

## Basic Troubleshooting Of Tools

Nr.	Fault	Possible cause	Remedy
1	High tool wear	a) Wrong tool material	a) Select tool material to suit workpiece (HSS, stellite, carbide)
2	Nicks in cutting edges	a) Tool edge overheated during resharpening b) Back clearance angle too large	a) Reduce grinding speed and use coolant; select suitable grinding wheel b) Reduce back rake angle
3	Tool rumbling	a) Tool not properly balanced b) Knives not mounted uniformly c) Knives of different size mounted (weight imbalance) d) Cutting chips between tool body and spindle collar e) Deposits on spindle collar	a) Balance tool b) Mount knives uniformly on tool body c) Always use knives of the same size and weight d) Clean all contact surfaces before mounting tools e) Remove deposits using grindstone
4	Tool cannot be pushed on spindle	a) Tool clamping screws not tightened uniformly; bore thus distorted	a) Tighten clamping screws to uniform torque