

# Root Cause - Blunt Tool Gripper Datum Hole Failure

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Describing how a blunt 10mm tool can cause a datum hole failure

## Contents

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Problem

Failure Mode

Solution

Comments

## Problem

10mm tool is slightly blunt on piercing end

## Failure Mode

When machining the datum hole on a ZX5, the profile is only held by the infeed roller clamps and a the infeed datum clamp. If the tool is blunt, it can "grab" the profile and pull it into the machine, therefore changing the datum position and creating inaccuracies

## Solution

Change the cutter

Check the infeed Datum Rubber Clamp pad exists - Setting Infeed Datum Clamp