

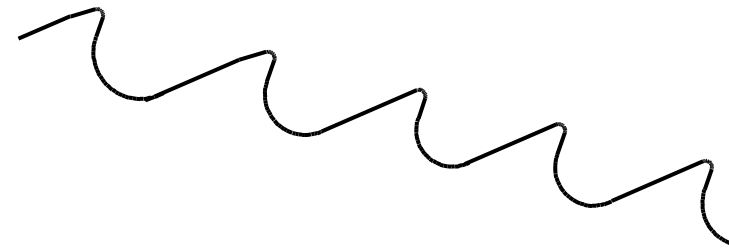


# Band Saw Training

*Troubleshooting*

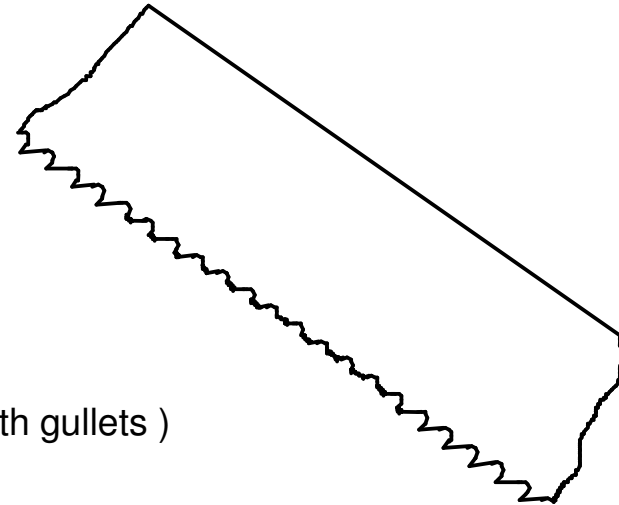
## Premature wear-out

- too much blade speed
- feed pressure too low or too heavy
- improper blade break-in
- less cooling or improper coolant ratio ( 5-10% )
- on small tooth pitches maybe blade ran backwards

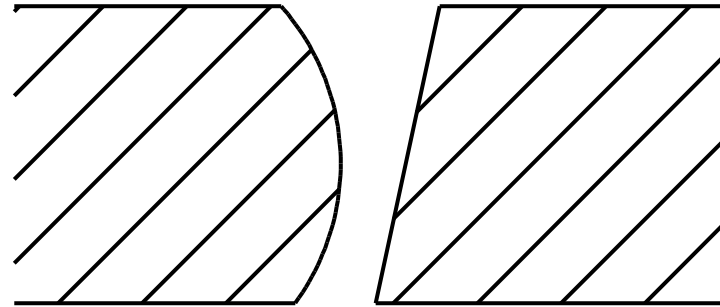


## Tooth breakages

- tooth pitch too coarse, blade is “hacking”
- too fine tooth pitch, blade is “jumping” on light and manual machines
- excessive feed rate or feed pressure ( overload of tooth gullets )
- blade speed is too low
- movement of the material in vice during cutting
- blade tension too low, blade starts slipping on the band wheels
- feed rate is not constantly due to hydraulic problems of feed unit
- chip brush is not working, chip overload in the gullets
- improper blade break in
- hard skin on material surface or uneven hardness within material



