Troubleshooting

（Morse taper holder）

	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 holder ID and tool shank part. ② Adhered oil to holder ID and tool shank part. ③ Wrong Morse taper size. ④ Scratch or dent exists in holder ID or tool shank. ⑤ Poor taper contact in tool shank part.	① Cleaning of holder ID and tool shank ② Cleaning (degreasing) of holder ID and tool shank part. ③ Check Morse taper size. ④ ・Replacement of holder or tool ・Touching up of area in question（rubbing off with sand paper #1000 and above） Correction (grinding) by NT TOOL is not possible. ⑤ Replacement of tools.
2	Tool will not fit.	① Tongue type Morse taper shank tool is used for MTB type.	① Use MTA type for tongue type Morse taper shank tool.
3	Poor holding accuracy	① Seized or adhered chip and dust to holder ID and tool shank part. ② Scratch or dent exists in holder ID or tool shank. ③ Poor accuracy of tool	① Cleaning of holder ID and tool shank ② ・Replacement of holder 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.
4	Unable to pull out cutting tool.	① Large thrust resistance causes taper to stick fast to cutting tool.	① ・Use of cotter or hitting hard from tool tongue side. ・Revision of cutting conditions（Decrease cutting resistance.） a. Higher rotation or lower feed rate （Approx. 20%）
5	Slippage of tool during machining.	① Drawing thread type Morse taper shank tool is used for MTA type. ② Drawing thread is loosened in case of drawing thread type Morse taper shank (MTB type).	① Use of MTB type for drawing thread type Morse taper shank tool. ② Tightening of drawing thread
6	Tool is pulled out during machining.	① Seized or adhered chip and dust to holder ID and tool shank part. ② Adhered oil to holder ID and tool shank part. ③ Poor taper contact in tool shank part.	① Cleaning of holder ID and tool shank ② Cleaning (degreasing) of holder ID and tool shank part. ③ Replacement of tools.
7	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	② 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.）

		・Dust, scratch or dent in the taper part or end face (in the case of two-face contact)	manufacturer.) ・Cleaning of taper and end face (in the case of two-face contact) , touching up of scratch or dent.