

POSSIBLE CAUSES OF BLADE FAILURE

Observation	Band Speed	Band Wheels	Break-In Proced.	Chip Brush	Sawing Fluid	Feeding Rate	Side Guides	Backup Guides	Preload Condition	Band Tension	Band Tracking	Tooth Pitch
#1 Heavy even wear on tips and corners of teeth	•		•		•	•						
#2 Wear on both sides of teeth							•	•				
#3 Wear on one side of teeth		•					•					
#4 Chipped or broken teeth			•			•						•
#5 Discolored tips of teeth due to excessive frictional heat	•				•	•						
#6 Tooth strippage	•		•	•	•	•						•
#7 Chips welded to tooth tips	•			•	•	•						
#8 Gullets loading up with material				•	•	•						•
#9 Heavy wear on both sides of band					•		•					
#10 Uneven wear or scoring on sides of the band							•					
#11 Body breakage or cracks from gullets							•		•	•		
#12 Body breakage—fracture traveling in angular direction							•		•			
#13 Body breakage or cracks from back edge						•		•	•	•	•	
#14 Heavy wear and/or swaging on back edge						•		•	•		•	
#15 Butt weld breakage						•	•	•	•	•	•	
#16 Used band is “long” on the tooth edge		•				•	•		•		•	
#17 Used band is “short” on the tooth edge		•				•	•					
#18 Band is twisted into figure “8” configuration		•				•	•	•	•	•	•	
#19 Broken band shows a twist in band length		•				•	•	•	•	•	•	
#20 Heavy wear in only the smallest gullets	•					•						•