

# Troubleshooting

## (Boring system Type M)

	Details of the trouble	Cause	Pulled out of holder. Unable to attach fast to spindle or holder in case of MT shank.
1	Insert cannot be mounted	<p>① Designated insert is not used.</p> <p>② Designated insert mounting bolts are not used.</p>	<p>① Use designated insert.</p> <p>② Use designated mounting bolts.</p>
2	Cannot adjust diameter.	<p>① Adjustment is being made with lock bolt tightened.</p> <p>② Exceeding adjusting range.</p>	<p>① Adjust with lock bolt loosened.</p> <p>② Adjust within the adjusting range.</p>
3	Chattering	<p>① Cutting resistance is too high in comparison with holder's rigidity.</p> <p>② Inappropriate tool tip clamping. •Dust seizing. •Designated insert mounting bolts are not used.</p> <p>③ RPM is too high.</p> <p>④ Abrasion or deposition of insert.</p> <p>⑤ Tip nose R is too large against cutting feed. (Because of large thrust force.)</p>	<p>① Revision of cutting conditions (Decrease cutting resistance.) a : Higher rotation speed or lower feed rate (Approx. 20%) b : Lower cutting depth •Shorter tool projection length</p> <p>② •Cleaning of insert seat. •Use designated mounting bolts.</p> <p>③ Reduce RPM.</p> <p>④ •Replacement of insert. •When adhesion occurs, increase RPM.</p> <p>⑤ Replace tip with one having smaller nose R.</p>
4	Coolant is not supplied.	<p>① Mischoice of retention stud.</p>	<p>① Use designated retention stud for the machine (Coolant specification).</p>
5	Poor machining accuracy.	<p>① Cutting resistance is too high in comparison with holder's rigidity.</p> <p>② Inappropriate tool tip clamping. •Dust seizing. •Designated insert mounting bolts are not used.</p> <p>③ RPM is too high.</p> <p>④ Abrasion or deposition of insert.</p>	<p>① Revision of cutting conditions (Decrease cutting resistance.) a : Higher rotation speed or lower feed rate (Approx. 20%) b : Lower cutting depth •Shorter tool projection length</p> <p>② •Cleaning of insert seat. •Use designated mounting bolts.</p> <p>③ Reduce RPM.</p> <p>④ •Replacement of insert. •When adhesion occurs, increase RPM.</p>