TROUBLE SHOOTING

1 - When Form Tool Diameter Changes Size, Varies or Chatters.
- a. Check for maximum rigidity in tool set-up and head locking.
  - 1a. Check for sloppy tool or work spindle bearings.
  - 2a. Check for proper hook in tool and on center.
  - 3a. Proper work support if necessary.
- b. Check for loose slide or tool arm bushing.
- c. See if all bolts are tight.
- d. Check stop screw pressure (.005 pressure would be .010 on diameter of piece, this should be enough.)
- e. Dull tool.

2 - When the hole gets big.
- a. Head locking properly.
- b. Sloppy spindles.
- c. Center drill, chipped or off center.
- d. Check if drill is dull or loaded.
- e. Check drill alignment and spindle alignment.

3 - When threads come out stripped.
- a. See if proper cam is used.
- b. Check block location for proper rises.
- c. Check proper clutch shifting.
- d. Check for excess wobble in tap or die.
- e. Check threading clutch torque.
- f. Check if hole or body size is correct.
- g. Spindle is out of line.
- h. Dull, loaded up, tap or die.

4 - Variation in length.
- a. Check head thrust and thrust bearings end play.
- b. Worm or sloppy bearings in spindle.
- c. Dull end working tools pushing work back into collets, such as drills, broaches, and etc.
- d. Loose, worn, or dirty collets.
- e. Check for equal feed finger pressure.
- f. Check for clean cutoff on bar end.
- g. Stock stop should be tight, highly polished, and proper length of stop plate.
- h. Check for worn rolls and pins on end working cam lever.

5 - When parts have burr on cutoff.
- a. Check for proper pressure on stop collar (1263-101-14-1) on the burring spindle.
- b. Check timing of closing dogs so burring chuck is closing at proper time.
- c. Check rolls and pins on cam levers.
- d. Cutoff above or below center.

6 - When box tool dimension is rough or varies in size.
- a. Check for proper grind on box tool.
- b. Check for proper feed.
- c. Check rollers for proper tension.