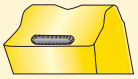
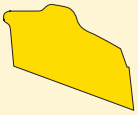
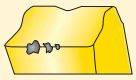
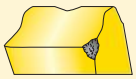
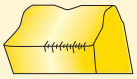
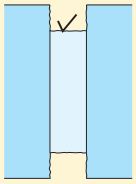
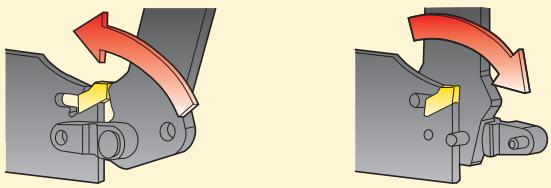
Troubleshooting

Flank wear	• Reduce the cutting speed. • Select a more wear resistant grade.
Crater wear 	• Use a coolant. • Select a more wear resistant grade. • Reduce the cutting speed. • Reduce the feed rate.
Plastic deformation 	• Use a coolant. • Select a more wear resistant grade. • Reduce the cutting speed. • Reduce the feed rate.
Edge chipping 	• Select a tougher grade. • Check the workpiece mounting. • Check the cutting speed.

Insert fracture 	• Reduce the feed rate. • Select a tougher grade. • Select a stronger chipbreaker.
Comb cracks 	• Reduce the cutting speed. • Reduce the feed rate. • Ensure that the coolant flow is adequate and constant. If not, shut off the coolant.
Built-up edge	• Increase the cutting speed. • Increase the feed rate. • Do not use coolant.
Poor finish 	• Reduce the feed rate. • Increase the cutting speed. • Use a coolant. • Improve the stability. • Check the alignment of the tool.

Change of insert

Inserts are changed with the aid of key 150.10A-150.