

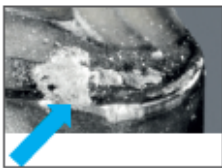

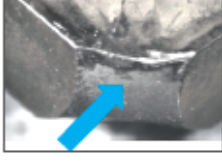

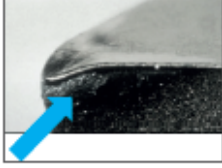


Fault	Description	Solution
 <p>Rapid flank wear</p>	<ul style="list-style-type: none"> <li>• Inappropriate feed rate</li> <li>• Cutting speed too high</li> </ul>	<ul style="list-style-type: none"> <li>• Adjust feed rate according to cutting depth and width</li> <li>• Reduce cutting speed</li> </ul>
 <p>Thermal cracking</p>	<ul style="list-style-type: none"> <li>• Insufficient coolant</li> <li>• Cutting speed too high</li> </ul>	<ul style="list-style-type: none"> <li>• Increase coolant flow, or use dry cutting data (for milling)</li> <li>• Reduce cutting speed</li> </ul>
 <p>Built-up edge</p>	<ul style="list-style-type: none"> <li>• Cutting speed too low</li> <li>• Insufficient coolant</li> <li>• Rake angle too low</li> </ul>	<ul style="list-style-type: none"> <li>• Increase cutting speed</li> <li>• Increase coolant flow</li> <li>• Use insert with higher rake angle</li> </ul>
 <p>Notch wear</p>	<ul style="list-style-type: none"> <li>• Scaling or work hardening of workpiece surface area</li> <li>• Burrs in workpiece</li> </ul>	<ul style="list-style-type: none"> <li>• Vary cutting feed and depth of cut</li> <li>• Change tool direction</li> </ul>
 <p>Fracture/Chipping</p>	<ul style="list-style-type: none"> <li>• Feed rate too high</li> <li>• Cutting speed too low</li> <li>• Toolholder vibration</li> <li>• Wrong insert shape or corner radius</li> </ul>	<ul style="list-style-type: none"> <li>• Reduce feed rate</li> <li>• Increase cutting speed</li> <li>• Reduce tool overhang</li> <li>• Choose bigger insert or corner radius</li> </ul>
 <p>Cratering</p>	<ul style="list-style-type: none"> <li>• Insufficient coolant supply</li> <li>• Cutting speed and feed rate too high</li> </ul>	<ul style="list-style-type: none"> <li>• Increase coolant flow or concentration</li> <li>• Reduce cutting speed and feed rate</li> </ul>
 <p>Plastic deformation</p>	<ul style="list-style-type: none"> <li>• Cutting speed too high</li> <li>• Insufficient coolant supply</li> <li>• High stress applied to cutting edge</li> </ul>	<ul style="list-style-type: none"> <li>• Reduce cutting speed</li> <li>• Increase cutting flow</li> <li>• Choose bigger insert or corner radius</li> </ul>