для размещения заказа - zakaz@widiahanita.ru

problem	source	solution
heavy wear on the cutting corners	**insufficient coolant**	• Check cooling lubricant. In the case of internal coolant supply, increase coolant pressure. In the case of external coolant supply, adjust positioning of coolant jet. Cool from both sides.
	workpiece movement	• Stabilise workpiece chucking and check stability of machine tool.
	wrong drill	• Check drill type, drilling depth, cooling system, and workpiece material.
	cutting conditions	• Reduce cutting speed; increase feed.
splintering on the chisel edge	**clamping chuck**	• Check clamping accuracy. Use hydraulic clamping chuck or high-precision chucking system.
	cutting conditions	• Decrease feed; increase speed.
built-up edge	**insufficient coolant**	• Check cooling lubricant. In the case of internal coolant supply, increase coolant pressure. In the case of external coolant supply, adjust positioning of coolant jet. Cool from both sides.
	cutting conditions	• Increase speed 20–30%.
splintering on the cutting edges	**clamping chuck**	• Check clamping accuracy and torque transmission. Use hydraulic clamping chuck or high-precision chucking system.
	cutting conditions caused by built-up edge	• Check cutting values, and possibly increase cutting speed.
		• Examine regularly for built-up edge.
thermal checking/comb cracking	**cutting conditions**	• Adapt coolant and cutting conditions to reduce thermal shock.

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