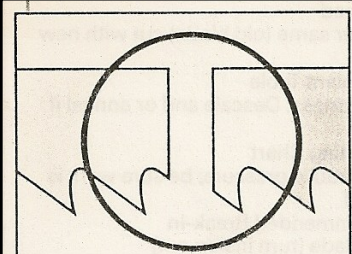
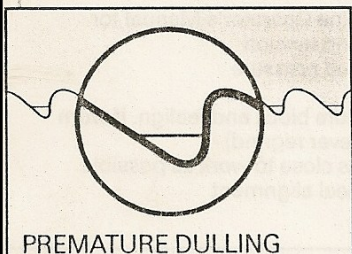
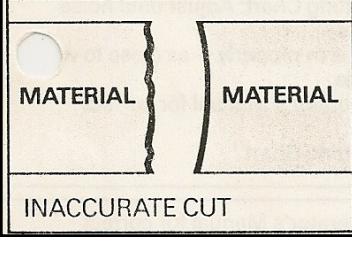
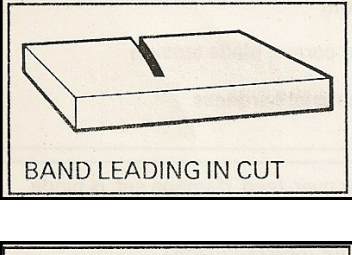
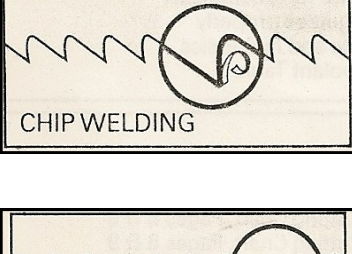
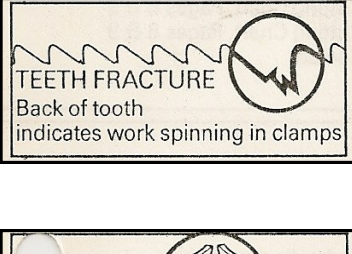
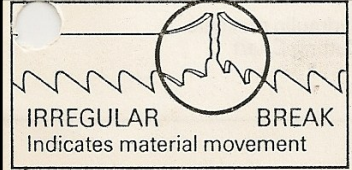


TROUBLESHOOTING/PROBLEM SOLVING

PROBLEM	PROBABLE CAUSE	SOLUTION
 <p>BLADE BREAKAGE Straight Break indicates fatigue</p>	<ul style="list-style-type: none"> • Incorrect blade - Teeth too coarse • Band tension too high • Excessive feed • Incorrect cutting fluid • Wheel diameter too small for blade being used • Blade rubbing on wheel flanges • Teeth in contact with work before starting saw • Guides too tight 	<ul style="list-style-type: none"> • Use Finer Tooth Pitch • Reduce band tension. • See Machine Operator's Manual • Reduce feed pressure • Check Coolant • Use thinner blade and lower speed • Adjust wheel alignment • Allow 1/2" clearance before starting cut
 <p>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 manufacturer's recommendations (See breaking-in procedures for Bi-metal blades) • Check material for actual hardness - hard spots like scale or flame cut surfaces • Increase feed pressure • Check Coolant • Check Cutting Chart
 <p>MATERIAL MATERIAL</p> <p>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 Cutting Chart • Adjust coolant nozzles • Tighten or replace guides
 <p>BAND LEADING IN CUT</p>	<ul style="list-style-type: none"> • Overfeed • Lack of band tension • Tooth set damage • Loose guide arms or set too far from work 	<ul style="list-style-type: none"> • Check cutting chart • Check operators manual for correct tension • Check material hardness • Adjust arm close to work as possible tighten and align. Check machine guide
 <p>CHIP WELDING</p>	<ul style="list-style-type: none"> • Improper or lack of cutting fluid • Wrong coolant concentration • Excessive speed or pressure • Incorrect blade (wrong pitch) • Chip Brushes Defective 	<ul style="list-style-type: none"> • Check Coolant • Reduce speed or pressure, • Check Cutting Chart • Check Chip Brushes
 <p>TEETH FRACTURE Back of tooth indicates work spinning in clamps</p>	<ul style="list-style-type: none"> • Incorrect feed and/or speed • Incorrect blade (wrong pitch) • Saw guides not adjusted properly • Chip Brushes Defective 	<ul style="list-style-type: none"> • Check cutting chart • Adjust or replace saw guides • Check chip brushes
 <p>IRREGULAR BREAK Indicates material movement</p>	<ul style="list-style-type: none"> • Indexing out of sequence • Material loose in vice 	<ul style="list-style-type: none"> • Check for correct indexing sequence (head rise) • Check hydraulic pressure