T-A® INSERT WEAR PATTERNS

A Quick Reference Guide

Accelerated Corner Wear



- Worn or misaligned spindle / poor centering condition.
- Material harder than expected.
- Running tool beyond recommended speeds.

Cored/Existing Hole



- Interrupted cuts / poor material structure / nonperpendicular exit or entry.
- Insert being used to core/open up an existing hole.

Step Burned on Insert



- Material harder than expected.
- Running tool beyond recommended speeds.
- Flood coolant, low coolant pressure, or low coolant volume.

Premature Insert Chipping



- Poor workpiece fixturing.
- Interrupted cuts / poor material structure / nonperpendicular exit or entry.
- Insert substrate too hard for application; choose tougher insert.

Damaged or Broken Tools



- Poor workpiece fixturing.
- Poor material structure.
- Machine issues.
- Starting on an inclined surface.
- Poor chip control.
- Insert substrate too hard for application; choose tougher insert.

Excessive Margin Wear



- Incorrect coolant and material combination.
- Starting on an inclined surface.
- Worn or misaligned spindle / poor centering condition.
- Interrupted cuts / poor material structure / nonperpendicular exit or entry.

Chipping of Point



- Spot drill point angle not matching included angle of drilling insert.
- Worn or misaligned spindle / poor centering condition.
- Starting on an inclined surface.

Built-up Edge



- Flood coolant, low coolant pressure, or low coolant volume.
- Material harder than expected.
- Running tool beyond recommended speeds.
- Poor lubricity in coolant.

For additional assistance troubleshooting insert wear patterns, visit ***www.alliedmachine.com/fse*** to contact your local FSE or email our application engineering department at ***appeng@alliedmachine.com***.

ALLIED MACHINE & ENGINEERING | THE HOLEMAKING EXPERTS

www.**alliedmachine**.com | **330.343.4283**