

DEFA FAQ

Question	Causes	Remedy
Chamfer diameter too small	• D2 set too small	• Turn the adjusting screw anti-clockwise (see Adjusting the chamfer diameter on page 108)
Chamfer diameter too large	• D2 set too large	• Turn the adjusting screw clockwise (see Adjusting the chamfer diameter on page 108)
Chamfer not even	• Blade force too low	• Turn the clamping screw clockwise (see Setting the blade force page 109)
	• Tool not centred in the bore	• Align tool
Chamfered surface poor	• Working feed rate too high	• Reduce working feed rate
	• Blade wear	• Resharpening, TiN coating or new blades
Secondary burr	• Working feed rate too high	• Reduce working feed rate
	• Blade force too strong	• Turn the clamping screw anti-clockwise (see Setting the blade force page 109)
	• Tool not centred in the bore	• Align tool
	• Blade wear	• Resharpening, TiN coating or new blades
	• Cutting speed too low	• Increase cutting speed