

Troubleshooting (DRX)

Trouble condition	Condition	Cause	Countermeasures
Hole diameter becomes smaller (at hole bottom)	<p>A (Entrance side) B (Bottom side)</p> <p>$A > B$</p>	Chip jam (External or Internal edge chip stuck)	Change the cutting conditions <ul style="list-style-type: none"> • Increase the cutting speed • Lower the feed rate See page K34 for "Recommended Cutting Conditions"
Hole diameter becomes larger (at hole bottom)	<p>A (Entrance side) B' (Bottom side)</p> <p>$A < B'$</p>	Internal edge chip jam.	Change the cutting conditions <ul style="list-style-type: none"> • Increase the cutting speed • Lower the feed rate See page K34 for "Recommended Cutting Conditions" <ul style="list-style-type: none"> • Check the core height See page K36~K37
Hole diameter is small (from the hole entrance)		Hole diameter is small from entrance. (At turning moment)	Inappropriate adjustment of hole diameter. See page K36
		No core at internal edge. (No core remains)	Adjust the core height. See page K36~K37



◆ MagicDrill (DRX) Hole Bottom Shape (mm)

øDc	A	B	C	øDc	A	B	C	øDc	A	B	C
12.0	1.8	4.2	0.5	24.5	3.2	9.1	0.8	39.0	5.8	13.7	1.5
12.5		4.5		25.0		9.3	0.9	40.0		14.2	
13.0		4.7		25.5		9.6		41.0		14.7	
13.5	2	4.8	0.5	26.0	3.9	9.8	1.0	42.0	7.1	15.2	1.6
14.0		5.0		26.5		9.4		43.0		15.7	
14.5		5.3		27.0		9.6		44.0		16.2	
15.0		5.5		27.5		9.9		45.0		16.7	
15.5		5.8		28.0		10.1		46.0		17.2	
16.0	2.4	6.0	0.6	28.5	4.7	10.4	1.1	47.0	7.1	17.7	1.7
16.5		6.3		29.0		10.6		48.0		16.9	
17.0		6.5		29.5		10.9		49.0		17.4	
17.5		6.8		30.0		11.1		50.0		17.9	
18.0		7.0		30.5		11.4		51.0		18.4	
18.5	3.2	6.9	0.7	31.0	4.7	11.6	1.2	52.0	7.1	18.9	1.8
19.0		7.1		31.5		11.9		53.0		19.4	
19.5		7.4		32.0		11.3		54.0		19.9	
20.0		7.6		33.0		11.8		55.0		20.4	
20.5		7.9		34.0		12.3		56.0		20.9	
21.0	3.2	8.1	0.8	35.0	4.7	12.8	1.1	57.0	7.1	21.4	1.9
21.5		8.4		36.0		13.3		58.0		21.9	
22.0		7.8		37.0		13.8		59.0		22.4	
22.5		8.1		38.0		14.3		60.0		22.9	
23.0		8.3		Common for 2xD,3xD,4xD,5xD type							
23.5	8.6	* Figures above are nominal sizes (Varies from -0.1mm to +0.1mm depending on work material and cutting conditions)									
24.0	8.8										

