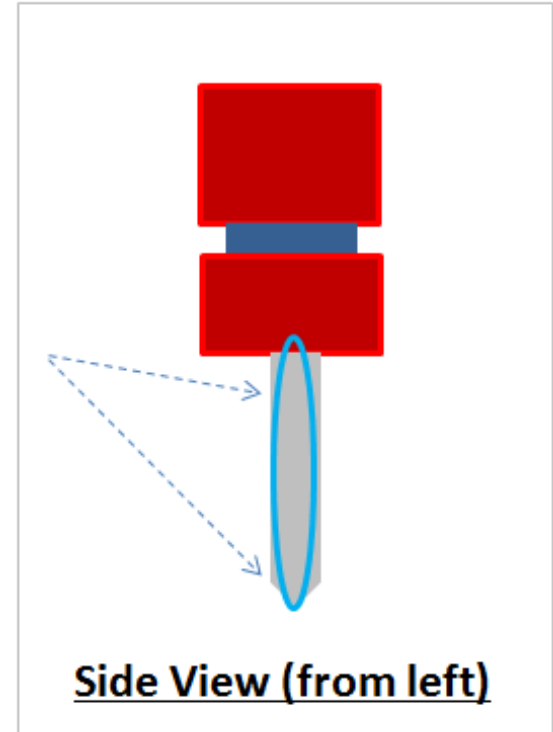
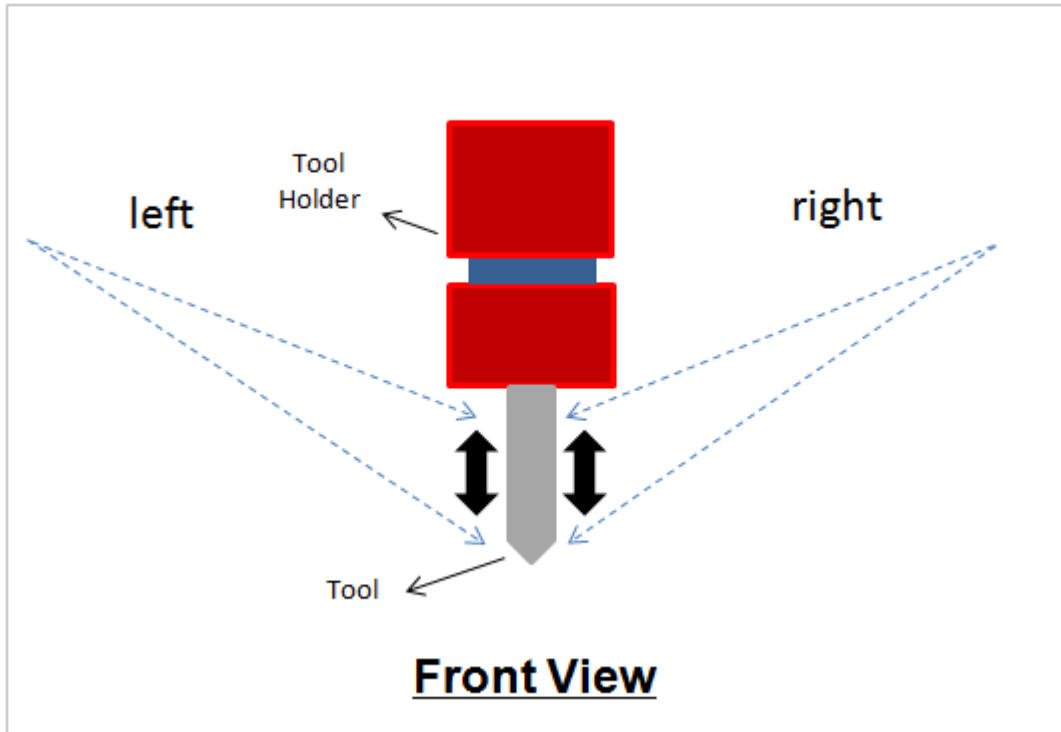


General. Basic Setting for all tools



Sweep the whole of blade area.

