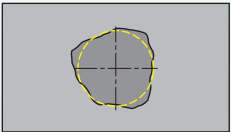
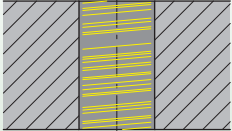


Reamer Troubleshooting *(continued)*

Problem	Cause	Possible Remedy
Conical hole profile wider at drill entry point 	1. Reaming tool running out of centre. 2. Slanted cutting surface/asymmetrical cutting. 3. Workpiece twisted.	• Use equalising adaptor. • Spot face as drilling preparation. • Take the direction of impact into account when clamping the workpiece.
Surface quality does not meet specification 	1. Tool cutters worn. 2. Reaming tool running out of centre. 3. Incorrect technology data (cutting parameters). 4. Inadequate chip evacuation.	• Use equalising adaptor. • Re-align, use floating head. • Change cooling lubricant. • Change cutting speed. • Measure reamers and send for repairs.
Feed grooves 	1. Built-up edge.	• Change cooling lubricant. • Change cutting speed.