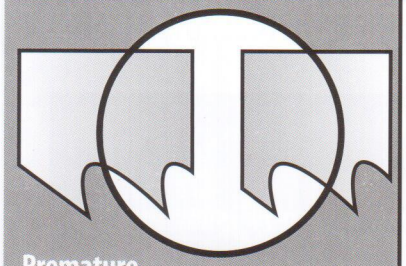
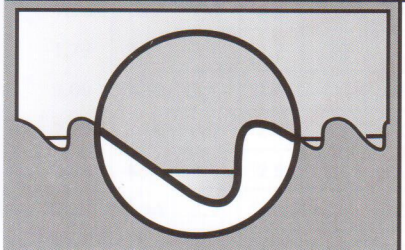
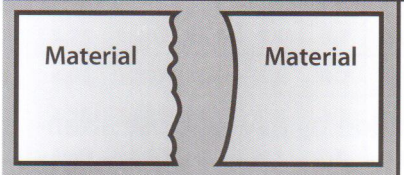
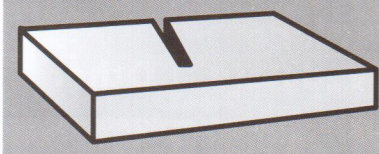
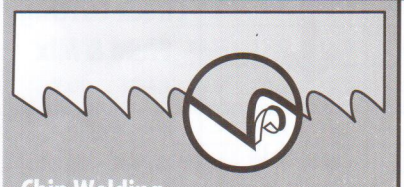
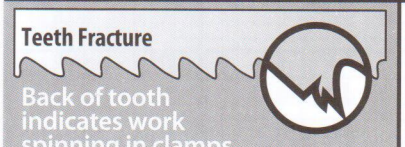
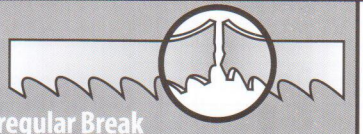
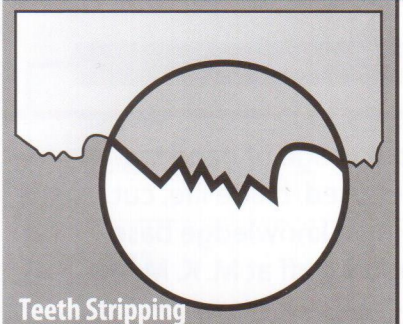
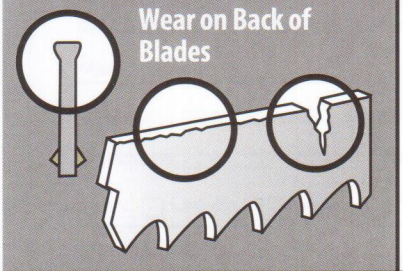
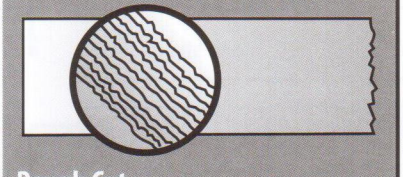
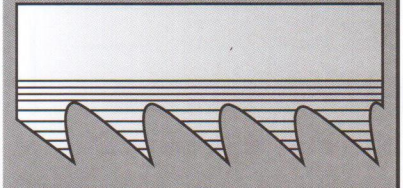
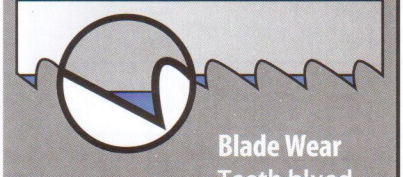
BLADE PROBLEM SOLVING

Problem	Problem Cause	Solution
 **Premature Blade Breakage** Straight Break indicates fatigue	• Incorrect blade - teeth too coarse • Blade tension too high • Side guides too tight • Damaged or misadjusted blade guides • Excessive feed • Incorrect cutting fluid • Wheel diameter too small for blade • Blade rubbing on wheel flanges • Teeth in contact with work before starting saw • Incorrect blade speed	• Use finer tooth pitch • Reduce blade tension (see machine manual) • Check side guide clearance (see machine manual) • Check all guides for alignment/damage • Reduce feed pressure • Check coolant • Use thinner blade • Adjust wheel alignment • Allow 1/2" clearance before starting cut • Increase or decrease blade speed
 **Premature Dulling of Teeth**	• Teeth pointing in wrong direction / blade mounted backwards • Improper or no blade break-in • Hard spots in material • Material work hardened • Improper coolant • Improper coolant concentration • Speed too high • Feed too light • Teeth too small	• Install blade correctly. If teeth are facing the wrong direction, flip blade inside out • Break in blade properly (Page 17) • Check for hardness or hard spots like scale or flame cut areas • Increase feed pressure • Check coolant type • Check coolant mixture • Check recommended blade speed (Page 24-25) • Increase feed pressure • Increase tooth size
 **Inaccurate Cut**	• Tooth set damage • Excessive feed pressure • Improper tooth size • Cutting fluid not applied evenly • Guides worn or loose • Insufficient blade tension	• Check for worn set on one side of blade • Reduce feed pressure • Check tooth size chart (Page 23) • Check coolant nozzles • Tighten or replace guides, check for proper alignment • Adjust to recommended tension
Band Leading in Cut 	• Over-feed • Insufficient blade tension • Tooth set damage • Guide arms loose or set too far apart • Chips not being cleaned from gullets • Teeth too small	• Reduce feed force • Adjust recommended tension • Check material for hard inclusions • Position arms as close to work as possible. Tighten arms. • Check chip brush • Increase tooth size
