Troubleshooting

（Jacobs taper arbor）

	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 install or fasten tool.	① Seized or adhered chip and dust to arbor and tool attachment part. ② Adhered oil to arbor and tool attachment part. ③ Wrong taper size. ④ Scratch and dent in arbor or tool attachment part.	① Cleaning of arbor and tool attachment part. ② Cleaning (degreasing) of arbor and tool attachment part. ③ Check taper size. ④ ・Replacement of arbor or tool ・Touching up of area in question（rubbing off with sand paper #1000 and above） Correction (grinding) by NT TOOL is not possible.
2	Tool is pulled out during use.	① Seized or adhered chip and dust to arbor and tool attachment part. ② Adhered oil to arbor and tool attachment part. ③ Machining vibration caused by cutting resistance is large.	① Cleaning of arbor and tool attachment part. ② Cleaning (degreasing) of arbor and tool attachment part. ③ Revision of cutting conditions（Decrease cutting resistance.） a. Higher rotation or lower feed rate （Approx. 20%）
3	Machining accuracy is not stable.	① Cutting resistance is too large. ② Mischoice of retention stud ③ Expansion of BT shank because of over-tightening retention stud. ④ Low taper contact of interface ・ Poor taper contact from expanded spindle nose ・ Dust, scratch or dent in the taper part or end face (in the case of two-face contact)	① Revision of cutting conditions（Decrease cutting resistance.） a. Higher rotation or lower feed rate （Approx. 20%） ② Use designated retention stud for the machine. ③ Keep recommended torque value for tightening retention stud. ④ ・Regrinding and correction of machine spindle （Contact the manufacturer.） ・Cleaning of taper and end face (in the case of two-face contact) , touching up of scratch or dent.
4	Poor holding accuracy	① Seized or adhered chip and dust to arbor and tool attachment part. ② Scratch and dent in arbor or tool attachment part. ③ Poor accuracy of tool	① Cleaning of arbor and tool attachment part. ② ・Replacement of arbor or tool ・Touching up of area in question（rubbing off with sand paper #1000 and above） Correction (grinding) by NT TOOL is not possible. ③ Replacement of tools.