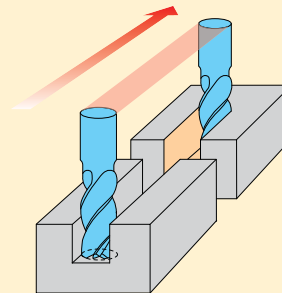


Troubleshooting

9. Loss in tool life with interrupted cutting

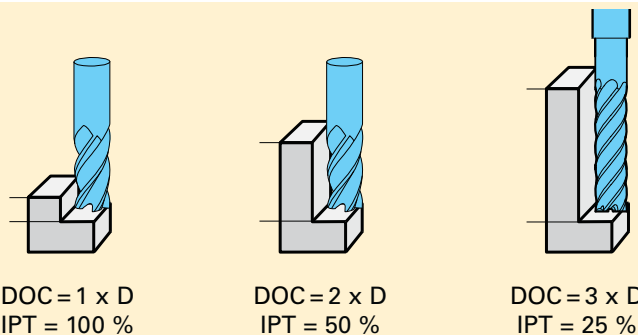
Significant loss in tool life through interrupted cutting (especially with milling angles of 90°)

- modify cutting distribution
- reduce feed rate for entry and exit
- reduce approach angle



10. Feed rate adjustment: Modifying the cutting depth

- when modifying the cutting depth DOC, the feed rate must be reduced in accordance with the illustration on the right
- cutting speed or revolutions remain unchanged up to cutting depths of 3 x D, must only be adapted over 3 x D



11. Plunging strategies

for drilling:

- reduce feed rate IPT
- additional pecking for drilling depths > 0.5 x D or transition to radial machining

Attention: Danger of breakage through abrupt load increase!

Ramping up to 15° (preferred):

- reduction in feed rate IPT not required

Ramping between 15° and 30°:

- reduce feed rate IPT in accordance with the illustration on the right

Helical plunging:

- for helical plunging on a milling cycle, we recommend a feed of 0.1 to 0.2 per cycle (0.100" - 0.200")
- reduce feed rate IPT in accordance with the illustration on the right
- select preferred hole diameter 1.8 x D

