

## Hand Hack Frame

Anyone who has done any appreciable amount of cutting with hand hack saw blades knows the value of a good frame. High quality, high tension frames allow the blade to be tensioned very tightly. This tension is where the hack saw blade gets its beam strength and stability.

Poor quality frames produce only enough blade tension to keep the blade from falling off the mounting pegs and keep the blade upright. When you cut with one of these frames, the blade wobbles all over the place. The more cutting pressure that is applied, the more the blade deflects.

The Morse HHBF02 Master McCoy® Hand Hack Saw Frame is one of the strongest frames in the world. Hack saw blades can be tensioned to 30,000 psi on this frame. This high tension on the blade creates a rock-solid cutting edge that deflects very little, even under the heaviest feed pressure.

### To Mount The Blade On The HHBF02 Frame

1. Place the blade on the mounting pegs with the teeth pointing away from the handle.
2. Turn the tensioning lever until the blade is just snug on the pegs.
3. From the snug point, turn the tensioning lever seven more revolutions to bring the blade into the proper high tension range.

### Tips On Cutting With A Hack Saw

- Although it is not always possible, try to firmly fixture the piece to be cut to prevent movement.
- Start the cut by using short, light strokes to create a slot or kerf.
- As the blade becomes fully engaged in the cut, gradually increase the stroke length and pressure.
- Try to use the entire length of the blade during the stroke.
- Apply pressure only on the forward stroke - the blade cuts only in one direction.
- Minimize the pressure on the back stroke to minimize tooth damage.
- Use small teeth like 24 tpi, 32 tpi, 20/24 vari-pitch, and 26/32 vari-pitch for thin material like thin walled conduit and sheet metal.
- Use larger teeth like 14 tpi, 18 tpi, and 14/18 vari-pitch for thicker material and pipe.

### HHBF02 Features

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| 1 Ergonomic handle grip  | 3 Multiple mounting pin positions for flush and angle cutting |
| 2 Tensioning handle for extra torque, maximum tension and superior cutting performance | 4 Locking screw design for storing spare blades and "jab"     |
|  | 5 Alloy steel support beam for strength and rigidity          |

