

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	① Designated insert is not used. ② Designated insert mounting bolts are not used.	① Use designated insert. ② Use designated mounting bolts.
2	Cannot adjust diameter.	① Adjustment is being made with lock bolt tightened. ② Exceeding adjusting range.	① Adjust with lock bolt loosened. ② Adjust within the adjusting range.
3	Chattering	① Cutting resistance is too high in comparison with holder's rigidity. ② Inappropriate tool tip clamping. •Dust seizing. •Designated insert mounting bolts are not used. ③ RPM is too high. ④ Abrasion or deposition of insert. ⑤ Tip nose R is too large against cutting feed. (Because of large thrust force.)	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 ② •Cleaning of insert seat. •Use designated mounting bolts. ③ Reduce RPM. ④ •Replacement of insert. •When adhesion occurs, increase RPM. ⑤ Replace tip with one having smaller nose R.
4	Coolant is not supplied.	① Mischoice of retention stud.	① Use designated retention stud for the machine (Coolant specification).
5	Poor machining accuracy.	① Cutting resistance is too high in comparison with holder's rigidity. ② Inappropriate tool tip clamping. •Dust seizing. •Designated insert mounting bolts are not used. ③ RPM is too high. ④ Abrasion or deposition of insert.	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 ② •Cleaning of insert seat. •Use designated mounting bolts. ③ Reduce RPM. ④ •Replacement of insert. •When adhesion occurs, increase RPM.