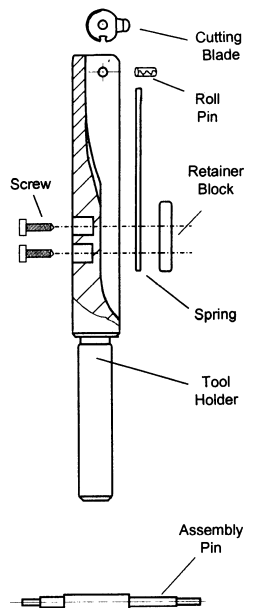


Trouble Shooting Solutions

Problem	Explanation	Solution
Chamfer Ø too large	Tool is designed to cut to a set chamfer diameter	Select a smaller sized tool
Chamfer Ø too small	Chamfer is cutting to the designed maximum from the catalog but this is not large enough Chamfer is not to designed maximum size	Use the next size larger tool if possible. The Cofa tool is only designed for edge breaks but specials can be requested. Use the next higher strength spring Use a slower feed rate
Tool chatters	Operating conditions are not correct Not enough cutting force for your material	Increase feed rates Decrease speed rates Use coolant on tool Use the next higher strength spring
Tool is pushing the burr	Blade is used or dull Blade is new but still not working	Change the insert Use the next higher strength spring Check programming position and feed rates Burr are too large
Tool creates a secondary burr or poor surface finish	Spring is too heavy Chamfer size is large Operating conditions are not correct	Use the next lighter strength spring Use a smaller tool to achieve a smaller edge break Check recommended feed rates & speed rates
Cutting blades are chipping	Programming error Interrupted cut or possible wall interference	Check programming positioning Make sure cutting edge is not in fast feed when cutting Try smaller tool or ask HEULE to look at application
Uneven chamfer or missing some burrs	Speed rate far too high Ratio between cross hole and tube diameter (d:D) is larger than 0.5 Not enough cutting force for your material	Reduce speed rate Ask HEULE to look at application Special inserts are possible Change spring or use the next higher strength spring
Blade is breaking or falling out of tool	Interrupted cut or possible wall interference Roll pins are being deformed	Ask HEULE to look at application Try smaller tool Check assembly procedures Assembly pins must be used when changing blades Change roll pin Check programming positioning

COFA Carbide-TiN Cutting Blades



My chamfer is too big. Can I reduce it by feeding the tool faster?

Not recommended. The Cofa tool is designed to cut the same diameter as stated in the catalog if all parameters are correct. Feeding it faster than recommended reduces tool life.

Will a stiffer spring create a larger chamfer?

No. If the Cofa tool is already cutting to the stated edge break size for the tool, a larger chamfer is not possible. A larger tool may be used if there is enough hole clearance.

Can I feed the tool faster by using a stiffer spring?

Yes. Using a stiffer spring will allow some applications to reduce cycle time; however, expect blade life to diminish.