



**BAHCO**

## Trouble shooting guide - Bandsawing

	Important Facts	Band breakage	Crooked sawing	Tooth breakage	Rough surface	Rapid tooth wear	Vibration	Band slips on wheel
Machine	<b>Guides and Guidearms</b> You have to check and adjust guides regularly. Check if worn out and replace if necessary. Position guidearms as close to work piece as possible	Guides worn out or guide setting to wide	Guides too far apart, work out, or poorly adjusted guidearm loose.				Guides poorly adjusted	
	<b>Band Wheels</b> The band wheels have to be kept in good condition and properly aligned.	Band wheels worn or too small - try thinner bands						Driving wheel is work out
	<b>Chip Brush</b> Check that the chip brush is properly adjusted and change it regularly			Chip brush does not work; gullets filled		Chip brush does not work		
	<b>Band Tension</b> The correct band tension is needed to get a straight cut. Measure with Bahco tensionmeter	Band tension too high	Band tension too low				Band tension too low	Band tension too low
	<b>Coolant/Cutting Fluid</b> Need to lubricate and to cool. Check concentration with a Bahco refractometer. Use good coolant. It should reach the cut with low pressure and with generous flow.					Too little coolant or incorrect concentration		
Cutting Data	<b>Band Speed</b> The band speed has to be chosen correctly. Check the band speed by using a bahco tachometer.		Band speed too low		Band speed too low	Band speed too high	Natural vibration band speed slightly high low	
	<b>Feed Rate</b> The feed rate has to be chosen so that the teeth of the bandsaw blade can work properly.	Feed rate too high	Feed rate too high	Feed rate too high	Feed rate too high	Feed rate too high or too low	Feed rate too high or too low	Feed rate too high
Bandsaw Blade	<b>Tooth Pitch</b> The selection of the right tooth pitch is just as important as choosing the right feed and speed.		Tooth pitch too fine	Tooth pitch too fine gullets filled	Tooth pitch too coarse	Tooth pitch too fine		
	<b>Tooth Shape</b> Every tooth shape has its ideal application.			Tooth shape too weak		Wrong tooth shape selection	Use Combo	
	<b>Break-in</b> A new bandsaw blade should be broken in to obtain maximum bandsaw lifetime. Never saw in old kerf.				Band not properly run in	Band not properly run in	Band not properly run in	
	<b>Blade Life</b> All blades wear out eventually. Look for signs of wear.		Blade worn out		Blade worn out			Blade worn out
Workpiece	<b>Surface</b> A bad surface (scale) of the work piece will shorten the life of the blade. Lower the band speed.					Surface defects, i.e. scale, rust, sand		
	<b>Clamping</b> Securely clamp work pieces, especially when bundle cutting. Do not use bent or damages work pieces			Work piece moves			Work piece not properly clamped	