

## TYPICAL DRILLING ISSUES

	<p><b>ANGLED SURFACE</b></p> <ul style="list-style-type: none"> <li>• Reduce feed when starting</li> <li>• <math>&lt;5^\circ</math> reduce by <math>\leq 30\%</math></li> <li>• <math>&lt;10^\circ</math> reduce by <math>\leq 40\%</math></li> <li>• <math>&lt;25^\circ</math> reduce by <math>\leq 50\%</math></li> <li>• <math>&gt;25^\circ</math> reduce by <math>\leq 60\%</math></li> <li>• Use shortest drill possible</li> <li>• If possible, use flat bottom carbide drill or spade drill</li> </ul>
	<p><b>ANGLED EXIT</b></p> <ul style="list-style-type: none"> <li>• At point of exit, reduce feed by <math>\leq 50\%</math></li> </ul>
	<p><b>CROSS BORE</b></p> <ul style="list-style-type: none"> <li>• Reduce feed by <math>\leq 50\%</math> at start of interrupted cut</li> <li>• Increase feed once cross bore has been cleared</li> <li>• Be wary of chip clogging</li> </ul>
	<p><b>STACKED DRILLING</b></p> <ul style="list-style-type: none"> <li>• Plates must be clamped rigidly</li> <li>• Maximum permissible gap 0.5mm - 1.0mm</li> </ul>
	<p><b>UNEVEN SURFACE</b></p> <ul style="list-style-type: none"> <li>• Reduce feed when starting by <math>\leq 50\%</math> depending on depth of unevenness</li> <li>• If possible, spot face surface first</li> </ul>
	<p><b>CHAIN DRILLING</b></p> <ul style="list-style-type: none"> <li>• Drill holes 1 &amp; 2 first</li> <li>• When drilling hole 3, reduce feed by <math>\leq 50\%</math> to cater for interrupted cut</li> <li>• Make overlap <math>&lt; 1.5\text{mm}</math> on diameter if possible</li> </ul>