an object of this invention to provide a high performance bandsaw blade operable with present equipment and manufactured using standard and
available equipment, yet providing a performance price benefit which is comparable to or surpasses the surging blades previously described. Other objects of the invention are a high performance bandsaw blade which can be manufactured using existing equipment, and which has relatively low or no additional costs associated with the manufacturing process wherein the blade is used. Yet further objects of the invention are a reliable, simple to operate, simple to use, high performance, high speed bandsaw blade.

Summary of the Invention

The invention relates to a bandsaw blade which features a straight back edge and a repeating tooth pattern. Each set tooth of each repeating tooth pattern has a set which is monotonically related to the height of the tooth. Each tooth of each repeating tooth pattern has a tooth height in which a tooth at the beginning of the pattern has a height which is less than to the height of a tooth at the end of the pattern by between, preferably fifteen and twenty thousandths of an inch, and in one illustrated embodiment, about twenty thousandths of an inch.

In various embodiments of the invention, the repeating tooth pattern can be between four and twelve inches in length, and preferably is about six inches in length. This matches the typical length of a present day cutter used for manufacturing bandsaw blades. The bandsaw blade further has a tooth height which preferably increases linearly over the repeating pattern. In another aspect of the invention, the bandsaw blade teeth have a repeating, specified, set pattern which includes a raker tooth followed by a predetermined number of set teeth. The direction of set of the set teeth alternates in sequence along the blade. The teeth also can have,
according to a preferred embodiment of the invention, a variable pitch. Typically, the tooth gullet depth is approximately between 35-48% of tooth pitch.

The method of the invention for manufacturing a bandsaw blade features the steps of cutting repeating patterns of teeth, the height of the tooth at the beginning of the pattern being less than the height of the tooth at the end of the pattern, and setting selected ones of the teeth, the set being a monotonically increasing function of the tooth height. The difference in height from beginning to end of each repeating pattern is between about fifteen and twenty thousandths of an inch, and preferably, is about twenty thousandths of an inch.

Brief Description of the Drawings

Other objects, features and advantages of the invention will be apparent from the following description taken together with the drawings in which:

Figures 1A, 1B, and 1C are elevation views of a section of a bandsaw blade manufactured in accordance with a preferred embodiment of the invention; and

Figures 2A, 2B and 2C are top views of the bandsaw blades of Figures 1A, 1B and 1C, respective, in accordance with a preferred embodiment of the invention.

Description of Preferred Embodiments

Referring to Figures 1A, 1B and 1C, a typical bandsaw blade 10, in accordance with the illustrated embodiment of the invention, has a plurality of teeth 12 in a body 13 having a straight back edge 14. The teeth 12 comprises a tip section 16 and a gullet section 18. In accordance with a preferred embodiment of the invention, the points of the teeth tips lie along an inclined imaginary plane 20 which extends from the
beginning 22 to the end 24 of a repeating pattern of teeth. According to the invention, the height difference of the teeth over the length of each repeating pattern is between about fifteen and twenty thousandths of an inch, and is preferably about twenty thousandths of an inch. The teeth in each repeating pattern accordingly increase monotonically in height, in accordance with this illustrated embodiment of the invention, from the beginning of the pattern to the end of the pattern. In other embodiments of the invention, the change in height between the ends of the pattern may not be monotonically increasing. In this illustrated embodiment, a variable pitch blade is described so that the distance between teeth tips varies. The gullet depth between teeth is a function of the pitch and is preferably between 35 and 48% of pitch.

Referring to Figures 2A, 2B, and 2C, the set of the teeth is determined by a repeating set pattern which is typically, due to manufacturing constraints, synchronous with the repeating tooth pattern; and can, for example, include multiple occurrences of a raker tooth 30 followed by alternately right and left set teeth 32. In accordance with the illustrated embodiment of the invention, the set of a tooth increases with increasing height. Accordingly, the set of a tooth such as tooth 40 is greater than the set of a tooth such as tooth 42.

