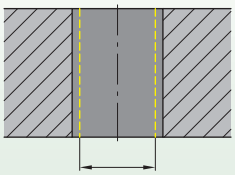
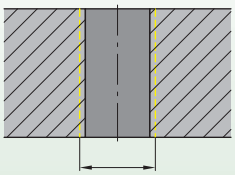
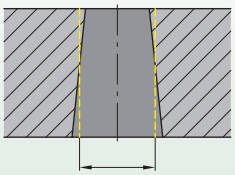
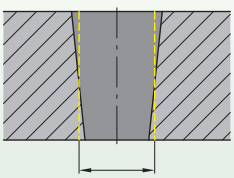
Reamer Troubleshooting

Problem	Cause	Possible Remedy
Hole diameter too large  	1. Reaming tool running out of centre. 2. Concentricity of pilot hole and ream machining unsatisfactory. 3. Built-up edge. 4. Unsuitable cooling lubricant. 5. Reaming tool diameter too large.	• Use equalising adaptor. • Re-align, use floating head. • Change cooling lubricant. • Change cutting speed. • Measure reamers and send for repairs.
Hole diameter too small  	1. Reamer worn. 2. Unsuitable cooling lubricant. 3. Reaming allowance too small.	• Replace and refit tool. • Change cooling lubricant. • Increase reaming allowance.
Conical hole profile wider towards drill runout  	1. Concentricity of pilot hole and reaming unsatisfactory. 2. Positioning accuracy of pilot hole to reaming.	• Re-align, use equalising adaptor. • Correct positioning accuracy.
Conical hole profile wider at drill entry point  	1. Concentricity of pilot hole and reaming unsatisfactory. 2. Reaming tool skim cutting with ledger.	• Re-align, use floating head. • Securely clamp reaming tool axially.

(continued)