Troubleshooting

（Drilling chuck）

	Details of the trouble	Cause	Pulled out of holder. Unable to attach fast to spindle or holder in case of MT shank.
1	Unable to mount drilling chuck on spindle or there is rattling when installing spindle.	① Spindle dimension is different from standard dimension. ② There is a gap on end surface even with special fastening screw.	① Check spindle dimension. ② ・ASBA, ASB and ASBV have six fastening screw holes at 0.1mm intervals. Choose the best hole to prevent drilling chuck from rattling in spindle direction. ・ASBAJ has eccentric lock washer. Eliminate rattling by installing spindle according to user's manual. ・Check spindle's screw hole location.
2	Unable to mount or lock holder.	① Drilling chuck and SSMA nut are different in size. ② Tr nut is used. ③ Abrasion of internal parts.	① Check the size of drilling chuck and SSMA nut. ② Use of SSMA nut. ③ Ask NT for repair.
3	Unable to remove drilling chuck.	① Special fastening screw is not removed.	① Removal of special fastening screw.
4	Drilling chuck is pulled out.	① Special fastening screw is not mounted. ② Special fastening screw is not used.	① Use of special fastening screw. ② Use of special fastening screw when installing drilling chuck.
5	Unable to remove adjustable adapter and straight drill chuck from drilling chuck.	① Poor operation sleeve movement caused by seized or adhered chip and dust as well as adhered coolant.	① Cleaning of drilling chuck.
6	Poor accuracy.	① Spindle and drilling chuck have rattling. ② Adhered chip and dust to spindle end surface. ③ Adhered chip and dust to drilling chuck end surface or SSMA nut end surface. ④ Loosened SSMA nut's fastening screw. ⑤ Special fastening screw is not used.	① ・ASBA, ASB and ASBV have six fastening screw holes at 0.1mm intervals. Choose the best hole to prevent drilling chuck from rattling in spindle direction. ・ASBAJ has eccentric lock washer. Eliminate rattling by installing spindle according to user's manual. ・Check spindle's screw hole location. ② Cleaning of spindle. ③ Cleaning of drilling chuck end surface or SSMA nut end surface. ④ Tightening of fastening screw. ⑤ Use of special fastening screw when installing drilling chuck.
7	Poor operation sleeve movement.	① Poor operation sleeve movement caused by seized or adhered chip and dust as well as adhered coolant.	① Cleaning of drilling chuck.

8	Fastening screw is pulled out.	① Loosening of fastening screw caused by machining vibration. ② Operation sleeve hole and screw hole for fastening screw on spindle are in alignment with each other. ③ Special fastening screw is not used. ④ Used for re-tightening of special fastening screw. ⑤ Adhered oil to screw hole on spindle.	① ・Revision of cutting conditions (Decrease cutting resistance.) a : Higher rotation speed or lower feed rate (Approx. 20%) b : Lower cutting depth ・Shorter tool projection length ・Shorter chuck length ② After fixing with special fastening screw, turn operation sleeve by some 90° to prevent both chip from clogging and fastening screw from dropping. ③ Use of special fastening screw when installing drilling chuck. ④ Replacement with new special fastening screw due to deteriorated adhesive agent's effect. ⑤ Cleaning and degreasing of spindle screw hole to prevent adhesive agent's effect from deteriorating.