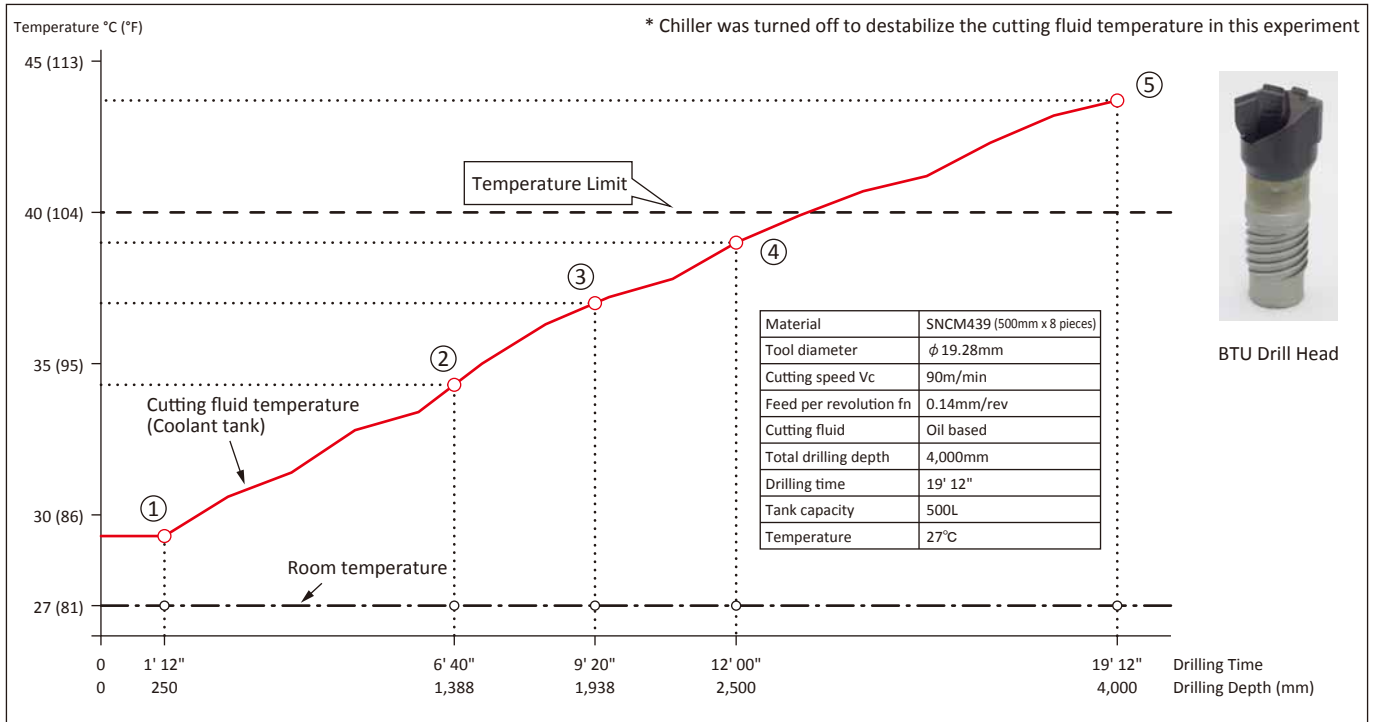


Cutting Fluid Temperature and Chip Formation

Cutting Fluid Temperature Change

Cutting fluid temperature keeps rising if a chiller is not used in deep hole drilling.



Cutting Fluid Temperature and Chip Formation



Chip evacuation is much more essential for successful deep hole drilling than for general metal working. It is very important to keep cutting fluid temperature constant using a chiller during the drilling operation so that stable chip formation can be maintained which contributes to good chip evacuation.

Please refer to our technical information "Cutting Fluid Management" for cutting fluid function. (<http://www.unitac.co.jp/pdf/UT10004E-A.pdf>)