GEN3SYS® XT PRO WEAR PATTERNS

A Quick Reference Guide

Accelerated Corner Wear



- Worn or misaligned spindle.
- Material harder than expected.
- Running tool beyond recommended speeds.

Premature Insert Chipping



- Poor workpiece fixturing.
- Interrupted cuts / poor material structure / nonperpendicular exit or entry.
- Spot drilled holes with included angle less than 140° or cored holes.

Damaged or Broken Tools



- Worn or misaligned spindle.
- Poor workpiece fixturing.
- Flood coolant, low coolant pressure, or low coolant volume.
- Interrupted cuts / poor material structure / nonperpendicular exit or entry.
- Material harder than expected.
- Running tool beyond recommended speeds.
- Poor chip control.

Excessive Margin Wear



- Worn or misaligned spindle.
- Poor workpiece fixturing.
- Interrupted cuts / nonperpendicular exit or entry.

Chipping of Point



- Interrupted cuts / nonperpendicular exit or entry.
- Worn or misaligned spindle / poor centering condition.
- Material harder than expected.

Built-up Edge



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

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***.

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