

# Trouble Shooting Solutions

Problem	Reason	Solution
Chamfer is too small	<ul style="list-style-type: none"> <li>Selected blade is too small.</li> </ul> <p><u>SNAP-Gs only</u></p> <ul style="list-style-type: none"> <li>Blade force is too small.</li> <li>Feed rate is too high.</li> </ul>	<ul style="list-style-type: none"> <li>Choose a larger blade (if possible).</li> <li>Increase blade force.</li> <li>Reduce the feed rate.</li> </ul>
No Chamfer at all	<ul style="list-style-type: none"> <li>Tool is incorrectly programmed</li> </ul> <p><u>SNAP-Gs only</u></p> <ul style="list-style-type: none"> <li>Blade force is too small.</li> <li>Blade is dull.</li> <li>Too heavy of a burr.</li> </ul>	<ul style="list-style-type: none"> <li>Check programming depths</li> <li>Increase blade force.</li> <li>Replace the blade.</li> <li>Replace drill tool.</li> </ul>
Chamfer is too large	<ul style="list-style-type: none"> <li>Selected blade is too large.</li> </ul> <p><u>SNAP-Gs only</u></p> <ul style="list-style-type: none"> <li>Feed rate too small.</li> <li>Blade force too high.</li> </ul>	<ul style="list-style-type: none"> <li>Choose a smaller blade.</li> <li>Increase the feed rate.</li> <li>Reduce blade force.</li> </ul>
Chamfer differs from front to back	<p><u>SNAP-Gs only</u></p> <ul style="list-style-type: none"> <li>Feed varies between forward and reverse feed.</li> <li>Variation of burr between front and back.</li> </ul>	<ul style="list-style-type: none"> <li>Select a constant feed rate.</li> <li>Reduce the feed rate when too small, or increase feed rate when too large.</li> </ul>
Poor surface finish	<ul style="list-style-type: none"> <li>Tool or part not held properly.</li> <li>Tool is unstable.</li> <li>Speed rate is too high.</li> </ul>	<ul style="list-style-type: none"> <li>Ensure tool and part are secured.</li> <li>Increase blade force and (<i>SNAP-Gs only</i>) feed rate.</li> <li>Reduce speed.</li> </ul>
Inconsistent Chamfer	<ul style="list-style-type: none"> <li>Varying feed rate.</li> <li>Blade not returning to cutting position properly.</li> <li>Tool is unstable.</li> </ul>	<ul style="list-style-type: none"> <li>Ensure constant feed rate.</li> <li>Increase blade tension by turning set screw clockwise.</li> <li>Increase blade force and (<i>SNAP-Gs only</i>) feed rate.</li> </ul>
Poor blade life (chipping)  (Excessive wear)	<ul style="list-style-type: none"> <li>Workpiece or tool not secured.</li> <li>Insufficient machine stability.</li> <li>Poor cutting conditions.</li> </ul>	<ul style="list-style-type: none"> <li>Ensure tool or part is secured.</li> <li>Recondition or rectify machine faults.</li> <li>Check speed and feed and coolant supply.</li> </ul>