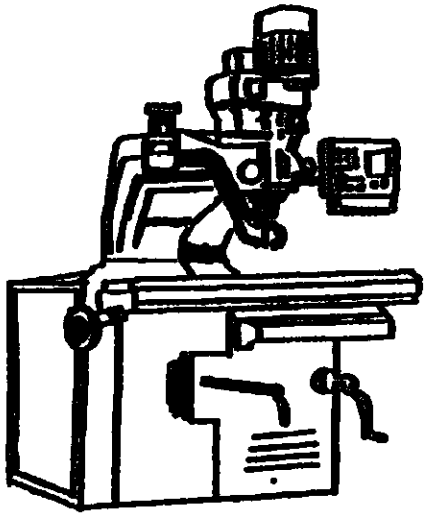
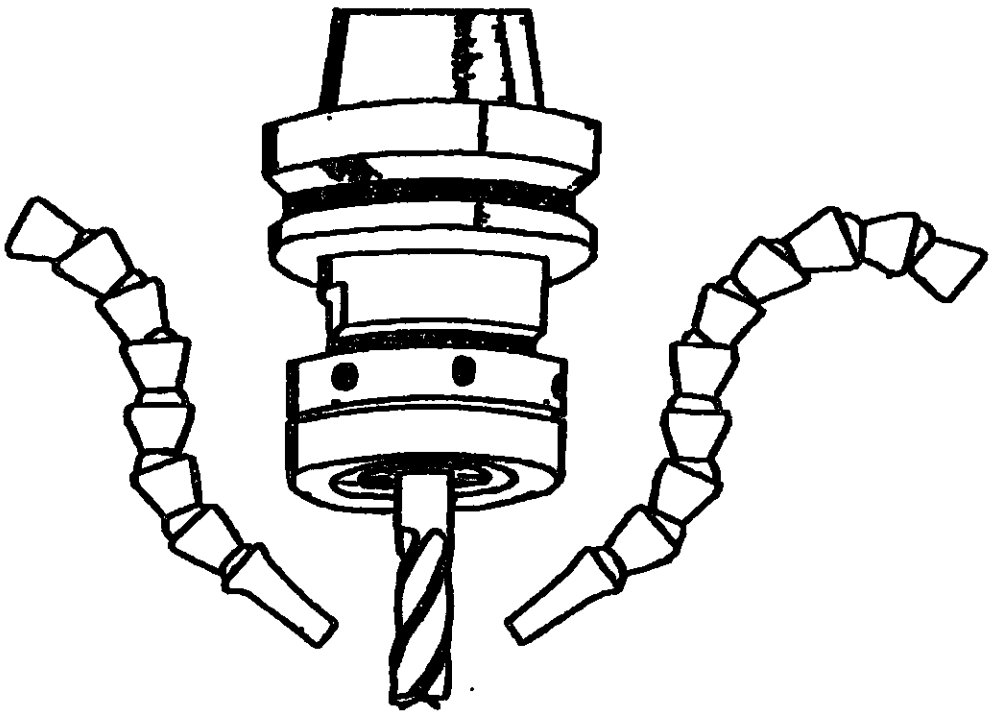
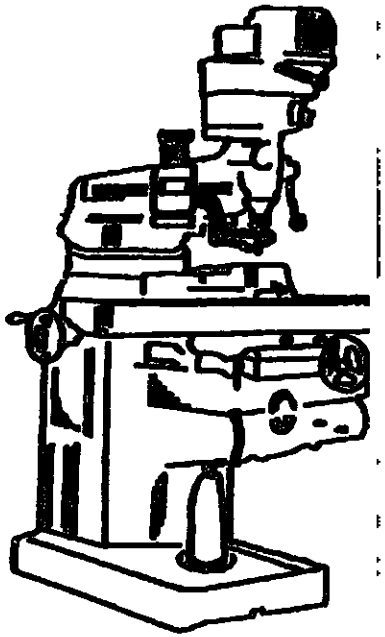
Milling (all Fluted Cutters)







Milling –

A single nozzle MerLicator is usually satisfactory for single spindle milling operations that only engage the periphery of the work piece (squaring up rough stock etc,).

Use a double nozzle MerLicator whenever more than ½" of the circumference of the end mill is engaged in the work piece (as in slot milling) or when both the side and the end cutting edges of the mill are engaged (as in contour or pocket milling).

Machine Tool Speeds and Feed Rates

- Speeds (spindle RPM, Blades FPM, etc) - Operate at speeds 10-15% greater than "dry" speed that is recommended for tool/material combinations 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 Merlicator nozzles

Aim nozzles downward.

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

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

The closer a nozzle is to the cutter the less MerLube i required.

Flow Control Valve

It may be necessary to adjust Merlicator air flow to optimize application of MerLube due to the turbulen at the tool and/or work piece interface