In accordance with the illustrated embodiment of the invention, various set patterns and pitch variations can be employed. The overall length of a typical tooth pattern is 6 inches. Thus, in the preferred and illustrated embodiment of the invention, there is provided a 20 thousandths of an inch change in tooth height over a length of about 6 inches.

The manufacture of the bandsaw blades illustrated in Figures 1A, 1B, 1C, 2A, 2B and 2C is performed using a
standard bandsaw manufacturing process. The cutters are adjusted and positioned to enable the selected repeating tooth pattern, as described above, to be created. The teeth are then set in a standard fashion, and the set of a tooth will automatically be a monotonically increasing function of the tooth height. Accordingly, the manufacturing process closely resembles the standard process for making a bandsaw blade.

Additions, deletions, and other modifications of the preferred and illustrated embodiments of the invention will be apparent to those practiced in the art and are within the scope of the following claims:
THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS:

1. A bandsaw blade having
   a repeating tooth pattern,
   each set tooth of each tooth pattern of said
5 repeating tooth patterns having a set which has a
monotonically non-decreasing functional relationship to
the height of said tooth, and
   a first tooth of each repeating tooth pattern
having a tooth height which varies from a beginning of
said pattern to an end of said pattern, said tooth height
at the end of the repeating pattern being between about
fifteen and twenty thousandths of an inch greater than
the tooth height at the beginning of the repeating
pattern.

2. The bandsaw blade of claim 1 wherein
   said repeating tooth pattern is between four and
ten twelve inches in length.

3. The bandsaw blade of claim 2 wherein
   said repeating tooth pattern is about six inches
20 in length.

4. The bandsaw blade of claim 1 wherein said
tooth height increases linearly over said repeating
pattern.

5. The bandsaw blade of claim 1 wherein said
25 teeth have a repeating specified set pattern comprising a
raker tooth followed by a predetermined number of set
teeth, the set alternating in sequence along said teeth
of the set pattern.

6. The bandsaw blade of claim 1 wherein said
30 teeth have a variable pitch.
7. The bandsaw blade of claim 6 wherein said teeth have a gullet depth of between about 35% and 48% of tooth pitch.

8. A bandsaw blade having a repeating tooth pattern, each set tooth of each tooth pattern of said repeating tooth patterns having a set which increases with the height of the tooth, each repeating tooth pattern having a length of about 6 inches, and the teeth of each repeating tooth pattern having a tooth height which increases linearly over the repeating pattern, the tooth height at the end of the repeating pattern being between about fifteen and twenty thousandths of an inch greater than the tooth height at the beginning of the repeating pattern, the tooth height having a repeating specified set pattern including a raker tooth followed by a predetermined number of set teeth, the set alternating in sequence along the teeth of the set pattern, and set teeth having a variable pitch.

9. A method of manufacturing a bandsaw blade comprising the steps of cutting repeating patterns of teeth, the height of each tooth increasing monotonically through said repeating pattern, the height difference through a pattern being between fifteen and twenty thousandths of an inch, and setting selected ones of said teeth, said set being a monotonically increasing function of the tooth height.
10. A bandsaw blade substantially as hereinbefore described with reference to the drawings.

11. The steps, features, compositions and compounds disclosed herein or referred to or indicated in the specification and/or claims of this application, individually or collectively, and any and all combinations of any two or more of said steps or features.

DATED this FIFTEENTH day of APRIL 1993

The L. S. Starrett Company

by DAVIES COLLISON CAVE
Patent Attorneys for the applicant(s)
ABSTRACT OF THE DISCLOSURE

A high performance, moderate cost bandsaw blade has a unique tooth configuration which enables it to provide high performance, while using standard manufacturing processes and available bandsaw equipment. The bandsaw blade has a straight back edge and a repeating tooth pattern wherein each set tooth, of each repeating tooth pattern has a set which is a monotonically increasing function of the height of the tooth. The height of each tooth in the repeating tooth pattern increases from the first tooth of the pattern to the last tooth of the pattern. The height difference between the beginning and end of a tooth pattern is preferably on the order of fifteen to twenty thousandths of an inch, and the length of a repeating pattern is typically about six inches to match a standard cutter.
FIG. 2A

FIG. 2B

FIG. 2C