 **Chip Welding**	• Insufficient coolant flow • Wrong coolant concentration • Excessive speed and/or pressure • Tooth size too small • Chip brush not working	• Check coolant level and flow • Check coolant ratio • Reduce speed and/or pressure • Use coarser tooth pitch • Repair or replace chip brush
Teeth Fracture  Back of tooth indicates work spinning in clamps	• Incorrect speed and/or feed • Incorrect blade pitch • Saw guides not adjusted properly • Chip brush not working • Work spinning or moving in vise	• Check cutting chart (Page 24-25) • Check tooth size chart (Page 23) • Adjust or replace saw guides • Repair or replace chip brush • Check bundle configuration/adjust vise pressure
 **Irregular Break** Indicates material movement	• Indexing out of sequence • Material loose in vice	• Check proper machine movement • Check vise or clamp

Problem	Problem Cause	Solution
 Teeth Stripping	• Feed pressure too high • Tooth stuck in cut • Improper or insufficient coolant • Incorrect tooth size • Hard spots in material • Work spinning in vise - loose nest or bundle • Blade speed too slow • Blade teeth running backwards • Chip brush not working	• Reduce feed pressure • Do not enter old cut with a new blade • Check coolant flow and concentration • Check tooth size chart (Page 23) • Check material for hard inclusions • Check clamping pressure - be sure work is held firmly • Increase blade speed - see cutting chart (Page 24-25) • Reverse blade (turn inside out) • Repair or replace chip brush
Wear on Back of Blades 	• Excessive feed pressure • Insufficient blade tension • Back-up guide roll frozen, damaged, or worn • Blade rubbing on wheel flange	• Decrease feed pressure • Increase blade tension and readjust guides • Repair or replace back-up roll or guide • Adjust wheel cant
 Rough Cut Washboard surface Vibration and or chatter	• Dull or damaged blade • Incorrect speed or feed • Insufficient blade support • Incorrect tooth pitch • Insufficient coolant	• Replace with new blade • Increase speed or decrease feed • Move guide arms as close as possible to the work • Use finer pitch blade • Check coolant flow
Wear Lines, Loss of Set 	• Saw guide inserts or wheel flange are riding on teeth • Insufficient blade tension • Hard spots in material • Back-up guide worn	• Check machine manual for correct blade width • Tension blade properly • Check material for inclusions • Replace guide
Twisted Blade Profile sawing 	• Blade binding in cut • Side guides too tight • Radius too small for blade width • Work not firmly held • Erratic coolant flow • Excessive blade tension	• Decrease feed pressure • Adjust side guide gap • Use narrower blade • Check clamping pressure • Check coolant nozzles • Decrease blade tension
 Blade Wear Teeth blued	• Incorrect blade • Incorrect feed or speed • Improper or insufficient coolant	• Use coarser tooth pitch • Increase feed or decrease speed • Check coolant flow