

Question	Causes	Remedy
Highly irregular deburring	• Cutting speed too high	• Reduce cutting speed considerably, leave working feed unchanged
	• Ratio of cross bore to bore diameter (d:D) is greater than 0.5	• Ratio is too high for the tool, solution with COFA not possible. Alternatively, check machining with COFA-X
	• Selected tool too large	• Use a tool with a smaller diameter (e.g. instead of C12/diameter 15.0 >C12/diameter 14.5)
Vibration, chatter marks	• Cutting speed too high	• Reduce cutting speed
	• Working feed too low	• Increase working feed
	• Spring too soft	• Install harder spring (spring index), existing tool can be converted
Deburr too large	• Tool/blade used is too large	• Use a tool with a smaller diameter (e.g. instead of C12/diameter 15.0 >C12/diameter 14.5) or a smaller blade if applicable
Deburr incomplete	• Spring too soft	• Install harder spring (spring index), existing tool can be converted
	• Clearance angle on blade too small	• Alternative blade
Secondary burr formation	• Spring too hard	• Install softer spring
No deburring	• Tool dirty, blade cannot move freely	• Clean tool
	• Blade worn out	• Replace blade
No deburring on the back of the bore	• Dimension C too short for the blade to fold out due to burr height	• Increase dimension C by burr height
	• Switchover time of the machine from rapid traverse forwards to rapid traverse backwards too fast or distance too short for the blade to fold out	• Provide a short dwell time or increase dimension C if space is available