

Metal Chip Inspection Chart

The best method of evaluating the performance of your metal cutting operation is to inspect the chips that are formed from cutting. Refer to the chart below for chip inspection guidelines.









Chip Appearance	Chip Description	Chip Color	Blade Speed	Feed Pressure	Additional Actions
	Thin & Curled	Silver	<i>Good</i>	<i>Good</i>	
	Hard, Thick & Short	Brown or Blue	Decrease	Decrease	Lubricate with a small amount of oil
	Hard, Strong & Thick	Brown or Blue	Decrease	Decrease	Lubricate with a small amount of oil
	Hard, Strong & Thick	Silver or Light Brown	<i>Good</i>	Decrease Slightly	Check Blade Pitch
	Hard & Thin	Silver	Increase	Decrease	Check Blade Pitch
	Straight & Thin	Silver	<i>Good</i>	Increase	
	Powdery	Silver	Decrease	Increase	
	Curled Tight & Thin	Silver	<i>Good</i>	Decrease	Check Blade Pitch

Figure 49. Chip inspection chart.

