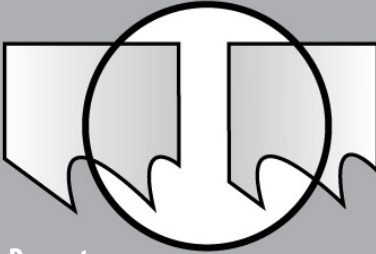
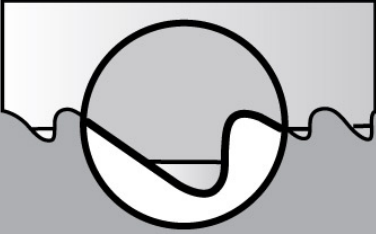
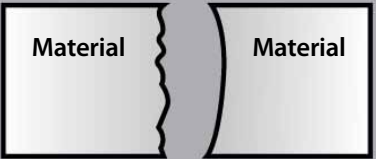
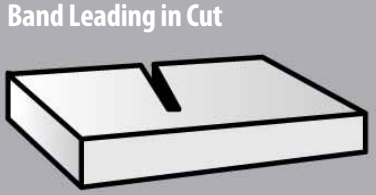
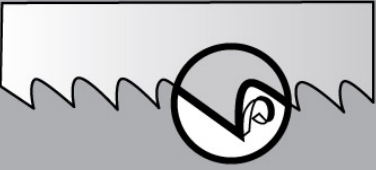
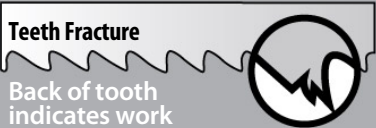

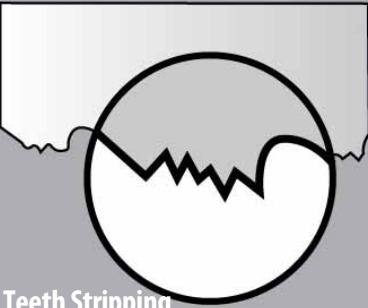
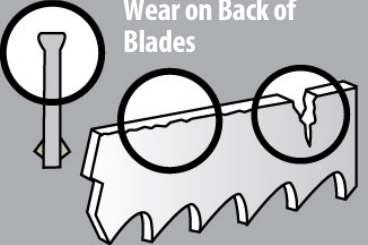
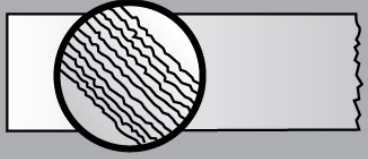
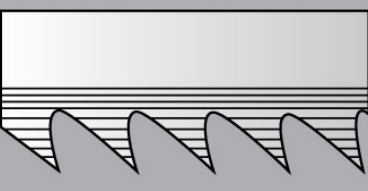

