

DL2 FAQ

Question	Causes	Remedy
Burr is not cut away cleanly or deburr too small	<ul style="list-style-type: none"> • Blade selected too small • Working feed rate too high • Burr too large 	<ul style="list-style-type: none"> • Select blade for larger deburr \emptyset • Reduce working feed rate • Minimise burr size from drilling
No deburring	<ul style="list-style-type: none"> • Blade worn, worn out 	<ul style="list-style-type: none"> • Replace blade
	<ul style="list-style-type: none"> • Excessive burr formation 	<ul style="list-style-type: none"> • Replace or sharpen the drill
	<ul style="list-style-type: none"> • Wrong direction of rotation 	<ul style="list-style-type: none"> • DL2 runs anti-clockwise (M4)
Forward and backward deburring size not the same	<ul style="list-style-type: none"> • Working feed rate forwards and backwards different 	<ul style="list-style-type: none"> • Select the same working feed rate forwards and backwards if possible
	<ul style="list-style-type: none"> • Different burr formations front and back 	<ul style="list-style-type: none"> • On the side with under-deburring: reduce working feed rate. On the side with over-deburring: increase working feed rate
Deburring with chatter marks	<ul style="list-style-type: none"> • Poorly set workpiece or tool 	<ul style="list-style-type: none"> • Ensure that workpiece and tool are firmly clamped
	<ul style="list-style-type: none"> • Tool in unstable condition 	<ul style="list-style-type: none"> • Increase tool feed rate
	<ul style="list-style-type: none"> • Cutting speed too high 	<ul style="list-style-type: none"> • Reduce cutting speed
Inconsistent deburring size	<ul style="list-style-type: none"> • Different working feed rate 	<ul style="list-style-type: none"> • Select consistent working feed rate
	<ul style="list-style-type: none"> • Tool in unstable condition 	<ul style="list-style-type: none"> • Increase working feed rate
Poor service life	<ul style="list-style-type: none"> • Poorly clamped workpiece or tool (vibration) 	<ul style="list-style-type: none"> • Ensure that workpiece and tool are rigidly clamped
	<ul style="list-style-type: none"> • Insufficient machine stability (spindle play, etc.) 	<ul style="list-style-type: none"> • Improve machine stability or guide with special tool in the bore
	<ul style="list-style-type: none"> • Incorrect blade coating 	<ul style="list-style-type: none"> • Select correct coating