

Troubleshooting

(BT shank for stub holder)

	Details of the trouble	Cause	Pulled out of holder. Unable to attach fast to spindle or holder in case of MT shank.
1	Cannot insert coolant pin. (In the case of KH/BH)	<p>① Selection of coolant pin size is not correct.</p> <p>② The size selected is of the size that coolant pin cannot be inserted.</p>	<p>① Check size.</p> <p>② Check size; there are sizes that do not allow center-thru coolant supply.</p>
2	Cannot insert stub holder.	<p>① Sizes do not match between BT shank for stub holder and stub holder.</p> <p>② Seized or adhered chip and dust to stub holder shank, BT shank for stub holder I.D..</p> <p>③ Scratch or dent exists in BT shank for stub holder I.D. or stub holder shank.</p> <p>④ In the case of KD/BT series, end face to end face dimension between shank and finger bolt is longer than specified dimension. (When replacing finger collets)</p>	<p>① Check shank size and stub holder size.</p> <p>② Cleaning of stub holder shank, BT shank for stub holder I.D..</p> <p>③ • Replace stub holder or repair BT shank for stub holder. • Touching up of area in question (rubbing off with sand paper #1000 and above) Correction (grinding) by NT TOOL is not possible.</p> <p>④ Make thickness of spacer adjust to specified dimension.</p>
3	Excessive play when mounting into spindle.	<p>① In the case of KH series, spindle mounting is not proper due to functional failure of operating sleeve.</p> <p>② In the cases of KH-A, KH series, rubber damper is deteriorated.</p> <p>③ In the case of KH-E series, steel ball is worn.</p> <p>④ In the case of KD/BT, end face to end face dimension between shank and finger bolt is shorter than specified dimension. (When replacing finger collets)</p> <p>⑤ In the case of KD series, finger collet taper is worn.</p> <p>⑥ In the case of KD series, finger collets are broken.</p>	<p>① When installing, push operating sleeve down to bring it into position for secure mounting. • Cleaning of operating sleeve I.D..</p> <p>② Ask NT for repair.</p> <p>③ Ask NT for repair.</p> <p>④ Make thickness of spacer adjust to specified dimension.</p> <p>⑤ Replacement of finger collet assembly.</p> <p>⑥ Replacement of finger collet assembly.</p>
4	Chattering	<p>① Cutting resistance is too high in comparison with holder's rigidity.</p> <p>② When end-milling with KH-E, cutting pressure is too low against holder rigidity.</p> <p>③</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 Revision of cutting conditions (Increase cutting resistance.) a : Higher feed rate or lower rotation (Approx. 20%) b : Higher cutting depth</p> <p>③ Shorter tool projection length</p> <p>④</p>

		<p>Bending moment is too large.</p> <p>④ Stub holder is mounted improperly with play.</p>	<p>④ See Trouble: "Excessive play when mounting into spindle" and remove play.</p>
5	Poor machining accuracy.	<p>① BT shank for stub holder and stub holder have rattling.</p> <p>② Adhered chip and dust to BT shank for stub holder end surface or stub holder end surface.</p> <p>③ Poor chucking accuracy of collet.</p> <p>④ Dust seizing in collet insertion area.</p> <p>⑤ Scratch or dent in holder I.D..</p> <p>⑥ Scratch or dent on collet I.D. and O.D..</p> <p>⑦ Insufficient chucking length.</p> <p>⑧ Poor accuracy of tool.</p> <p>⑨ Dust seizing in cap nut thread.</p> <p>⑩ Malfunction of rotor ring of cap nut (Rotor ring will not rotate smoothly.)</p> <p>⑪ Mischoice of retention stud.</p> <p>⑫ Expansion of BT shank because of over-tightening retention stud.</p>	<p>① See Trouble: "Excessive play when mounting into spindle" and remove play.</p> <p>② Cleaning of BT shank for stub holder end surface or stub holder end surface.</p> <p>③ Replacement of collets</p> <p>④ Cleaning of collet insertion area.</p> <p>⑤ Replacement of holder.</p> <p>⑥ Replacement of collets.</p> <p>⑦ Keep minimum insertion length. (collet I.D. length must be filled.)</p> <p>⑧ Replacement of tools.</p> <p>⑨ Cleaning of thread part, applying grease.</p> <p>⑩ •Cleaning of cap nut. (so that rotor ring will rotate smoothly.) •Replacement of cap nuts.</p> <p>⑪ Use designated retention stud for the machine.</p> <p>⑫ Keep recommended torque value for tightening retention stud.</p>
6	Holder does not come off from spindle.	<p>① Deposition of fretting, rust and/or adhered coolant residual.</p> <p>② In the case of KH series, operating sleeve failure.</p>	<p>① Cleaning of BT shank for stub holder I.D. and stub holder shank.</p> <p>② Cleaning of operating sleeve I.D..</p>