TROUBLESHOOTING

ISSUE	POSSIBLE CAUSES	RECCOMENDATIONS
Machine is alarming or stalling	1. Broach Holder is off-center 2. Excessive swarf accumulation	1. Make sure the Tool Holder is centered correctly 2. Solutions to reduce swarf accumulation: - For internal broaches, increase pre-drill size (larger workpiece I.D.) - For external broaches, pre-turn dia. smaller (smaller workpiece O.D.)
Witness marks or skid on workpiece	Broach is bouncing off the face of the workpiece at initial contact	Reduce the speed to approx. 50-100 RPM during initial contact into the part (maintaining feed rate). Then, increase the speed back to the recommended RPMs once tool is about 1 mm into part. Consider leaving extra stock on workpiece and clean-off after broaching
Spiraling form/form is getting smaller towards bottom	Excessive swarf accumulation	1. Solutions to reduce swarf accumulation: - For internal broaches, increase pre-drill size (larger workpiece I.D.) - For external broaches pre-turn dia. smaller (smaller workpiece O.D.) 2. To prevent spiraling use the orientation lever
Workpiece is pushing back into the machine	Workpiece not held thight	Use a serrated collet to hold the workpiece
Broach tool chipping / poor tool life	1. Broach holder is off-center. 2. Improper workpiece preparation 3. Inaccurate speeds and feeds	1. Make sure the tool holder is centered correctly. 2. Be sure that pre-drill is large and deep enough. 3. Slow down your speeds and feeds especially at initial contact with the workpiece.
Form not centered / teeth larger on one side	1. Broach holder is off-center 2. Workpiece deflection	1. Poliangolar tool holders are adjustment-free 2. Reduce speed during initial contact (maintain feed rate)
Swarf remain in the bottom of the part	Missing undercut	Swarf may be cleared out from the bottom of the part by going back in with the same drill used to pre drill the pilot hole. A small undercut may be added at the end of the broaching depth prior to broaching the form