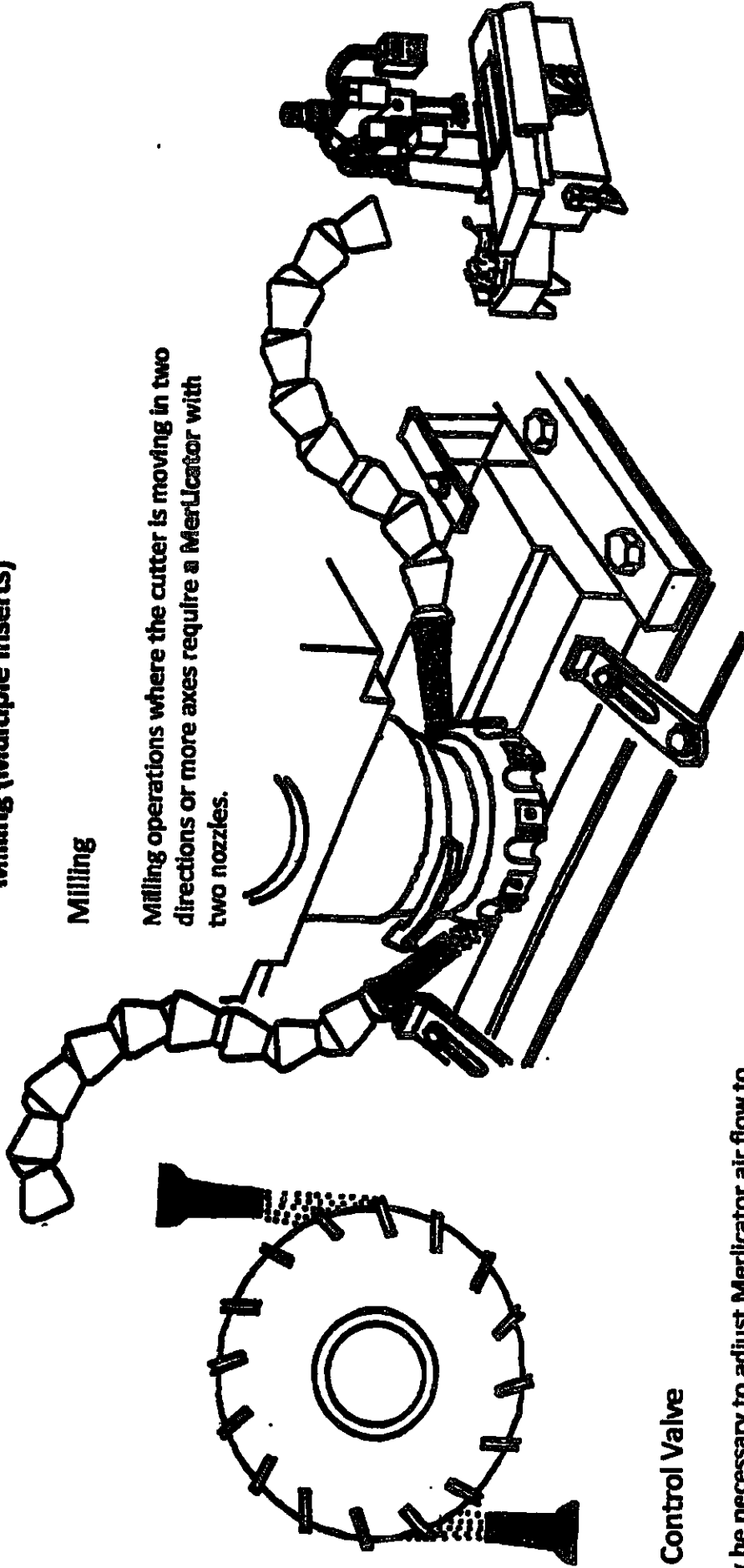


## Milling (Multiple Inserts)



### Milling

Milling operations where the cutter is moving in two directions or more axes require a MerLubeator with two nozzles.

### Flow Control Valve

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

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

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 is required.