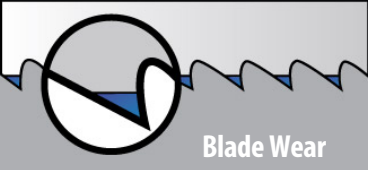


Problem	Problem Cause	Solution
 <p><b>Premature Blade Breakage</b> Straight Break indicates fatigue</p>	<ul style="list-style-type: none"> <li>• Incorrect blade - teeth too coarse</li> <li>• Blade tension too high</li> <li>• Side guides too tight</li> <li>• Damaged or misadjusted blade guides</li> <li>• Excessive feed</li> <li>• Incorrect cutting fluid</li> <li>• Wheel diameter too small for blade</li> <li>• Blade rubbing on wheel flanges</li> <li>• Teeth in contact with work before starting saw</li> <li>• Incorrect blade speed</li> </ul>	<ul style="list-style-type: none"> <li>• Use finer tooth pitch</li> <li>• Reduce blade tension (see machine manual)</li> <li>• Check side guide clearance (see machine manual)</li> <li>• Check all guides for alignment/damage</li> <li>• Reduce feed pressure</li> <li>• Check coolant</li> <li>• Use thinner blade</li> <li>• Adjust wheel alignment</li> <li>• Allow 1/2" clearance before starting cut</li> <li>• Increase or decrease blade speed</li> </ul>
 <p><b>Premature Dulling of Teeth</b></p>	<ul style="list-style-type: none"> <li>• Teeth pointing in wrong direction / blade mounted backwards</li> <li>• Improper or no blade break-in</li> <li>• Hard spots in material</li> <li>• Material work hardened</li> <li>• Improper coolant</li> <li>• Improper coolant concentration</li> <li>• Speed too high</li> <li>• Feed too light</li> <li>• Teeth too small</li> </ul>	<ul style="list-style-type: none"> <li>• Install blade correctly. If teeth are facing the wrong direction, flip blade inside out</li> <li>• Break in blade properly (Page 17)</li> <li>• Check for hardness or hard spots like scale or flame cut areas</li> <li>• Increase feed pressure</li> <li>• Check coolant type</li> <li>• Check coolant mixture</li> <li>• Check recommended blade speed (Page 24-25)</li> <li>• Increase feed pressure</li> <li>• Increase tooth size</li> </ul>
 <p><b>Inaccurate Cut</b></p>	<ul style="list-style-type: none"> <li>• Tooth set damage</li> <li>• Excessive feed pressure</li> <li>• Improper tooth size</li> <li>• Cutting fluid not applied evenly</li> <li>• Guides worn or loose</li> <li>• Insufficient blade tension</li> </ul>	<ul style="list-style-type: none"> <li>• Check for worn set on one side of blade</li> <li>• Reduce feed pressure</li> <li>• Check tooth size chart (Page 23)</li> <li>• Check coolant nozzles</li> <li>• Tighten or replace guides, check for proper alignment</li> <li>• Adjust to recommended tension</li> </ul>
 <p><b>Band Leading in Cut</b></p>	<ul style="list-style-type: none"> <li>• Over-feed</li> <li>• Insufficient blade tension</li> <li>• Tooth set damage</li> <li>• Guide arms loose or set too far apart</li> <li>• Chips not being cleaned from gullets</li> <li>• Teeth too small</li> </ul>	<ul style="list-style-type: none"> <li>• Reduce feed force</li> <li>• Adjust recommended tension</li> <li>• Check material for hard inclusions</li> <li>• Position arms as close to work as possible. Tighten arms.</li> <li>• Check chip brush</li> <li>• Increase tooth size</li> </ul>
 <p><b>Chip Welding</b></p>	<ul style="list-style-type: none"> <li>• Insufficient coolant flow</li> <li>• Wrong coolant concentration</li> <li>• Excessive speed and/or pressure</li> <li>• Tooth size too small</li> <li>• Chip brush not working</li> </ul>	<ul style="list-style-type: none"> <li>• Check coolant level and flow</li> <li>• Check coolant ratio</li> <li>• Reduce speed and/or pressure</li> <li>• Use coarser tooth pitch</li> <li>• Repair or replace chip brush</li> </ul>
 <p><b>Teeth Fracture</b> Back of tooth indicates work spinning in clamps</p>	<ul style="list-style-type: none"> <li>• Incorrect speed and/or feed</li> <li>• Incorrect blade pitch</li> <li>• Saw guides not adjusted properly</li> <li>• Chip brush not working</li> <li>• Work spinning or moving in vise</li> </ul>	<ul style="list-style-type: none"> <li>• Check cutting chart (Page 24-25)</li> <li>• Check tooth size chart (Page 23)</li> <li>• Adjust or replace saw guides</li> <li>• Repair or replace chip brush</li> <li>• Check bundle configuration/adjust vise pressure</li> </ul>
 <p><b>Irregular Break</b> Indicates material movement</p>	<ul style="list-style-type: none"> <li>• Indexing out of sequence</li> <li>• Material loose in vise</li> </ul>	<ul style="list-style-type: none"> <li>• Check proper machine movement</li> <li>• Check vise or clamp</li> </ul>

Problem	Problem Cause	Solution
 <p><b>Teeth Stripping</b></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>• Incorrect tooth size</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>• Check tooth size chart (Page 23)</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 (Page 24-25)</li> <li>• Reverse blade (turn inside out)</li> <li>• Repair or replace chip brush</li> </ul>
 <p><b>Wear on Back of Blades</b></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>• Adjust wheel cant</li> </ul>
 <p><b>Rough Cut</b> 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><b>Wear Lines, Loss of Set</b></p>	<ul style="list-style-type: none"> <li>• Saw guide inserts or wheel flange 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 guide</li> </ul>
 <p><b>Twisted Blade Profile sawing</b></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><b>Blade Wear Teeth blued</b></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>