

Application Guide Trouble Shooter - Reamers



Code		Problem				
1		Breakage				
2		Excessive wear				
3		Chattering				
4		Poor surface Finish				
1	2	3	4	Possible reason	Solution	
●		●		Dirt or burrs in spindle or socket in which reamer is held	clean spindle	
●	●			Misalignment of two or more parts of the set-up. This condition can cause a bell-mouthed hole	align holes or use bridge style reamer	
●	●	●	●	Too fast or too slow speeds.	adjust	
●	●	●	●	Too much or too little feed.	adjust	
	●			Wrong type of coolant.	refer to lubricant supplier's literature	
●				No lubricant between guide bushing and reamer.	apply	
	●		●	Lack of lubricant.	increase	
●				Bottoming in blind holes.	reduce depth travel of reamer	
		●		Lack of sufficient stock to ream.	drill smaller hole	
●	●		●	Too much stock to ream.	drill larger hole	
●		●		Entering work too fast.	slow down the approach feed, until all cutting edges are located in the hole	
●	●	●	●	Badly drilled holes – too rough, tapered or bell-mouthed. Bell-mouthed holes may cause the reamer to wedge rather than cut.	replace drill	
●		●		Oversize or undersize bushings.	Use suitable bush	
●		●		Lack of rigidity in machine or work holder.	improve rigidity	
●	●		●	Improperly designed reamer for the job.		