Auronix

ENGINEERED FOR PRECISION

PRECISION
STABILITY
HIGHER PRODUCTIVITY

TURNING FRONT HEAD WITH STATIONARY ANTI VIBRATION ADAPTOR

TROUBLESHOOTING GUIDE

Serrated-Face Connection
Correct • Rigid • Repeatable

PROBLEM / OBSERVATION	POSSIBLE CAUSE	CORRECTIVE ACTION
 **Front head does not seat flush.**	• Chips/dirt on serrated mating faces • Serrations misaligned	• Remove head, clean both serrated faces. • Realign teeth and seat squarely. • Do not force.
 **Visible gap after clamping.**	• Incorrect serration engagement • Contamination between faces	• Loosen screws, separate parts. • Clean mating faces and reassemble.
 **Front head moves after tightening.**	• Clamping screws insufficiently tightened	• Verify correct screw/thread. • Tighten using a calibrated torque wrench/key to the specified torque.
 **Clamping screw difficult to engage.**	• Screw started at an angle • Damaged/dirty thread • Incompatible screw	• Stop tightening. • Remove screw, inspect and clean threads. • Start screw by hand before applying torque.
 **Clamping screw repeatedly loosens.**	• Incorrect torque • Damaged thread • Poor seating	• Inspect screw/thread and serrated seating. • Reassemble and apply specified torque. • Do not continue operation until rigid.
 **Serrations do not mate correctly.**	• Wrong front head • Incorrect orientation • Damaged serration teeth	• Confirm component compatibility. • Check orientation. • Inspect serrations. Do not assemble damaged components.
 **Coolant flow weak or blocked.**	• Coolant passages misaligned • Contamination in coolant holes	• Remove head, clean coolant passages. • Verify correct alignment during assembly.
 **Coolant leakage at connection.**	• Front head not fully seated • Mating faces contaminated	• Stop machine. • Clean interfaces, check seating and reclamp correctly.
 **Unexpected vibration or chatter.**	• Loose front head • Incorrect seating • Runout or connection problem	• Stop machining. • Check head rigidity, serration seating, clamping torque and runout before restarting.

TORQUE REFERENCE (FOR CLAMPING SCREW)

Tool Ø (mm)	Clamping Thread	Recommended Torque (Nm) (Class 12.9, Dry)
25	M4	3 – 4
32	M5	6 – 8
40	M6	10 – 12
50	M6	10 – 12
60	M8	24 – 28

IMPORTANT

If correct seating, rigidity, coolant alignment or specified clamping torque cannot be achieved, **DO NOT** operate the tool. Inspect the front head, adaptor, serrations and clamping threads before reuse.

INSPECT REGULARLY | KEEP CLEAN | USE CORRECT TORQUE | ENSURE RIGID CONNECTION