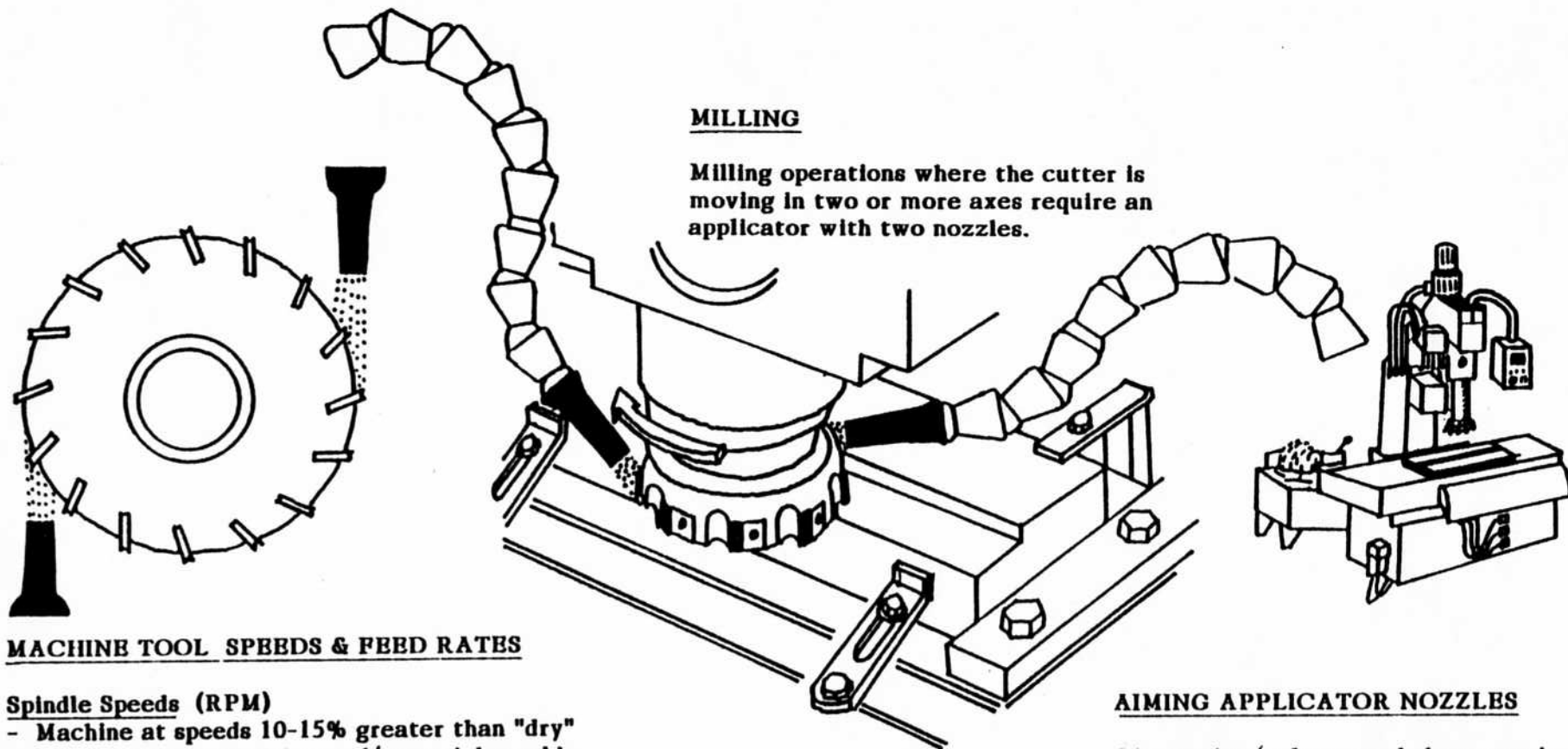


MILLING (Multiple Inserts)



MILLING

Milling operations where the cutter is moving in two or more axes require an applicator with two nozzles.

MACHINE TOOL SPEEDS & FEED RATES

Spindle Speeds (RPM)

- Machine at speeds 10-15% greater than "dry" speed recommended for tool/material combination being used.

Feed Rate (SFPM, depth of cut, etc.)

- Machine at the maximum rate recommended for the tool/combination being used. Accu-Lube helps achieve maximum "chip load".

FLOW CONTROL VALVE

It may be necessary to adjust applicator air flow to optimize application of Accu-Lube due to turbulence at the cutter workpiece interface.

AIMING APPLICATOR NOZZLES

Aim each nozzle toward the oncoming cutting edge of the insert.

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

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

The closer the nozzles are to the cutter, the less Accu-Lube is required.