

Technical Tip #105 – Excessive Reamer Wear or Breakage

The following conditions may adversely affect reamer life or, in some cases, damage the reamer through wear or breakage:

- Misalignment of the reamer that creates a bell-mouth condition and premature wear.
- Lack of chip space in the flutes.
- Inconsistent material condition.
- Dirt or burs in the holding collets or spindle.
- Over- or under-feeding or speeding.
- Lack of proper lubrication.
- Bottoming out in blind holes.
- Leaving too little or too much stock to remove.
- Poor hole quality.
- Improper regrinding.
- Careless handling of the reamer.
- Reamer chatter.
- Lack of rigidity of the set-up.
- Wrong reamer design for the application.

If you experience reamer wear or damage, make sure you have addressed each of these potential causes to eliminate the problem.