

AN AMBRELL COMPANY

Annealing stainless steel bread cutting saw blades

- **Objective** Anneal saw blades used for cutting bread, prior to hole punching.
- **Material** .38" (9.6mm) wide and .51" (12.9mm) wide continuous strips of 400 series stainless steel.

Temperature 600°C (315.6°F) for one second

Frequency 289kHz

- Ambrell 4.2 kW induction heating system equipped with a remote workhead containing one 1.00 µF capacitor.
 - An induction heating coil designed and developed specifically for this application.
 - **Process** A three turn helical coil at a 45[°] angle is used to anneal a 1.2" (30.5mm) strip of saw blade prior to hole punching.

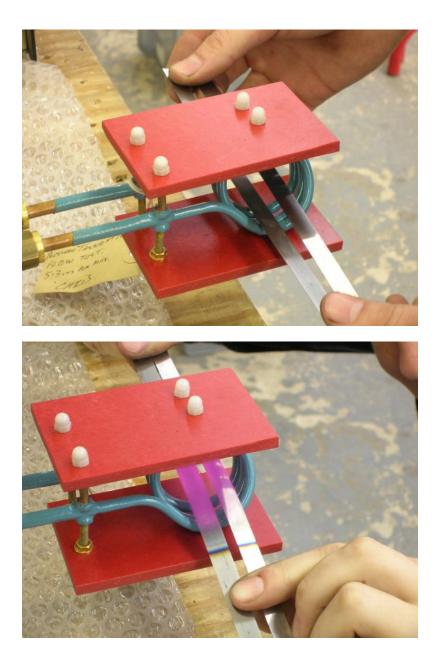
Results/Benefits Induction heating provides:

- Improved quality of blades at hole punching location
- Decreased scrap product
- Easily incorporated into existing production lines



Precision Induction Heating

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