



Code		Problem								Solution
1	Breaking of drill									
2	Outer corner breaks down									
3	Cutting edges chip									
4	Lands chip									
5	Drill splits up centre									
6	Drill will not enter work									
7	Hole rough									
8	Hole oversize									
9	Tang Breaks									
1	2	3	4	5	6	7	8	9	Solution	
●					●	●			Dull point	
●									Drill has front taper due to wearing	
●				●	●				Insufficient lip clearance on point	
●		●							Lip clearance too great	
●									Drill in incorrectly point ground	
●	●								Flutes clogged with chips	
●									Spring or backlash in drill press, fixture or work	
●		●		●		●			Feed too heavy	
	●								Cutting speed too high	
	●					●			Dry cutting, no lubricant at cutting edges	
	●								Hard spots in workpiece material	
			●						Oversize jig bushing	
					●				Drill web (core) diameter too big	
						●			Fixture/Clamping not rigid	
							●		Unequal angle or Uneven length of cutting edges	
							●		Spindle run-out/Loose spindle	
								●	Bad fit between shank taper & socket. The drive & alignment is controlled by the taper fit.	