

TECHNICAL - HIGH SPEED STEEL

TROUBLE SHOOTING GUIDE

Problem

Wear on Outer Corners

Solution

- Reduce cutting speed
- Increase feed (IPR)
- Improve coolant flow
- Add corner break
- Review and adjust alignment
- Check for proper drill clearance

Chipping of Cutting Lips

- Reduce lip clearance
- Reduce feed rate

Margin Chipping

- Review and adjust alignment
- Replace oversize bushing

Drill Breakage

- Resharpen or replace drill
- Review and adjust alignment
- Review and adjust setup
- Check point geometry
- Check drill geometry (possible chip congestion)

Drill Splits Up Center

- Check web thickness
- Reduce feed rate
- Check lip clearance

Drill Will Not Enter Workpiece

- Check lip clearance
- Check web thickness (web too heavy)
- Resharpen or replace drill
- Check drill rotation
- Check chisel edge angle (angle too high)

Oversize Hole

- Resharpen or replace drill
- Check drill geometry (possible chip congestion)
- Review and adjust alignment

Rough Hole

- Reduce feed
- Resharpen or replace drill
- Adjust coolant flow
- Check drill geometry (possible chip congestion)
- Check point geometry

Tang Breaks

- Check socket for proper fit
- Check for nicks on shank
- Check for dirty sockets

