

SNAP FAQ

Question	Causes	Remedy
Burr is not cut away cleanly or chamfer too small	• Blade selected too small • Working feed rate too high	• Select blade for larger chamfer • Reduce working feed rate
No chamfer	• Blade force too low	• Turn the set screw clockwise to increase the blade pressure (only possible with SNAP blades with GS geometry)
	• Blade worn, worn out	• Insert new blade
	• Excessive burr formation	• Replace or sharpen the drill tool
	• Blade jams, no longer extends out of blade housing	• Cast materials should always be processed with coolant. This removes the dust from the blade window.
Forward and backward chamfer size not the same	• Working feed rate forwards and backwards different	• Select the same working feed rate forwards and backwards if possible (only for blades with GS geometry)
	• Different burr formation front and back	• 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
Chamfer with chatter marks	• Poorly set workpiece or tool	• Ensure that workpiece and tool are firmly clamped
	• Tool in unstable condition	• Increase tool feed rate, and possibly blade force
	• Cutting speed too high	• Reduce cutting speed
Inconsistent chamfer size	• Different working feed rate	• Select consistent working feed rate
	• Blade force so weak that the blade does not return to the neutral position every time	• Turn the set screw clockwise to increase the blade pressure
	• Tool in unstable condition	• Increase blade force and working feed rate
Poor service life	• Poorly clamped workpiece or tool (vibration)	• Ensure that workpiece and tool are more firmly clamped
	• Inadequate machine stability (spindle play, etc.)	• Improve machine stability or guide with special tool in the bore
	• Incorrect blade coating	• Select another coating