



Code		Problem							
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.