DL2 FAQ

Question	Causes	Remedy
Burr is not cut away cleanly or deburr too small	• Blade selected too small • Working feed rate too high • Burr too large	• Select blade for larger deburr Ø • Reduce working feed rate • Minimise burr size from drilling
No deburring	• Blade worn, worn out	• Replace blade
	• Excessive burr formation	• Replace or resharpen the drill
	• Wrong direction of rotation	• DL2 runs anti-clockwise (M4)
Forward and backward deburring size not the same	• Working feed rate forwards and backwards different	• Select the same working feed rate forwards and backwards if possible
	• Different burr formations front and back	• On the side with under-deburring: reduce working feed rate. On the side with over-deburring: increase working feed rate
Deburring with chatter marks	• Poorly set workpiece or tool	• Ensure that workpiece and tool are firmly clamped
	• Tool in unstable condition	• Increase tool feed rate
	• Cutting speed too high	• Reduce cutting speed
Inconsistent deburring size	• Different working feed rate	• Select consistent working feed rate
	• Tool in unstable condition	• Increase working feed rate
Poor service life	• Poorly clamped workpiece or tool (vibration)	• Ensure that workpiece and tool are rigidly clamped
	• Insufficient machine stability (spindle play, etc.)	• Improve machine stability or guide with special tool in the bore
	• Incorrect blade coating	• Select correct coating