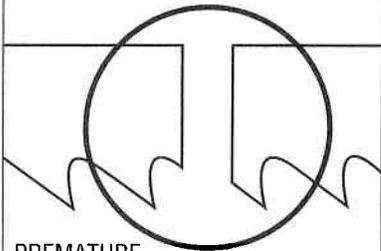
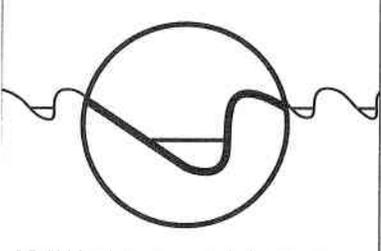
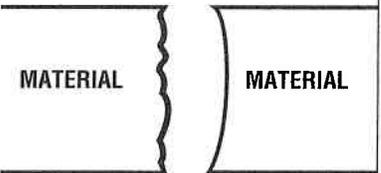
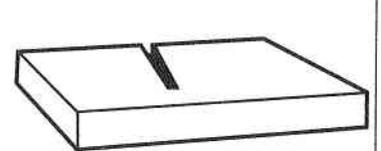
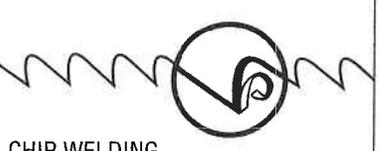
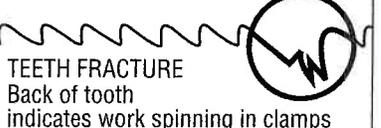
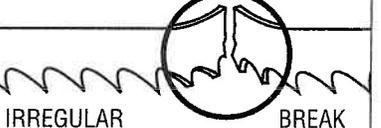


PROBLEM SOLVING

PROBLEM	PROBABLE CAUSE	SOLUTION
 <p>PREMATURE BLADE BREAKAGE Straight Break indicates fatigue</p>	<ul style="list-style-type: none"> • 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 velocity 	<ul style="list-style-type: none"> • Use finer tooth pitch • Reduce blade tension - see machine operator's manual • Check side guide clearance - see machine manual • Check all guides for alignment and damage • Reduce feed pressure • Check coolant • Use thinner blade • Adjust wheel alignment • Allow 1/2" clearance before starting cut • Increase or decrease blade speed
 <p>PREMATURE DULLING OF TEETH</p>	<ul style="list-style-type: none"> • 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 	<ul style="list-style-type: none"> • Install blade correctly. If teeth are facing in the wrong direction, flip blade inside out • Break in blade properly - see recommended procedures • Check material for hardness or hard spots like scale or flame cut areas • Increase feed pressure • Check coolant type • Check coolant mixture • Check recommended blade speed • Increase feed pressure
 <p>MATERIAL MATERIAL</p> <p>INACCURATE CUT</p>	<ul style="list-style-type: none"> • Tooth set damage • Excessive feed pressure • Improper tooth size • Cutting fluid not applied evenly • Guides worn or loose • Insufficient blade tension 	<ul style="list-style-type: none"> • Check for worn set on one side of blade • Reduce feed pressure • Check cutting chart • Check coolant nozzles • Tighten or replace guides, check for proper alignment • Adjust to recommended tension
 <p>BAND LEADING IN CUT</p>	<ul style="list-style-type: none"> • Over-feed • Insufficient blade tension • Tooth set damage • Guide arms loose or set too far apart • Chips not being cleaned from gullets 	<ul style="list-style-type: none"> • Reduce feed force • Adjust recommended tension • Check material for hard inclusions • Position arms as close to work as possible. Tighten arms • Check chip brush
 <p>CHIP WELDING</p>	<ul style="list-style-type: none"> • Insufficient coolant flow • Wrong coolant concentration • Excessive speed and/or pressure • Tooth size too small • Chip brush not working 	<ul style="list-style-type: none"> • Check coolant level and flow • Check coolant ratio • Reduce speed and/or pressure • Use coarser tooth pitch • Repair or replace chip brush
 <p>TEETH FRACTURE Back of tooth indicates work spinning in clamps</p>	<ul style="list-style-type: none"> • Incorrect speed and/or feed • Incorrect blade pitch • Saw guides not adjusted properly • Chip brush not working 	<ul style="list-style-type: none"> • Check cutting chart • Check cutting chart • Adjust or replace saw guides • Repair or replace chip brush
 <p>IRREGULAR BREAK Indicates material movement</p>	<ul style="list-style-type: none"> • Indexing out of sequence • Material loose in vice 	<ul style="list-style-type: none"> • Check proper machine movement • Check vise or clamp