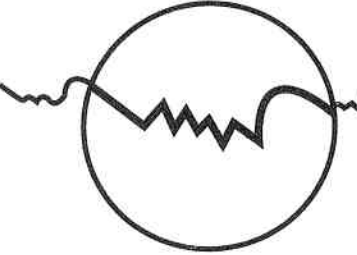
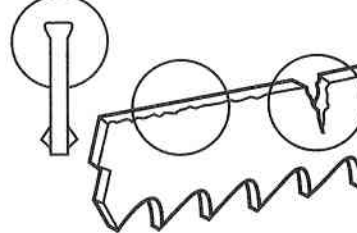
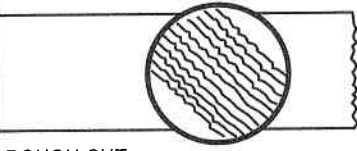
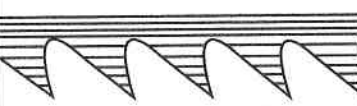




# PROBLEM SOLVING

PROBLEM	PROBABLE CAUSE	SOLUTION
 <p>TEETH STRIPPING</p>	<ul style="list-style-type: none"> <li>• Feed pressure too high</li> <li>• Tooth stuck in cut</li> <li>• Improper or insufficient coolant</li> <li>• Tooth pitch too large</li> <li>• Hard spots in material</li> <li>• Work spinning in vise - loose nest or bundle</li> <li>• Blade speed too slow</li> <li>• Blade teeth running backwards</li> <li>• Chip brush not working</li> </ul>	<ul style="list-style-type: none"> <li>• Reduce feed pressure</li> <li>• Do not enter old cut with a new blade</li> <li>• Check coolant flow and concentration</li> <li>• Use finer tooth pitch</li> <li>• Check material for hard inclusions</li> <li>• Check clamping pressure - be sure work is held firmly</li> <li>• Increase blade speed - see cutting chart</li> <li>• Reverse blade (turn inside out)</li> <li>• Repair or replace chip brush</li> </ul>
 <p>WEAR ON BACK OF BLADES</p>	<ul style="list-style-type: none"> <li>• Excessive feed pressure</li> <li>• Insufficient blade tension</li> <li>• Back-up guide roll frozen, damaged, or worn</li> <li>• Blade rubbing on wheel flange</li> </ul>	<ul style="list-style-type: none"> <li>• Decrease feed pressure</li> <li>• Increase blade tension and readjust guides</li> <li>• Repair or replace back-up roll or guide</li> <li>• Re-align wheel</li> </ul>
 <p>ROUGH CUT washboard surface Vibration and or chatter</p>	<ul style="list-style-type: none"> <li>• Dull or damaged blade</li> <li>• Incorrect speed or feed</li> <li>• Insufficient blade support</li> <li>• Incorrect tooth pitch</li> <li>• Insufficient coolant</li> </ul>	<ul style="list-style-type: none"> <li>• Replace with new blade</li> <li>• Increase speed or decrease feed</li> <li>• Move guide arms as close as possible to the work</li> <li>• Use finer pitch blade</li> <li>• Check coolant flow</li> </ul>
 <p>WEAR LINES, LOSS OF SET</p>	<ul style="list-style-type: none"> <li>• Saw guide inserts or pulley are riding on teeth</li> <li>• Insufficient blade tension</li> <li>• Hard spots in material</li> <li>• Back-up guide worn</li> </ul>	<ul style="list-style-type: none"> <li>• Check machine manual for correct blade width</li> <li>• Tension blade properly</li> <li>• Check material for inclusions</li> <li>• Replace</li> </ul>
 <p>TWISTED BLADE Profile sawing</p>	<ul style="list-style-type: none"> <li>• Blade binding in cut</li> <li>• Side guides too tight</li> <li>• Radius too small for blade width</li> <li>• Work not firmly held</li> <li>• Erratic coolant flow</li> <li>• Excessive blade tension</li> </ul>	<ul style="list-style-type: none"> <li>• Decrease feed pressure</li> <li>• Adjust side guide gap</li> <li>• Use narrower blade</li> <li>• Check clamping pressure</li> <li>• Check coolant nozzles</li> <li>• Decrease blade tension</li> </ul>
 <p>BLADE WEAR Teeth blued</p>	<ul style="list-style-type: none"> <li>• Incorrect blade</li> <li>• Incorrect feed or speed</li> <li>• Improper or insufficient coolant</li> </ul>	<ul style="list-style-type: none"> <li>• Use coarser tooth pitch</li> <li>• Increase feed or decrease speed</li> <li>• Check coolant flow</li> </ul>