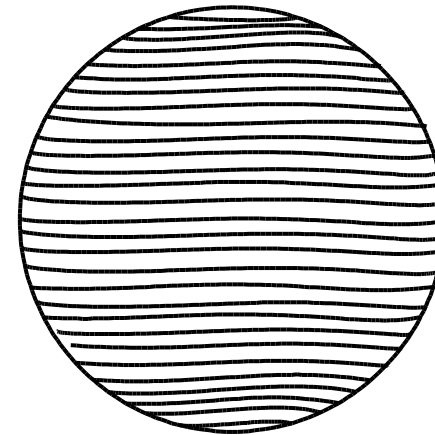
## Crooked cut

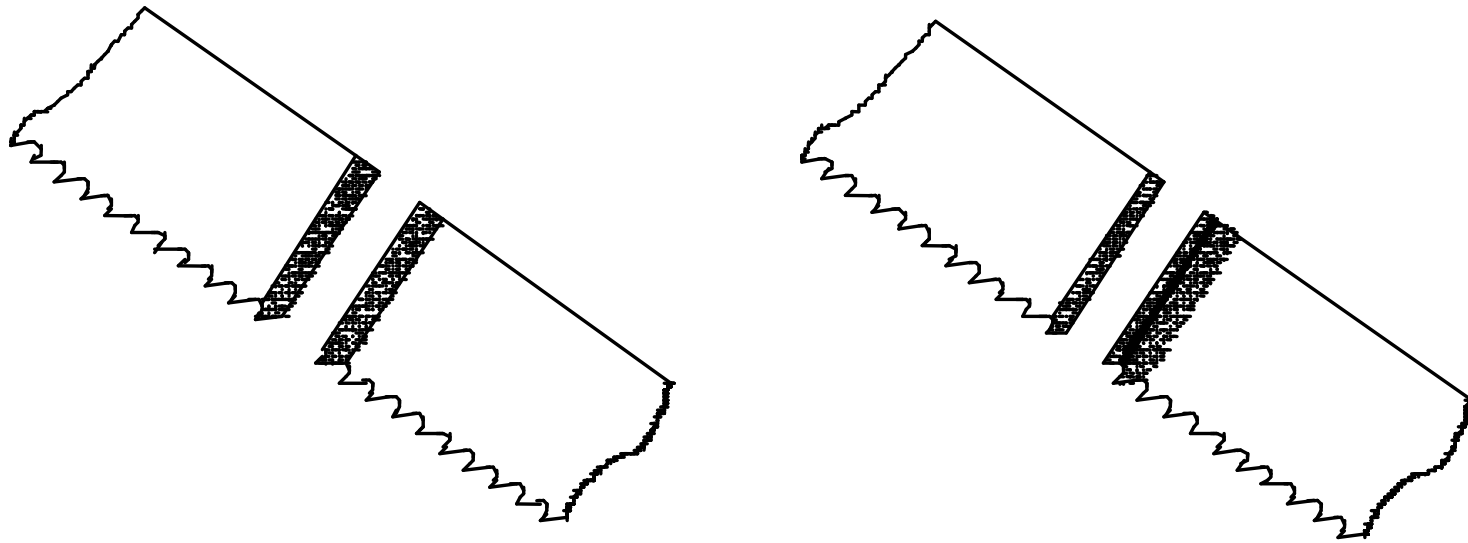


- ➔ blade tension too low
- ➔ feed pressure too high
- ➔ teeth pitch too fine for application
- ➔ loose or worn-out side guides
- ➔ machine out of alignment
- ➔ guide arms too far apart from work piece
- ➔ material is at maximum capacity of sawing machine

## Rough cutting surface

- cutting without break-in process
- blade speed too low or feed rate too high
- damaged or wear-out teeth
- bad weld joint
- chip brush is not working

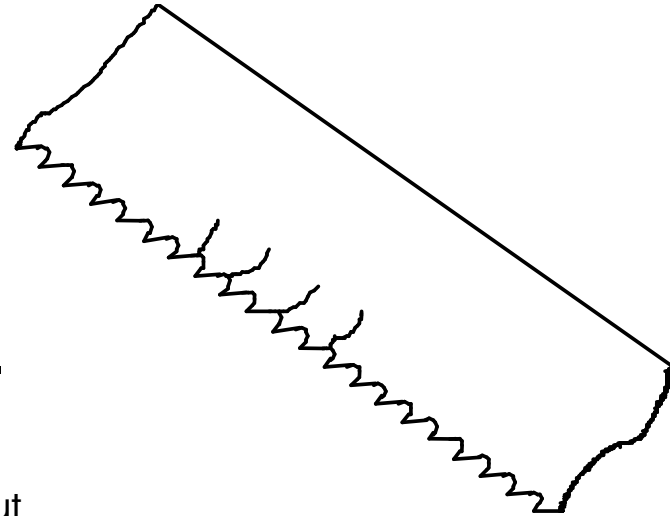




## Weld breakage

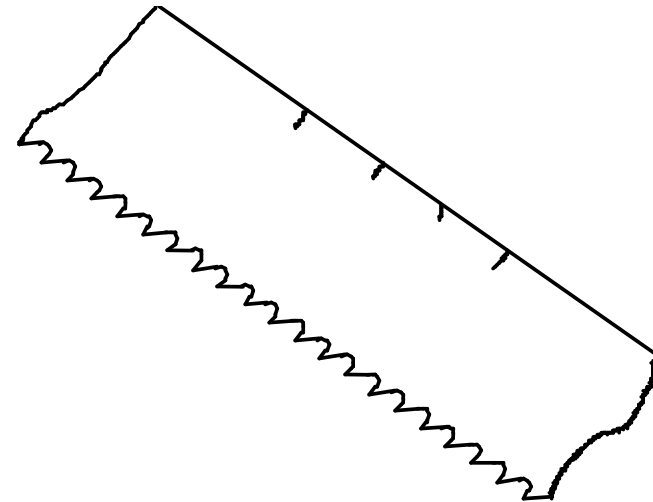
- poor quality of weld if weld joint is breaking in the center
- if weld-joint breaking in the annealing zone the blade tension could be too high
- diameter of saw machine wheel is too small
- blade tension too high

## **Cracking of tooth gullets**



- ➔ back / side guides are damaged or worn out
- ➔ side guides too tight / rubbing around gullet area
- ➔ loose side guides allows the blade to lean and bend
- ➔ blade tension too high

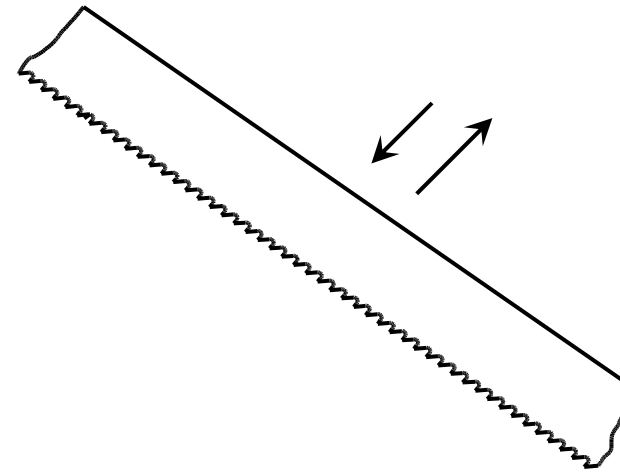
## **Backer cracks**



- excessive feed rate or feed pressure
- guide arms too far apart
- back / side guides are damaged or worn out
- blade backer is rubbing against machine wheel flange
- low blade tension



## **Blade is bouncing**



- ➔ weld is crooked, not straight
- ➔ too many teeth inside the cut, gullets filled-up with chips
- ➔ tooth breakages, blade worn-out
- ➔ feed pressure too low, teeth can not penetrate into material