

**Grooving Tools Troubleshooting**

<b>Problems</b>	<b>Causes</b>	<b>Solutions</b>
Built Up Edge	Cutting Forces	Check (IPR) for excessive feed rate
	Heat	Use coolant or air blast and a coated tool
	Tool	Use a coated tool
Tool Breakage	Cutting Conditions	Check (IPR) for excessive feed rate
	Chip Packing	Stagger - Peck Grooving
Chatter	Clamping	Clamping length should be 3x the grooving bar diameter. Check the tool-holder for rigidity.
	Cutting Conditions	Reduce RPM and Increase Feed Rates
	Tool	Add a (.0001-.0003) hone to the cutting edge to keep forces consistent.
Excessive Flank Wear	Cutting Conditions	Check for excessive speed
	Part	Make sure workhardening did not occur from prior operation
	Tool	Use a coated tool