



TROUBLESHOOTING CHART BAND SAW BLADES

For metal and/or wood cutting bandsaws

Blade Effect

Probable Cause

Solution

PREMATURE BLADE BREAKAGE

Straight break indicates fatigue

Incorrect Blade
Band tension too high
Excessive feed
Incorrect cutting fluid
Wheel diameter too small for blade width
Worn or chipped pressure block
Blade rubbing on wheel flange
Teeth in contact with work before starting saw
Side guides too tight

Check tooth selection
Reduce band tension,
Reduce feed pressure
Check coolant recommendations
Use narrower blade
Replace worn pressure blocks
Adjust wheel alignment
Allow blade clearance above work
Refer to operators manual

PREMATURE DULLING OF TEETH

Blade on machine backwards
Improper blade break-in procedure
Hard material or heavy surface scale
Material is work hardening
Improper cutting fluid or mix ratio
Speed or feed too high

Install blade correctly
Refer to recommended procedures
Check material hardness/surface cond.
Increase feed pressure
Follow coolant mixing procedures
Check cutting recommendations

INACCURATE UNMATCHING CUT

Guide arms too far apart
Blade worn out
Over or under feeding
Improper tooth pitch
Curing fluid not applied properly
Too many teeth for material cross section
Guides worn or loose

Adjust guide arms closer to material
Replace blade
Check cutting recommendations
Use proper tooth selection
Adjust coolant nozzles
Use proper tooth selection
Tighten or replace guides

BAND IS LEADING IN THE CUT

Over feeding
Low band tension
Tooth set damaged
Guide arms loose or space too wide

Check cutting recommendations
Refer to operators manual
Check material hardness
Adjust guides and guide arms

METAL CHIP WELDING TO BLADE

Worn or missing chip brush
Improper or lack of cutting fluid
Wrong coolant ratio
Excessive feed or speed
Incorrect blade pitch

Replace or adjust chip brush
Check coolant flow and fluid type
Check coolant type and ratio
Reduce feed or speed
Use proper tooth selection

Blade Effect	Probable Cause	Solution
IRREGULAR BREAK Indicates Material Movement.	Indexing while blade in work Blade not high enough before index Saw head drifts into work while neutral	Adjust index sequence Adjust height selector Check hydraulic cylinder
TEETH ARE STRIPPING OFF BAND	Improper blade break-in procedure Speed too slow Feed pressure to high Tooth jammed in cut Poor cutting fluid application or ratio Hard material or heavy scale Wrong blade pitch Work spinning or loose nested bundles Blade on backwards	Follow proper break-in procedure Refer to cutting recommendations Reduce feed pressure Do not enter new blade in that cut Adjust coolant flow and ration Check material or surface hardness Use proper tooth selection Tighten vises or use nesting clamps Install blade correctly
TEETH FRACTURE Back of tooth indicates work spinning in clamps.	Saw guides not properly adjusted Incorrect feed or speed Incorrect blade Material moved in vise	Align or adjust saw guides Refer to cutting recommendations Use proper blade type and pitch Inspect and adjust vises
WEAR ON THE BACK EDGE OF BLADE	Excessive back-up guide preload Low blade tension Incorrect blade (carbon steel type) Excessive feed rate or pressure Damaged or worn pressure block Guide arms spaced too far apart Blade rubbing band wheel flanges	Adjust pressure blocks Refer to operators manual Switch to a Bimetal blade Reduce feed rate or pressure Replace pressure block Adjust guide arms closer to work Adjust wheel alignment
ROUGH CUT Washboard surface. Vibration & Chatter.	Dull or damaged blade Incorrect feed or speed Blade not supported properly Low blade tension Incorrect tooth pitch Guide arms too far apart	Install new blade Refer to cutting recommendations Adjust or tighten guide arms Refer to operators manual Use proper tooth selection Adjust guide arms closer to material
WEAR LINES, LOSS OF SET	Saw side guides too tight Blade riding too high in guide Blade teeth riding on band wheel surface Wrong blade width for machine Chips be carried back into cut Worn or damaged pressure block Insufficient coolant flow	Adjust guides properly Adjust rollers or pressure blocks Adjust tracking or replace wheel Refer to operators manual Replace or adjust chip brush Replace pressure block Adjust coolant flow

Blade Effect

Probable Cause

Solution

TWISTED BLADE

Profile Sawing.

Blade binding in cut
Side guides are too tight
Work loose in vise
Feed to heavy
Guide arms too far apart

Adjust feed or use heavy set blades
Adjust guides
Adjust vises
Reduce feed pressure
Adjust guide arms closer to material

BLADE WEAR

Teeth are Blued.

Incorrect blade
Heavy feed or too fast speed
Lack of cutting fluid
Blade installed backwards

Use proper tooth selection
Adjust coolant flow or ratio
Install blade correctly