

Question	Causes	Remedy
Blade folds out automatically when the spindle stops (vertical machining).	<ul style="list-style-type: none"> Gravity. The blade is not fixed in the blade housing without the coolant pressure or compressed air switched on, or the activation ring on the BSF Manual set to lock. 	<ul style="list-style-type: none"> If the blade is to remain securely in the blade housing, switch on internal coolant, compressed air or actuate the activation ring on the BSF-M. Attention: To bring the blade safely into the working position (unfolding), the activation speed of the spindle must be correctly programmed.
No counterbore after machining	<ul style="list-style-type: none"> Blade does not fold out 	<ul style="list-style-type: none"> Check whether the spindle activation speed has been selected correctly. Check whether the blade is jammed in the blade window. If so, remove the blade and clean the blade and blade window.
Blade does not fold in reliably	<ul style="list-style-type: none"> Internal coolant pressure too low 	<ul style="list-style-type: none"> Minimum pressure is 20 bar. If this pressure cannot be reached, switch to BSF Air or BSF Manual if possible.
	<ul style="list-style-type: none"> Air pressure on the machine spindle too low 	<ul style="list-style-type: none"> Minimum air pressure is 5 bar. Check the available air pressure in the spindle. HEULE can provide a measuring device for this purpose if required.
Is coolant filtration necessary?	<ul style="list-style-type: none"> Yes. Excessively contaminated cooling medium impairs the activation operation of the blade. 	<ul style="list-style-type: none"> The cooling medium must be cleaned with a minimum filter size of 25 µm.
Can machining be done with internal coolant or compressed air?	<ul style="list-style-type: none"> Yes. This helps to remove chips and cool the tool/blade. 	<ul style="list-style-type: none"> Attention: The blade must be fully in the cut before the internal coolant is switched on.
I have a bore with H7 tolerance. Will the BSF damage the finished bore?	<ul style="list-style-type: none"> It is possible that the BSF will leave marks on the finished bore. 	<ul style="list-style-type: none"> We recommend using the BSF tool on a pre-machining diameter.
Does it matter from which side the split pin is inserted when changing the blade?	<ul style="list-style-type: none"> No 	
Is it possible to hold the BSF tool in a shrink-fit chuck?	<ul style="list-style-type: none"> No. The shank is made of tool steel and has a different thermal expansion compared to carbide tools. 	
The blade housing is assembled onto the shank with 3 clamping screws. Is there a recommended location or position?	<ul style="list-style-type: none"> No, the tool works in any position. 	