Troubleshooting

（Drill jig bush）

	Details of the trouble	Cause	Pulled out of holder. Unable to attach fast to spindle or holder in case of MT shank.
1	Unable to place in bush plate.	① Wrong bush plate hole dimension and dimension tolerance in case of fixed bush.	① Use of H7 tolerance for bush plate hole.
2	Unable to place in cutting blade.	① Bush for precision drill or average drill is used for reamer machining. ② In case of fixed bush, bush plate hole dimension is small and I.D. is shrunk at the time of injection.	① Selection of bush for reamer in case of reamer machining. ② Use of H7 tolerance for bush plate hole.
3	Unable to obtain required accuracy for hole diameter.	① Abrasion of bush. ② Average bush is used. ③ Bush is not fixed properly.	① Replacement of bush. ② Use of precision bush. ③ Check if bush is fixed.
4	Easily gets abraded.	① Bush is not fixed firmly. ② Core misalignment between machine spindle and bush is large.	① Check if bush is fixed. ② Readjustment of core.
5	Work is scratched.	① Chips are not discharged well.	① Chips are not discharged well.
6	Bush is not fixed by fastening screws and studs	① Fixing bush for guidance is not inserted to the end of bush plate. ② Insert bush is different from fixed bush for guidance in size. ③ Wrong pitch between bush and fastening screw. ④ Abrasion of fastening screw and stud.	① Insert fixed bush for guidance so that flange end surface on insert bush touches plate. ② Check size. ③ Check pitch. ④ Replacement of fastening screw and stud.