

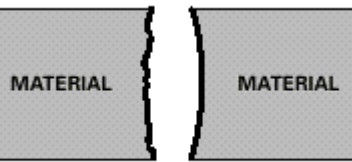
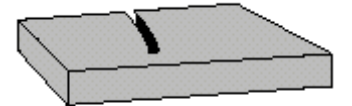




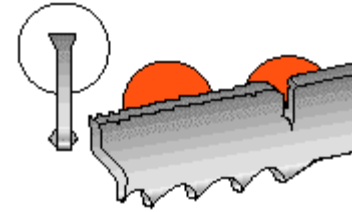
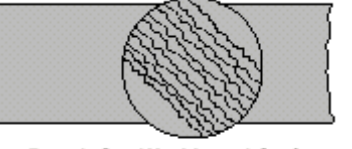
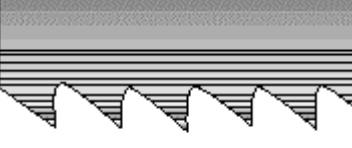


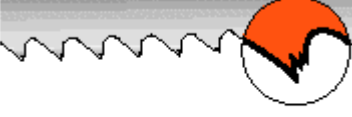


Band Saw Trouble Chart

Problem	Probable Cause	Solution
 <p style="text-align: center;">Blade Breakage Straight Break Indicates Fatigue</p>	<ul style="list-style-type: none"> • Incorrect blade • Band tension too high • Excessive feed • Incorrect cutting fluid • Wheel diameter too small for blade being used • Worn or chipped pressure block (back-up guide) • Blade rubbing on wheel flanges • Teeth in contact with work before starting saw • Side guides too tight 	<ul style="list-style-type: none"> • Teeth too coarse. Check your cutting chart * • Reduce band tension. See Machine Operator's Manual • Reduce feed pressure • Check your coolant * • Use thinner blade and lower speed • Check pressure block. Replace if worn • Adjust wheel alignment • Allow 1/2" clearance before starting cut • See Machine Operator's Manual
 <p style="text-align: center;">Premature Dulling of Teeth</p>	<ul style="list-style-type: none"> • Blade teeth inverted (backwards) • Improper break-in period • Hard spots in material (like scale) • Material work hardened (check for hardness and adjust feed) • Improper cutting fluid or mixture • Speed and feed too high 	<ul style="list-style-type: none"> • Install blade correctly • Reduce feeds and speeds during break-in period in accordance with manufacturers' recommendations • Check material for actual hardness - hard spots like scale or flame cut surfaces • Increase feed pressure • Check your coolant * • Check your cutting chart *
 <p style="text-align: center;">Inaccurate Cut</p>	<ul style="list-style-type: none"> • Teeth dull • Over or under feed • Improper pitch blade • Cutting fluid not applied evenly • Incorrect blade (too many teeth per inch) • Guides worn or loose 	<ul style="list-style-type: none"> • Use new blade • Check your cutting chart * • Check your cutting chart * • Adjust coolant nozzles • Check your cutting chart * • Tighten or replace guides
 <p style="text-align: center;">Band Leading in Cut</p>	<ul style="list-style-type: none"> • Over feed • Lack of band tension • Tooth set damage • Loose guide arms or set too far from work 	<ul style="list-style-type: none"> • Check your cutting chart * • Check Operator's Manual for correct tension • Check material hardness • Adjust arm as close to work as possible - tighten and align. Check guide
 <p style="text-align: center;">Chip Welding</p>	<ul style="list-style-type: none"> • Improper or lack of cutting fluid • Wrong coolant • Excessive speed or pressure • Incorrect blade (wrong pitch) 	<ul style="list-style-type: none"> • Check your coolant * • Check your coolant * • Reduce speed or pressure. Check your cutting chart * • Check your coolant *
 <p style="text-align: center;">Teeth Fracture Back of Tooth (indicates work spinning in vise)</p>	<ul style="list-style-type: none"> • Incorrect feed and/or speed • Incorrect blade (wrong pitch) • Saw guides not adjusted properly 	<ul style="list-style-type: none"> • Check your cutting chart * • Check your cutting chart * • Adjust or replace saw guides
 <p style="text-align: center;">Irregular Break (indicates material movement)</p>	<ul style="list-style-type: none"> • Indexing out of sequence • Material loose in vise 	<ul style="list-style-type: none"> • Check for correct indexing sequence (head rise) • Check hydraulic pressure

Band Saw Trouble Chart

 <p style="text-align: center;">Teeth Stripping</p>	<ul style="list-style-type: none"> • Feed pressure too high • Tooth lodged in cut • No cutting fluid or incorrect coolant • Hard spots, scale, inclusions, etc. • Incorrect blade (wrong pitch) • Work spinning in vise; loose "nest" or bundles • Blade teeth running backwards 	<ul style="list-style-type: none"> • Reduce feed pressure and/or speed. See your cutting chart * • Never enter same (old blade), cut with new blade • Check your coolant * • Check hardness. Descale and/or anneal if necessary • Check your cutting chart * • Check hydraulic pressure; be sure work is firmly held • Reverse blade teeth, turn inside out
 <p style="text-align: center;">Wear on Back of Blades</p>	<ul style="list-style-type: none"> • Insufficient blade tension • Incorrect blade (back too soft) • Incorrect feed (excessive) • Back-up guide frozen in position, damaged, or worn off • Guide arms too far apart, cocked, worn or loose • Blade rubbing on wheel flanges 	<ul style="list-style-type: none"> • See Machine Operator's Manual for correct band tension • If using hard back blade, switch to a variable tooth • Reduce feed pressure. See your cutting chart * • Free pressure block and realign; if worn, replace (never regrind) • Move arms close to work as possible • Adjust wheel alignment
 <p style="text-align: center;">Rough Cut Washboard Surface Vibration and or Chatter</p>	<ul style="list-style-type: none"> • Dull or damaged blade • Incorrect feed and/or speed • Lack of band support • Insufficient band tension • Incorrect pitch blade 	<ul style="list-style-type: none"> • Replace with proper blade • Check your cutting chart *. Adjust until noise disappears • Set guide arm properly - close to work as possible • Check Operator's Manual for correct tensions • Check your cutting chart *
 <p style="text-align: center;">Wear Lines, Loss of Set</p>	<ul style="list-style-type: none"> • Saw guide inserts or roller are riding on teeth • Insufficient blade tension • Incorrect blade (width of blade incorrect) • Hard spots • Back-up guide worn 	<ul style="list-style-type: none"> • Check table and Operator's manual for correct blade width • Check for correct blade tension • Check your cutting chart * • Check material hardness • Replace back-up guide
 <p style="text-align: center;">Twisted Blade Contour Sawing</p>	<ul style="list-style-type: none"> • Band binding in cut • Side guides adjusted too tight • Work not held firmly • Incorrect (or lack of) cutting fluid 	<ul style="list-style-type: none"> • Check table and Operator's manual for correct blade width • Check for correct blade tension • Check your cutting chart * • Check your coolant *
 <p style="text-align: center;">Blade Wear / Teeth Blued</p>	<ul style="list-style-type: none"> • Incorrect blade • Incorrect feed or speed • Improper (or lack of) cutting fluid 	<ul style="list-style-type: none"> • Check your cutting chart * • Check your cutting chart * • Check your coolant *
 <p style="text-align: center;">Teeth Fracture / Front of Tooth (indicates work spinning in vise)</p>	<ul style="list-style-type: none"> • Material loose in vise • Incorrect blade (wrong pitch) 	<ul style="list-style-type: none"> • Check hydraulic pressure • Check