

# Trouble Shooting Solutions

Problem	Probable Cause	Solution
Chamfer is too small.	<ul style="list-style-type: none"> <li>• <math>\text{ØD2}</math> is set too small.</li> </ul>	<ul style="list-style-type: none"> <li>• Turn Chamfer Adjusting set screw counter-clockwise.</li> </ul> <p><i>CAUTION: Do Not Exceed Maximum <math>\text{ØD2}</math></i></p>
Chamfer is too large.	<ul style="list-style-type: none"> <li>• <math>\text{ØD2}</math> is set too large.</li> </ul>	<ul style="list-style-type: none"> <li>• Turn chamfer adjusting '<b>set screw</b>' clockwise.</li> </ul>
Chamfer is inconsistent.	<ul style="list-style-type: none"> <li>• Blade force is too small.</li> <li>• Blades are worn out.</li> <li>• Tool is not centered in hole.</li> </ul>	<ul style="list-style-type: none"> <li>• When machining harder materials such as nickel based alloys, more blade tension may be required. Turn '<b>tension screw</b>' clockwise.</li> <li>• Replace the blade set.</li> <li>• Center tool to hole.</li> </ul>
Poor chamfer surface quality.	<ul style="list-style-type: none"> <li>• Feed rate is too high.</li> <li>• Blades are worn out.</li> </ul>	<ul style="list-style-type: none"> <li>• Reduce the feed rate.</li> <li>• Replace the blade set.</li> </ul>
Secondary burr is formed.	<ul style="list-style-type: none"> <li>• Feed rate is too high.</li> <li>• Blade tension is too high.</li> <li>• Tool is not centered in hole.</li> <li>• Blades are worn out.</li> <li>• Cutting speed is too slow.</li> <li>• Too much runout.</li> </ul>	<ul style="list-style-type: none"> <li>• Reduce the feed rate.</li> <li>• Turn '<b>tension screw</b>' counter-clockwise.</li> <li>• Center tool in the hole.</li> <li>• Replace the blade set.</li> <li>• Increase the cutting speed.</li> <li>• Check holders or use bushings.</li> </ul>
Tool does not cut at all.	<ul style="list-style-type: none"> <li>• <math>\text{ØD2}</math> is too small.</li> </ul>	<ul style="list-style-type: none"> <li>• Check the D2 setting.</li> </ul>
Blades do not fit into tool or are tight and do not slide easily.	<ul style="list-style-type: none"> <li>• Incorrect blade size.</li> <li>• Burr or debris in window or on blades.</li> </ul>	<ul style="list-style-type: none"> <li>• Check part numbers or blade dimensions from catalog.</li> <li>• Ensure window and blades are clean and free of dirt or burrs.</li> </ul>

**Special Application** When machining materials with a hardness greater than 28 Rc, HEULE recommends using a tool with the blade housing sized 0.006" under the hole size. The ordering instructions for these tools can be found in the Appendix A.