



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 too 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 too 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