

Tennessee Abrasive Inc.

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TROUBLESHOOTING CHART

<u>WITNESSED CONDITIONS</u>	<u>CORRECTIONS IN USUAL ORDER OF IMPORTANCE</u>
ABRASIVE GLAZING	2-3-5-15-13-18-11
ABRASIVE LOADING	2-3-15-7-17-19-11
ABRASIVE GALLING	2-3-7-15-0-17-19-24-11
ABRASIVE SPALLING	30-6-22-23
FINISH TOO ROUGH	1-4-6-17-16-7-12
FINISH TOO SMOOTH	2-3-5-18-15-8-13
EXCESSIVE ABRASIVE USAGE	1-4-6-16-7
TAPERED STONE WEAR	12-22-21-16
ECCENTRIC STONE WEAR	14-22-21-16
SLOW STOCK REMOVAL	5-3-2-8-11-15-18
EXCESSIVE HEAT GENERATION	10-6-8-11-24-15-20
PART OUT OF ROUND	6-2-3-12-14-15-25
PART BELL MOUTHED TAPERED	26-12-14-25
PART NOT AXIALLY STRAIGHT	31-14-25-32
PART BEING HONED ECCENTRIC TO OD	14-28-29
SWIPE MARKS IN BORE	27
BORE NOT SQUARE TO FACE	28-14-32
WASHOUT AROUND KEYWAYS, PORTS	6-17

CORRECTIONS

1. INCREASE SPINDLE RPM
2. DECREASE SPINDLE RPM
3. INCREASE RECIPROICATION
4. DECREASE RECIPROICATION
5. INCREASE FEED RATE
6. DECREASE FEED RATE
7. INCREASE COOLANTS BASE CONTENT
8. DECREASE COOLANTS BASE CONTENT
9. CHECK FILTRATION OF COOLANT
10. CHECK REFRIGERATION OF COOLANT
11. CHECK COOLANT FOR HYDRAULIC OIL CONTAMINATION
12. INCREASE RUN-OUT TIME
13. DECREASE RUN-OUT TIME
14. CHECK SPINDLE TO PART ALIGNMENT
15. USE SOFTER ABRASIVES
16. USE HARDER ABRASIVES
17. USE FINER GRIT STONES
18. USE COARSER GRIT STONES
19. USE LESS POROUS STONES
20. USE MORE POROUS STONES
21. CHECK THAT ABRASIVES ARE ON GRADE
22. CHECK TOOL SLOTS, PINS, CONE FOR WEAR
23. TRIAL OTHER ABRASIVES
24. USE MORE COOLANT
25. CHECK TO SEE THAT FIXTURE IS NOT DISTORTING
26. ADJUST OVER-RUN OF STROKE
27. USE GUIDES
28. TRAM PART FACE TO DETERMINE THAT PART IS SQUARE TO SPINDLE
29. ROTATE PART OCCASIONALLY WHILE HONING
30. USE LIGHT FEED PRESSURE AT START OF HONE
31. USE LONGER ABRASIVES
32. CHECK PART ACCURACY PRINT TO HONING