TROUBLE SHOOTING/POTENTIAL PROBLEMS

crooked cut

1. Material is at maximum capacity of machine
2. Feed pressure too high
3. Guides loose
4. Blade tension too low
5. Guides too far apart
6. Machine out of alignment
7. Teeth too fine for application
8. Uneven hardness in material

stripping teeth

1. Speed too slow
2. Incorrect TPI selection
3. Excessive feed pressure
4. Wire brush not working
5. Improper blade break in
6. Movement of material in vise during cutting
7. Hard skin on surface of material or uneven hardness within material
8. Insufficient coolant

blade stalling

1. Guides too tight
2. Blade tension too low
3. Feed pressure too high
4. Speed too slow
5. Drive wheel surface contaminated with chips
6. Insufficient machine power

premature teeth wear

1. Wrong selection of welded high speed edge
2. Speed too high
3. Improper blade break in
4. Feed pressure too heavy or too light
5. Extremely hard or abrasive material
6. Hard scale on surface of material or uneven hardness within material
7. Improper or insufficient coolant

premature blade breakage

1. Guides damaged or worn
2. Blade tension too high
3. Band wheels misaligned or shoulders worn
4. Guides too far apart or improperly adjusted
5. Feed pressure too high
6. Too short a span between wheels and guide arms

blade vibration or squeal

1. Blade speed
2. Guide tension
3. Spacing of guide arms
4. Blade tension
5. Feed pressure too low
6. Position of material in vise
7. Flow or mixture of coolant