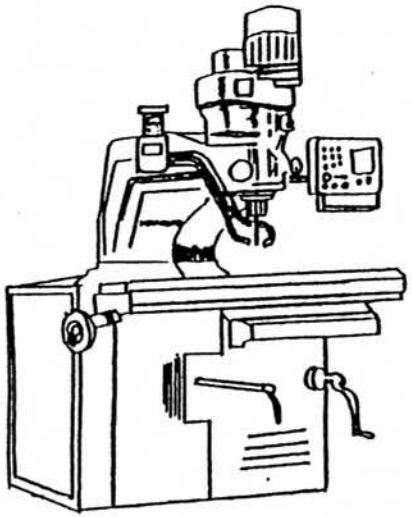
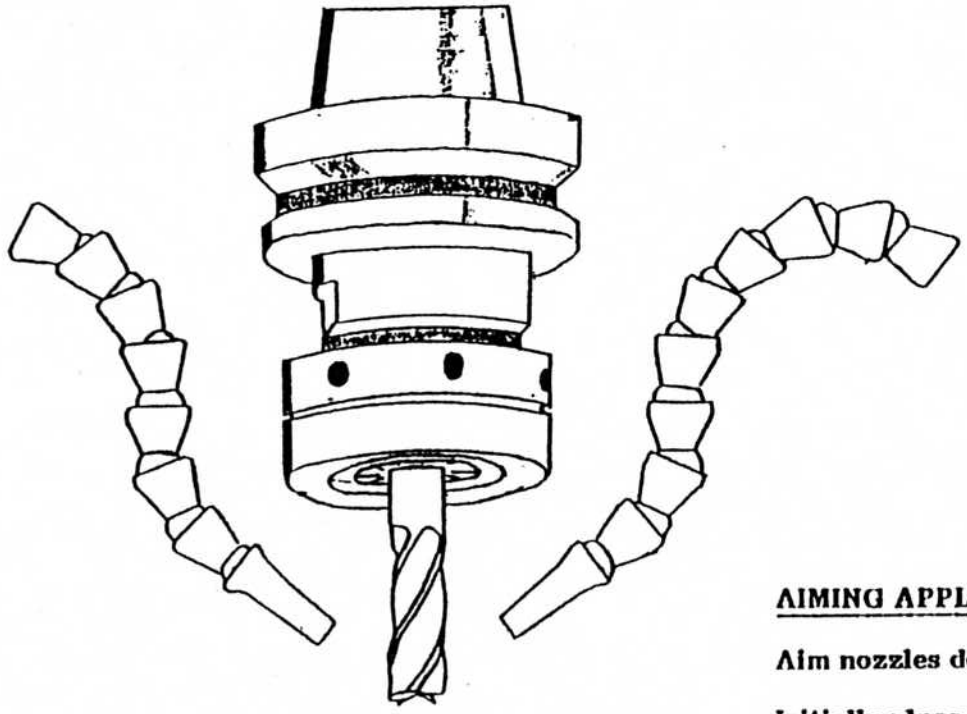
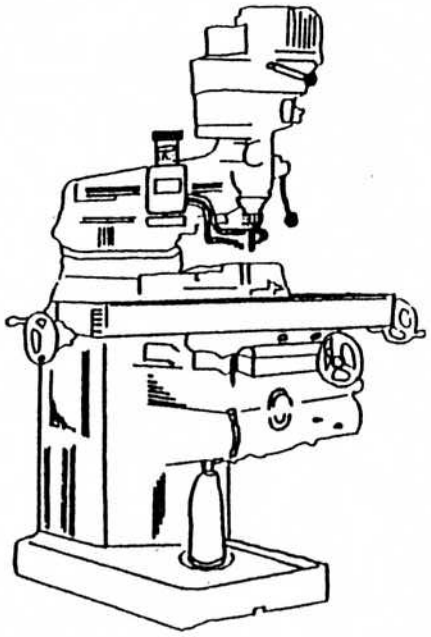
MILLING (Fluted Cutters)







MILLING –

A single nozzle applicator is usually satisfactory for milling operations engaging only the periphery of the work piece (squaring up rough stock etc.).

But whenever more than 1/2 of the circumference of the end mill is engaged (as in slot milling), or when both the side and end cutting edges of the mill are engaged (as in contour or pocket milling), USE A DOUBLE NOZZLE APPLICATOR.

MACHINE TOOL SPEEDS & FEED RATES

* Speeds (Spindle RPM, Blade FPM, etc.) - Operate at speeds 10-15% greater than "dry" speed recommended for tool/material combination being used.
* Feed Rate (Surface feed, Depth of cut, etc.) - Operate at the maximum rate recommended for the tool/combination being used. Objective is to achieve maximum "chip load".

AIMING APPLICATOR NOZZLES

Aim nozzles downward.

Initially place nozzle tips 4-5 cm from cutter edge.

Adjust nozzles according to your experiences, tool configuration, workpiece & obstructions, etc.

The closer a nozzle is to the cutter, the less ACCU-LUBE is required.

FLOW CONTROL VALVE

It may be necessary to adjust applicator air flow to optimize application of ACCU-LUBE due to turbulence at the tool / work-piece interface.