






TROUBLESHOOTING - DRILLING

Fault	Solution
 <p>Heavy/Rapid flank wear</p>	<ul style="list-style-type: none"> • Reduce cutting speed • Increase feed rate
 <p>Chipping on cutting edge</p>	<ul style="list-style-type: none"> • Reduce feed rate • Check spindle and tool holder rigidity • Check workpiece rigidity
 <p>Chipping on corner</p>	<ul style="list-style-type: none"> • Reduce feed rate • Check workpiece rigidity
 <p>Built-up edge</p>	<ul style="list-style-type: none"> • Increase cutting speed • Use different chip breaker
 <p>Scratching on drill body</p>	<ul style="list-style-type: none"> • Check workpiece rigidity • Reduce feed rate • Increase coolant flow