

# TROUBLESHOOTING

## Premature Tooth Wear

- Improper Break-In
- Check blade speed and feed rates
- Improper cooler or coolant concentration
- Incorrect tooth pitch

## Teeth Stripping

- Excessive feed rate
- Improper break-in
- Insufficient coolant
- Parts held insecurely
- Too slow blade speed and incorrect tooth size

## Blade Not Cutting Straight

- Worn out blade
- Worn out or loose guide arms
- Too high feed pressure
- Improper blade tension and tooth pitch

## Wear on back of Blade

- Excessive feed pressure
- Improper blade tension
- Back-up guide worn

## Rough Cut

- Dull / Damaged Blade
- Improper drill feed or speed
- Insufficient band support or tension
- Improper break in

## Blade Breakage

- Blade tension too high
- Excessive feed pressure
- Course teeth
- Improperly set or worn out guides
- Wheel diameter too small

## Gullets Loaded with Chips

- Speed too slow
- Blade pitch too fine
- Chip bursh not working
- Improper/Insufficient coolant mix

## Chip Welding

- Excessive feed pressure
- Chip bursh not working
- Insufficient/ Improper coolant mix