

PROBLEM	EXPLANATION	SOLUTION
Chamfer too small	<ul style="list-style-type: none"> Selected blade is too small Blade force is too small Feed rate is too high 	<ul style="list-style-type: none"> Choose larger blade (if possible) Increase blade force Reduce feed rate
No chamfer at all	<ul style="list-style-type: none"> Tool is incorrectly programmed Blade force is too small Blade is dull Too heavy of a burr 	<ul style="list-style-type: none"> Check programming depths Increase blade force Replace the blade Replace the drill tool
Chamfer is too large	<ul style="list-style-type: none"> Selected blade is too large Feed rate too small Blade force too high 	<ul style="list-style-type: none"> Choose a smaller blade Increase the feed rate Reduce the blade force Use DF geometry
Chamfer differs from front to back	<ul style="list-style-type: none"> Feed varies between forward and reverse feed Variation of burr between front and back 	<ul style="list-style-type: none"> Select a constant feed rate Reduce the feed rate when too small or increase feed rate when too large Increase blade tension
Poor surface finish	<ul style="list-style-type: none"> Tool or part not held properly Tool is unstable Speed rate is too high 	<ul style="list-style-type: none"> Ensure tool and part are secured Reduce Speed Check workpiece and holder
Inconsistent chamfer	<ul style="list-style-type: none"> Varying feed rate Incorrect programming position Tool is unstable 	<ul style="list-style-type: none"> Ensure constant feed rate Check workpiece and holder Check programming Reduce Speed
Poor blade life (chipping) (excessive wear)	<ul style="list-style-type: none"> Workpiece or tool not secured Insufficient machine stability Poor cutting conditions 	<ul style="list-style-type: none"> Ensure tool or part is secured Recondition or rectify machine faults Check speed and feed and coolant supply



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.