

## Frequently Asked Questions

### The blade swings out automatically after the spindle stops (vertical position), is that normal?

Yes. The BSF is designed so the blade swings out automatically. Nevertheless, for machining the recommended activation speed is compulsory.

### After running the machine, a counterbore is missing.

Check for correct activation speed and tool position. Check to see if the blade moves freely. Dismount the blade and clean the window of the blade housing and the blade itself. Increase activation speed and/or dwell if necessary. Check to make sure through coolant is off. Replace split pin if necessary.

### Does the BSF tool rub the bore surface?

The possibility of rubbing the hole exists due to the single blade design. For critical hole finishes we recommend using a smaller bore diameter (semi-finished bore).

### The housing is fixed with 3 clamping screws. Is there a fixing procedure recommended?

No. The housing can be set in any position. Make sure all screws are secure.

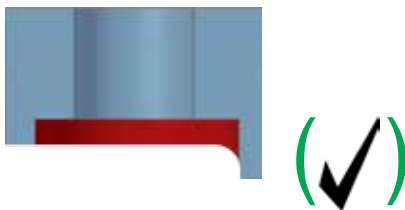
### Are the housings replaceable?

Yes, each tool size has a different diameter and hole off-set size, housings are not interchangeable between series.

### Are sloping surface permitted?

If you are working near a radius area do not use internal coolant until blade is in a full cut. Slow feeds and speeds accordingly.

Caution must be taken on interrupted cuts



Fully interrupted cut (nut, groove, etc.) not possible.



#### Note:

Pay special attention to the recommended bore hole tolerance (+0.1). Bores with a bigger tolerance can cause undesirable results (tool is rubbing in the bore, reduced counterbore diameter etc.) Watch the tool collision diameter (counterbore diameter + 2 mm) when you store the tool in the tool magazine.



Grinding may produce hazardous dust. To avoid adverse effects, use adequate ventilation and read MSDS. Cutting tools may break during use. To avoid injury, use proper safety precautions and protective equipment. Use the machine tool with sufficient rigidity and horsepower. Use a cover on a machine tool and protector, such as glasses, against shattering chips and broken tools due to misuse. Do not use insoluble oil because there is a danger of causing fire.