

DEFA FAQ

Question	Causes	Remedy
Chamfer diameter too small	<ul style="list-style-type: none"> • D2 set too small 	<ul style="list-style-type: none"> • Turn the adjusting screw anti-clockwise (see Adjusting the chamfer diameter on page 108)
Chamfer diameter too large	<ul style="list-style-type: none"> • D2 set too large 	<ul style="list-style-type: none"> • Turn the adjusting screw clockwise (see Adjusting the chamfer diameter on page 108)
Chamfer not even	<ul style="list-style-type: none"> • Blade force too low 	<ul style="list-style-type: none"> • Turn the clamping screw clockwise (see Setting the blade force page 109)
	<ul style="list-style-type: none"> • Tool not centred in the bore 	<ul style="list-style-type: none"> • Align tool
Chamfered surface poor	<ul style="list-style-type: none"> • Working feed rate too high 	<ul style="list-style-type: none"> • Reduce working feed rate
	<ul style="list-style-type: none"> • Blade wear 	<ul style="list-style-type: none"> • Resharpener, TiN coating or new blades
Secondary burr	<ul style="list-style-type: none"> • Working feed rate too high 	<ul style="list-style-type: none"> • Reduce working feed rate
	<ul style="list-style-type: none"> • Blade force too strong 	<ul style="list-style-type: none"> • Turn the clamping screw anti-clockwise (see Setting the blade force page 109)
	<ul style="list-style-type: none"> • Tool not centred in the bore 	<ul style="list-style-type: none"> • Align tool
	<ul style="list-style-type: none"> • Blade wear 	<ul style="list-style-type: none"> • Resharpener, TiN coating or new blades
	<ul style="list-style-type: none"> • Cutting speed too low 	<ul style="list-style-type: none"> • Increase cutting speed