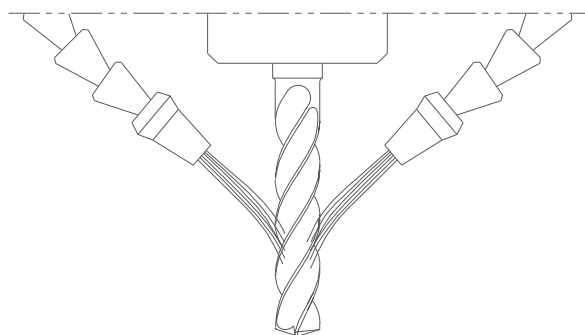
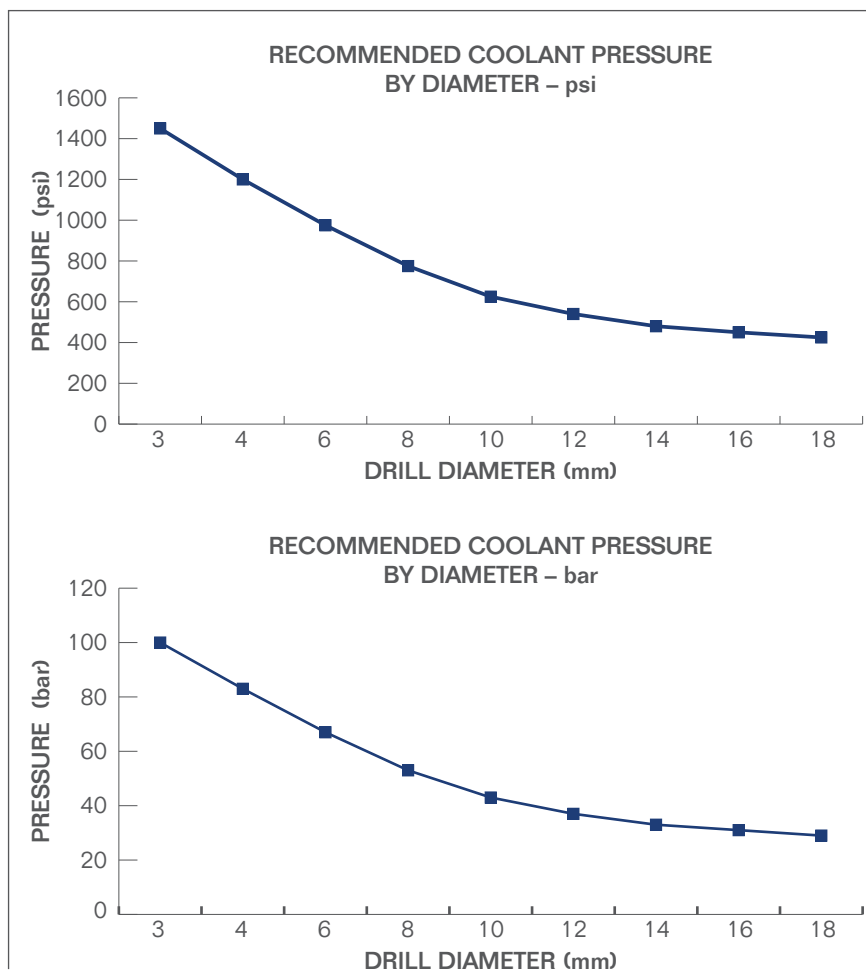
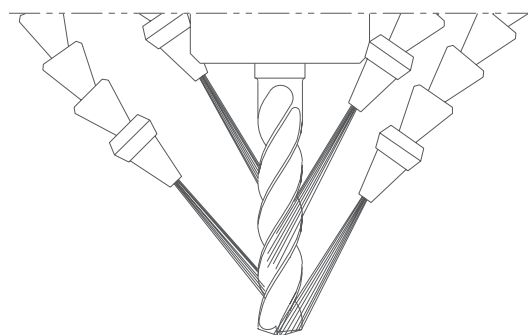


COOLANT RECOMMENDATIONS

- Coolant works to mobilize chips away from the cut zone, reduce the heat created during the cutting process and minimize friction.
- It is important to optimize the coolant pressure and position in order to gain the full benefits coolant offers the cutting process.
- Proper coolant application promotes greater operating parameters, greater material removal rates, improved surface finishes, predictable tool life, reduced power consumption and reduced cycle times.
- Pressure is important, but more importantly is consistency of the pressure and application onto the tool; intermittent cooling of carbide leads to thermal stressing of the material and the formation of "microcracks."
- Proper cleanliness and filtration of coolants is important in order for the coolant to maintain its beneficial properties, and also to avoid a reduction in coolant pressure or the possibility of clogging the coolant channels in coolant through drills.



**LARGE TIP – LOW VELOCITY
NO COVERAGE AT MAXIMUM DEPTH**



**SMALL TIP – HIGH VELOCITY
COMPLETE COVERAGE**

- Reducing the nozzle size helps maximize the cooling benefits of the unique double margin design on the Hi-PerCarb drill by increasing velocity. Aim the nozzles in line with the secondary flute located between the two margins as well as the flute for best results.