VEX FAQ

Question	Causes	Remedy
Built-up edge	• Cutting speed too low • Insufficient cooling / lubrication • Incorrect coating for the material	• Increase cutting speed • Increase coolant pressure • Select another coating
Chip jam	• Working feed rate too high for chip removal • Drill insert too short for bore depth • Insufficient cooling	• Reduce working feed rate • With VEX-S, use a longer drill insert or improve drilling cycle • Increase coolant pressure
Large burr formation at the exit of the bore	• Cutting values too high • Insufficient cooling • Drill insert/head worn	• Reduce cutting speed • Increase coolant pressure • Replace drill insert/head
Fluctuating accuracy	• Working feed rate too high • Insufficient cooling • Spindle/setup not stable	• Reduce working feed rate • Increase coolant pressure • Check radial run-out • Check spindle and setup stability
Poor surface quality	• Incorrect cutting values • Insufficient cooling • Spindle/setup not stable • Drill insert/head worn	• Increase or reduce working feed rate and cutting speed • Increase coolant pressure • Check radial run-out • Check spindle and setup stability • Replace drill insert or head • Improve drilling process
Vibration / chatter	• Incorrect cutting values • Insufficient cooling • Spindle/setup not stable	• Increase or reduce the cutting speed • Increase or reduce the working feed rate • Increase coolant pressure • Check radial run-out • Check spindle and setup stability
Wear on cutting edge	• Incorrect cutting values • Insufficient cooling • Spindle/setup not stable	• Increase cutting speed • Reduce working feed rate • Increase coolant pressure • Check spindle and setup stability
Wear on cross-cutting edge	• Working feed rate too high • Insufficient cooling • Spindle/setup not stable	• Reduce working feed rate • Increase coolant pressure • Check spindle and setup stability

VEX FAQ – continued

Question	Causes	Remedy
Wear on guiding section	• incorrect cutting values • Insufficient cooling • Spindle/setup not stable	• Reduce cutting speed • Reduce working feed rate • Increase coolant pressure • Check radial run-out • Check spindle and setup stability
Break of cutting edge	• incorrect cutting values • Insufficient cooling • Spindle/setup not stable	• Increase cutting speed • Increase coolant pressure • Check spindle and setup stability
Break of top of drill insert	• Working feed rate too high • Insufficient cooling • Spindle/setup not stable	• Reduce working feed rate • Increase coolant pressure • Check spindle and setup stability
No chamfer or chamfer not consistent	• see FAQ for SNAP on page 100	

VEX-P spare parts – Tool body

Item	Description	Part no.
3	Tool body bore Ø range Ø 11.00–11.49 mm	GH-Q-G-4250
	Ø 11.50–11.99 mm	GH-Q-G-4251
	Ø 12.00–12.49 mm	GH-Q-G-4252
	Ø 12.50–12.99 mm	GH-Q-G-4253
	Ø 13.00–13.49 mm	GH-Q-G-4254
	Ø 13.50–13.99 mm	GH-Q-G-4255
	Ø 14.00–14.49 mm	GH-Q-G-4256
	Ø 14.50–14.99 mm	GH-Q-G-4257
	Ø 15.00–15.49 mm	GH-Q-G-4258
	Ø 15.50–15.99 mm	GH-Q-G-4259
	Ø 16.00–16.49 mm	GH-Q-G-4260
	Ø 16.50–17.00 mm	GH-Q-G-4261