

# SNAP FAQ

SNAP

Question	Causes	Remedy
Burr is not cut away cleanly or chamfer too small	<ul style="list-style-type: none"> <li>• Blade selected too small</li> <li>• Working feed rate too high</li> </ul>	<ul style="list-style-type: none"> <li>• Select blade for larger chamfer</li> <li>• Reduce working feed rate</li> </ul>
No chamfer	<ul style="list-style-type: none"> <li>• Blade force too low</li> </ul>	<ul style="list-style-type: none"> <li>• Turn the set screw clockwise to increase the blade pressure (only possible with SNAP blades with GS geometry)</li> </ul>
	<ul style="list-style-type: none"> <li>• Blade worn, worn out</li> </ul>	<ul style="list-style-type: none"> <li>• Insert new blade</li> </ul>
	<ul style="list-style-type: none"> <li>• Excessive burr formation</li> </ul>	<ul style="list-style-type: none"> <li>• Replace or sharpen the drill tool</li> </ul>
	<ul style="list-style-type: none"> <li>• Blade jams, no longer extends out of blade housing</li> </ul>	<ul style="list-style-type: none"> <li>• Cast materials should always be processed with coolant. This removes the dust from the blade window.</li> </ul>
Forward and backward chamfer size not the same	<ul style="list-style-type: none"> <li>• Working feed rate forwards and backwards different</li> </ul>	<ul style="list-style-type: none"> <li>• Select the same working feed rate forwards and backwards if possible (only for blades with GS geometry)</li> </ul>
	<ul style="list-style-type: none"> <li>• Different burr formation front and back</li> </ul>	<ul style="list-style-type: none"> <li>• On the side with the chamfer that is too small: reduce working feed rate, only possible for blades with GS geometry. On the side with the chamfer that is too large: increase working feed rate, only possible for blades with GS geometry</li> </ul>
Chamfer with chatter marks	<ul style="list-style-type: none"> <li>• Poorly set workpiece or tool</li> </ul>	<ul style="list-style-type: none"> <li>• Ensure that workpiece and tool are firmly clamped</li> </ul>
	<ul style="list-style-type: none"> <li>• Tool in unstable condition</li> </ul>	<ul style="list-style-type: none"> <li>• Increase tool feed rate, and possibly blade force</li> </ul>
	<ul style="list-style-type: none"> <li>• Cutting speed too high</li> </ul>	<ul style="list-style-type: none"> <li>• Reduce cutting speed</li> </ul>
Inconsistent chamfer size	<ul style="list-style-type: none"> <li>• Different working feed rate</li> </ul>	<ul style="list-style-type: none"> <li>• Select consistent working feed rate</li> </ul>
	<ul style="list-style-type: none"> <li>• Blade force so weak that the blade does not return to the neutral position every time</li> </ul>	<ul style="list-style-type: none"> <li>• Turn the set screw clockwise to increase the blade pressure</li> </ul>
	<ul style="list-style-type: none"> <li>• Tool in unstable condition</li> </ul>	<ul style="list-style-type: none"> <li>• Increase blade force and working feed rate</li> </ul>
Poor service life	<ul style="list-style-type: none"> <li>• Poorly clamped workpiece or tool (vibration)</li> </ul>	<ul style="list-style-type: none"> <li>• Ensure that workpiece and tool are more firmly clamped</li> </ul>
	<ul style="list-style-type: none"> <li>• Inadequate machine stability (spindle play, etc.)</li> </ul>	<ul style="list-style-type: none"> <li>• Improve machine stability or guide with special tool in the bore</li> </ul>
	<ul style="list-style-type: none"> <li>• Incorrect blade coating</li> </ul>	<ul style="list-style-type: none"> <li>• Select another coating</li> </ul>