

ProfileMaster

Problems, corrective measures



Type of problem								Corrective measures	
Type of wear				Work piece problems		Chip control			
Edge chipping	Built-up edge	Flank wear	Plastic deformation	Vibration	Surface quality	Chip too long (tangled swarf)	Chip too short (fragmented chip)		
	↑	↓	↓	↓ ↑	↓ ↑	↓		Cutting speed	Cutting values
↓		≈	↓	↓ ↑	↓	↑	↓	Feed rate	
↑		↑	↑	↓	↑			Corner radius	Selection of inserts
↓		↑	↑					Cutting material	
≈				≈	≈			Clamping of tool	General criteria
≈				≈	≈			Clamping of work piece	
≈				≈	≈			Overhang	
≈		≈		≈	≈			Tip height	
	○	○	○		○			Cooling lubricant	

↑ raise, increase, large influence

↓ avoid, reduce large influence

≈ check, optimise

↑ raise, increase low influence

↓ avoid, reduce low influence

○ use