

Drill Troubleshooting



POSSIBLE SOLUTIONS

PROBLEM		POSSIBLE SOLUTIONS																
		Speed & Feed					Coolant			Setup								
		Reduce Feed or Reduce at Exit	Reduce Feed at Entrance	Consistent Feed rate	Increase Feed	Reduce Speed	Increase Speed	Coolant Mix	Coolant Increase Flow	Coolant Filter	Workpiece Clamp Rigid	Collet Accuracy	Tool Holder fit .0008	Alignment	Peck Drill	Concentricity	Do not Extract Tool During Peck	
Tool Deterioration	Flank Wear	X			X	X		X	X									
	Margin Wear					X				X					X			
	Breakage	X	X	X				X	X	X	X	X	X	X	X			
	Flaking							X		X						X		
	Creater Wear					X												
	Chisel Edge Wear	X			X				X		X							
	Corner Chipping	X			X			X		X						X	X	
	Flute Chipping	X														X		
	Cutting Edge Chipping	X						X	X	X	X	X	X					
	Cutting Edge Wear				X	X												
	Point Center Chipping	X																
	Rake Face	X																
Scoring on Tool Body	X						X			X					X			
Chip Formation	Long Stringy			X	X													
	Varied Chip Form			X														
	Blue/Brown Chips							X										
Tool Life	Tool Life	X			X		X	X	X	X								
Workpiece	Undersized Hole	X	X		X	X	X	X	X									
	Oversized Hole	X			X					X	X	X	X					
	Poor Alignment									X						X		
	Poor Surface Finish	X	X			X	X	X	X							X		
	Heavy Burr Breakout	X					X	X	X	X								
	Retract Marks															X		
	Hole Location		X							X	X	X				X		
	Hole Straightness	X								X	X	X				X		
Process	Deflection		X															
	Point Deflection															X		
	Galling					X												
	Vibration			X							X	X				X		
	Abnormal Noise					X												
	Chip Packing	X	X	X		X		X	X	X								
	No Drill Penetration									X					X			