



Bandsaw Trouble Shooting Guide

For our customer's information the following is a guide to common problems encountered when running a bandsaw and the possible causes of the problems. This can only be considered valuable information to the bandsaw user, when trying to maximise production of high quality sawn timber and minimise wastage and down time. The second part of this guide consists of a recommended machine maintenance schedule covering all aspects of the bandsaw.

Problem

Possible Causes

Saw Overheats

Wood or Feed Causes

Overfeeding
 Variability in the wood, e.g. High density abrasive
 Uneven saw back
 Inadequate side clearance
 Unequal side clearance
 Saw guide too tight

Saw Causes

Saw Snakes In Cut

Feed causes

Saw causes

Insecurely held timber
 Incorrect or irregular tension
 Uneven Swage
 Insufficient hook (forcing feed)
 Dull teeth
 Saw not level (high spots)
 Saw dished
 Overloaded gullets
 Worn wheel faces
 Misaligned wheels

Band mill causes

Saw Runs Forward When Entering The Cut

Feeding too slow
 Excessive hook angle for set-up

Saw Dodges When Entering The Cut

Entering the cut too fast
 Insufficient tension
 Excessive side clearance
 Insufficient strain



Saw Deviates Constantly

- Faulty tension
- Faulty wheel faces
- Unequal side clearance

Saw Dishes (Tight on one side, slack on other, uneven tension)

Band mill causes

- Dirty wheels with guide rubbing saw on one side
- Excessive wheel wear
- Wheel faces worn differently



Bench causes

Tensioning rolls

- Unequal in diameter
- Travelling at different speeds
- Out of round
- Misaligned
- Non-parallel
- Saw fed into rolls at an angle

Saw Vibrates

Saw Causes

Faulty tension

- Saw not straight
- Saw has lumps or ridges
- Improperly adjusted saw guides
- Wheel out of balance
- Wheel bearings worn
- Wheel out of round
- V-belts loose, mismatched or oversize
- Insecurely mounted husk
- Insecurely mounted drive motor

Band mill causes

Saw Oscillates On Wheels

Saw causes

Cracks on saw edge

- Twisted saw
- Back edge of weld uneven
- Back edge uneven, either crowned or straight
- Dirty wheels
- Unevenly worn wheel surfaces

Band mill causes

Saw Twisted

Saw causes

- Stretcher rolls badly worn, improperly assembled
- Saw not held against fence during stretching
- Saw improperly hammered, faulty hammer used
- Saw overheats
- Saw overfed
- Wheels out of line
- Top wheel excessively tilted
- Saw guides set improperly

Band mill causes

Saw Develops Cracks

Saw causes

- Excessive tooth speed
- Excessive or uneven tension
- Hammering too hard, causing hardening or cuts
- Saw vibrates
- Stress risers, e.g. sharp angles in gullets



Band mill causes

Grinder causes

- Gullet too deep and narrow
- Insufficient or excessive tension on saw blade
- Back edge too long or too short
- Insufficient hook angle
- Overloading the gullets
- Saw improperly stored (overstressed)
- Insufficient saw gauge for speed and load
- Too much saw overhang on wheel
- Saw gauge excessive for wheel diameter
- Dull saw teeth (run too long between servicing)
- Excessive strain
- Saw guides improperly adjusted
- Cross-aligned wheels
- Saw crowded against back guard
- Faulty wheel faces
- Worn wheel bearings
- Case hardening caused by gummed grinding wheel
- Overheating during grinding causing blueing and case hardening
- Saw has lumps or ridges
- Excessive grinding load or speed

Machine Maintenance Guide

Periodic checks on all machines are essential if efficient and trouble free performance is to be maintained. The recommended servicing and lubrication routines, specified by the manufacturers of the various machines, should always be strictly adhered to and the various specified lubricants and spares always available. Likewise it is essential that during the actual working operations the machines are not operated by anyone who is not fully aware of their designated capacity and competent to work their particular machine

Weekly Checks

- 1.) Saw guides and deflectors
- 2.) Wheel scraper and cleaning pads
- 3.) Lubricant tanks for drip feed lubrication etc
- 4.) Saw straining mechanism
- 5.) Top wheel lifting screws
- 6.) Band mill wheels
- 7.) Saw cleaning assembly
- 8.) Log carriages
- 9.) Log loading equipment
- 10.) General lubrication and cleaning

Monthly Checks

- 1.) Bandsaw wheel bearings
- 2.) Top wheel assembly

Annual Checks

- 1.) Carriage track rail alignment
- 2.) Bandsaw wheel faces
- 3.) Bandsaw wheel bearings
- 4.) Re-facing bandsaw wheels
- 5.) Balancing bandsaw wheels
- 6.) Band mill wheel and carriage track alignment

Bandsaw Consumables

The following items in the maintenance of bandsaw machines and bandsaw blades are available from us.

- 1.) Saw guides
- 2.) Lubricants
- 3.) Scrapers and pads
- 4.) Feed rollers



3.) Saw straining mechanism

Six-Monthly Checks

- 1.) Log carriage wheels and track rails
- 2.) Top guide and assembly slides

We offer a service for bandsaw machines which includes a full survey followed by a written report, the subsequent supply of parts can then be arranged, inclusive of fitting if necessary. The condition of wheel faces and bearings is often found to be the main cause of poor sawing and sawblade cracking, maintenance on these should be carried out every 3 to 5 years.