

CUT-OFF SAWING TROUBLESHOOTING

CUTTING RATE TOO SLOW

1. Band pitch too fine. Use coarser pitch band.
2. Increase band speed.
3. Increase feed force.

INACCURATE CUTTING

1. Band teeth worn or dull. Replace band.
2. Hard spot in stock. Make new cut.
3. Chip brush not cleaning teeth. Adjust or replace.
4. Decrease feed force.
5. Check coolant. Replace if dirty.
6. Coolant not supplied evenly to both sides of band. Readjust.
7. Crooked stock. (Usually results in straight, but not square cuts.)
8. Guide arms too far from stock.
9. Wrong pitch band. Select correct pitch.
10. Increase band speed.
11. Wrong band tension. Readjust.
12. Check adjustment of saw guide inserts and back-up bearing. Readjust.
13. Check machine alignment.

SURFACE FINISH TOO DRY

1. Check for vibration. (See below)
2. Damaged band. Readjust.
3. Wrong coolant or mixture too weak. Replace.
4. Stock not firmly clamped.
5. Saw guide inserts worn or promptly adjusted. Readjust or replace.
6. Back-Up bearings worn. Replace.
7. Wrong band tension. Readjust.

VIBRATION

1. Dull or damaged band. Replace.
2. Wrong band speed or feed force. Readjust.
3. Wrong pitch band. Select correct pitch.
4. Stock not firmly clamped. Tighten vises.
5. Saw guide inserts worn or improperly adjusted. Readjust or replace.
6. Back-up bearing worn. Replace.
7. Wrong band tension. Readjust.

BAND NOT RUNNING TRUE AGAINST BACK UP BEARING (MAY CAUSE VIBRATION)

1. Check back-up bearings. Replace if chipped or worn more than 0.020-inch (0.5mm)
2. Check saw guide pivot bolts. Replace if worn.
3. Check machine Alignment.

BAND TOOTH STRIP PAGE

1. Decrease feed force.
2. Chipped tooth lodges in cut. Make new cut.
3. Chip welding. Check coolant mixture or reduce band speed.
4. Faulty stock. (Heavy scale, hard spots, etc) Decrease band speed by 1/2.
5. Wrong band. Too coarse for thin stock, use finer pitch.
6. Chip brush not cleaning teeth, adjust or replace.
7. Stock not firmly clamped. Tighten vises.
8. Saw guide inserts worn or improperly adjusted. Readjust or replace.
9. Back-up bearings worn. Replace.
10. Coolant not supplied correctly. Readjust.
11. Increase band speed.
12. Wrong band tension. Readjust.

BAND TOOTH LOADING

1. Band pitch too fine. Use coarser pitch band.
2. Increase band speed.
3. Chip brush not cleaning teeth. Adjust or Replace.
4. Decrease feed force.
5. Coolant not supplied correctly. Readjust.
6. Wrong band tension. Readjust.

PREMATURE TOOTH DULLING

1. Cutting rate too high. Decrease band speed and feed force.
2. Faulty stock (heavy scale, hard spots etc) Decrease band speed by 1/2.
3. Wrong band. Select correct. Readjust.
4. Coolant not supplied correctly. Readjust.
5. Check for vibration. (See above).
6. Chipped tooth lodged in cut. Make a new cut.
7. Chip welding. Check coolant mixture or reduce band speed.
8. Wrong coolant or mixture too weak. Replace.
9. Decrease feed force to "break in" band on first few cuts.
10. Wrong band tension.

PREMATURE BAND BREAKAGE

1. Poor weld. Replace band.
2. Band dropped into stock. Slow approach.
3. Decrease feed force.
4. Stock not firmly clamped. Tighten vises.
5. Increase band speed.
6. Check adjustment of saw guide inserts and back-up bearing. Readjust.
7. Insufficient coolant. Readjust.
8. Band pitch too fine. Use coarser pitch band.
9. Wrong band tension Readjust.