Troubleshooting Guide

Problem	Possible Cause	Possible Solution
Oversize hole	**a.)** The reamer is running eccentric to the center line of the machine spindle **b.)** Excessive misalignment causing reamer to cut on back taper **c.)** Material build up on cutting edges **d.)** The reamer diameter is too large	**a.)** Use the Modular system with radial adjustment **b.)** Rectify misalignment **c.)** Replace the coolant or change the cutting speed **d.)** Use smaller reamer or regrind existing one
Undersize hole	**a.)** The reamer diameter is too small **b.)** The reamer diameter is worn **c.)** The coolant is not suitable **d.)** Stock allowance too small **e.)** The cutting speed is too low	**a.)** Use larger reamer **b.)** Expand, regrind or replace the reamer **c.)** Replace the coolant **d.)** Increase the stock allowance **e.)** Increase the cutting speed
Tapered hole	**a.)** Excessive misalignment	**a.)** Correct misalignment
Burr at the entry of the hole	**a.)** Excessive misalignment	**a.)** Correct misalignment
The hole is not straight	**a.)** Concentricity and alignment error between the workpiece and the tool **b.)** Asymmetrical cutting or angled surfaces	**a.)** Correct misalignment and use the modular system with radial adjustment **b.)** Create a chamfer on the lead-in
Poor hole finish	**a.)** One cutting edge is chipped **b.)** The lead-in is irregular **c.)** Back taper on the cutting edges too great **d.)** Excessive misalignment **e.)** Cutting data not correct **f.)** Poor chip evacuation	**a.)** Regrind the reamer **b.)** Regrind the reamer **c.)** Regrind the reamer **d.)** Correct misalignment or use the modular system with radial adjustment **e.)** Verify cutting data **f.)** Verify coolant volume and pressure or use through tool coolant
The reamer creates excessive torque loading	**a.)** Back taper on the cutting edges too small **b.)** The radially ground land is too wide **c.)** The coolant is not suitable	**a.)** Regrind the reamer **b.)** Regrind the reamer **c.)** Replace the coolant