

# Burr **OAK** Tool Inc.

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## TROUBLESHOOTING THE STRAIGHT TUBE CUTOFF

The following guide lists the problem or condition first, then where to check to correct the problem. This is only a quick guide. If a specific solution cannot be found, please refer to your Machine Manual or contact Burr Oak Tool Inc., and we will try to help resolve the problem to return your machine to full production.

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### STRAIGHT TUBE CUTOFF LINE

PROBLEM	CAUSE	SOLUTION
Cutter blade malfunctions. (Chipping)	Malfunctioning oil mist lubricator.	Failure to use adequate lubricant will diminish blade life. Lack of lubricant will also make the cutoff head sluggish, eventually causing blades to be broken.
	Improperly installed cutter blade.	(Single blades only) The straight side of the blade should face the feed portion of the machine, while the angle side should face the discharge end.
	Inadequate pressure in the hold-down clamp.	If the pull-apart is being used and the tube slips in the hold-down clamp the cutter will break.
	Cutter return stroke proximity switch set too close.	If set too close, the switch will initiate the feed before the cutter has completely retracted, breaking the blade or causing spiral marks on the tube.
	Foreign material buildup or clogging inside cutter sandwich.	Any binding action that prevents the carrier from retracting will cause chipped cutters.
	Fatigued return springs.	The cutter must retract quickly or spiral marks may appear on the tube.
	Bent tubing reaching the cutter area.	Only about .020" clearance is provided for the cutter blade. Bent tubing can cause chipping.

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## STRAIGHT TUBE CUTOFF LINE (Con't)

PROBLEM	CAUSE	SOLUTION
Cutter blade malfunctions. (Chipping)	Binding cam pins.	Any binding action may cause chipped cutters.
	Dense material.	Life of cutters is dependent on the material being cut.
Loss of Length Control	Improperly installed clamp jaws.	When the upper and lower jaws are assembled, the clamping area of the jaws will present a staggered pattern.
	Foreign material buildup or clogging.	Buildup may occur in the relieved areas of the clamp jaws.
	Insufficient air pressure.	Additional pressure maybe needed if tubing is heavier or needs an exceptional amount of straightening.
	Worn shock blocks.	Readjust if possible, replace if needed.
Hydraulic oil reserve needs constant refilling.	Seals on cut cylinder are ripped.	Run machine in manual mode, push and hold the cut button. If bubbles appear in cylinder, the seals need replacing.
Undesired spiraling on tube.	Foreign material buildup or clogging, preventing blade from retracting.	Clean and apply proper amounts of grease.
Excessive clamp markings.	Incorrect pressure on hold, pull, and hitch feed clamps.	Refer to Setup Instructions.