

ENGLISH MANUAL

Technical user manual Annular Cutters

Using Magnetic Drilling Machines

- Make sure the slide is tightened

Using Stationary machines

- The material should be tightened correctly;
- Spindle must make a perfect circle;
- The table should be moved towards the spindle as far as possible;
- Use the machine manually.

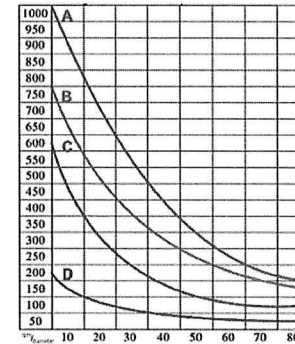
Manual Cooling

- Morse Tapers such as MC.2, MC.3, MC.3.32;
- Hole cutter must be lubricated with a top quality lubricant (fully oil based). The holes on the arbor allow lubrication from inside.
Or use a spraycan with cutting oil and spray regularly.

Automatic cooling

- Morse tapers such as IMC.20, IMC.30/19, IMC.30/32;
- Hole cutter must be lubricated with a top quality lubricant (fully oil based);
- When drilling horizontally we advise you to use a spray or paste. When using the spray make sure you regularly lubricate the cutter.

RPM indication:



RPM Indication for HSS Hole Cutters

A = Aluminium
B = Copper
C = Steel 37
D = Stainless steel

Feed

Steel up to 500 N/mm² – 25 m/min.
Steel 500-700 N/mm² – 20 m/min.
Stainless steel V2A, V4A – 15 m.min.

Manual pressure

Lot's of pressure is not required for drilling. Be careful during the initial cut that you do not apply too much pressure as this adversely affects the life-span of the cutter. Too less pressure or too high RPM can result in burned teeth of the cutter. When drilling deep holes, remove metal swirls regularly and fill the hole with cutting oil before restart drilling.

Automatic pressure

It is not advisable to use stationary machines with the auto-pressure on. The chance of your cutter breaking will be higher.