

Troubleshooting

(Floating holder)

	Details of the trouble	Cause	Pulled out of holder. Unable to attach fast to spindle or holder in case of MT shank.
1	Tool will not fit.	① Wrong choice of sleeve. ② Scratch or dent in sleeve I.D.. ③ Scratch or dent on tool shank.	① Check sleeve I.D. size, tool shank diameter size and size of its square portion. ② Replacement of sleeve. ③ Replacement of tool.
2	Tool turns idly.	① Square portion of tool does not fit into square hole of sleeve. ② Tool without square portion is being used.	① Insert tool until square portion of tool is fitted into square hole of sleeve. ② Replace tool with one with square portion.
3	Poor machining accuracy.	① Excessive cutting edge runout when revolving due to centrifugal force. •RPM is too high. •Too much floating. ② Excessive runout at ream tip. ③ Chattering	① •Reduce RPM. •Adjust amount of floating. To reduce amount of floating, turn screw ring clockwise. ② •Adjust amount of floating. To reduce amount of floating, turn screw ring clockwise. •Enlarge insert guide portion at ream tip. ③ •Replacement of reamer. •Change cutting conditions.
4	The diameter of a hole entrance is created bigger.	① Too much misalignment between ream axis and center of prepared hole. ② Too much floating. ③ In the case of horizontal type, cutter tends to bow under its own weight.	① •Larger chamfering for the entrance of prepared hole. •Enlarge insert guide portion at ream tip. ② Adjust amount of floating. To reduce amount of floating, turn screw ring clockwise. ③ Adjust amount of floating. To reduce amount of floating, turn screw ring clockwise.
5	Reamer is pulled out.	① In the case of FH type, insufficient set screw tightening. ② In the case of GPK type, dust deposited or stuck into, and/or oil adhered to, tool or holder I.D..	① Tighten set screw. ② Cleaning (degreasing) of tool or holder I.D..
6	A holder does not do a float.	① Screw ring tightening too much. ② Breakage of parts inside.	① Adjust amount of floating. Increase amount of floating by turning screw ring counterclockwise. ② Ask NT for repair.