Mode : SWEEP

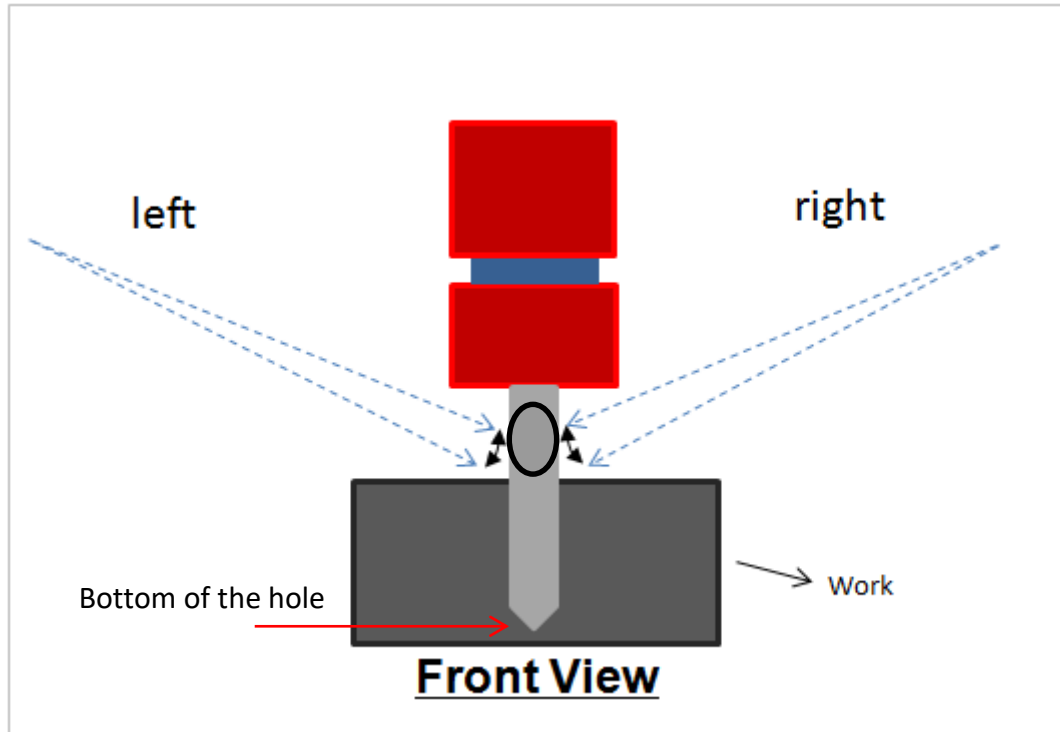
ANGLE : Tool blade length (depending on the tool)

SPEED : 50 (Higher speed is recommended for Long tool)

Aim the center of the tool.

Drilling

Case of chip remaining to the drill



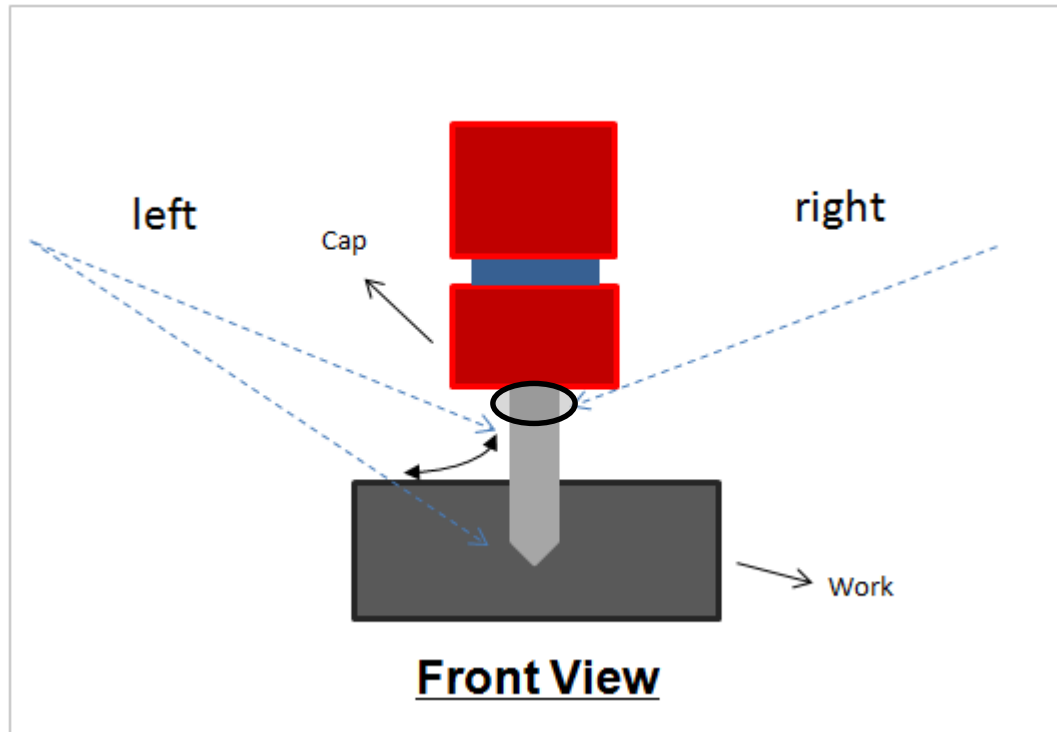
Mode : KICK

ANGLE : Only above the work

SPEED : 10

Extend the chips upward, then remove.

Case of chip remaining around the tool holder



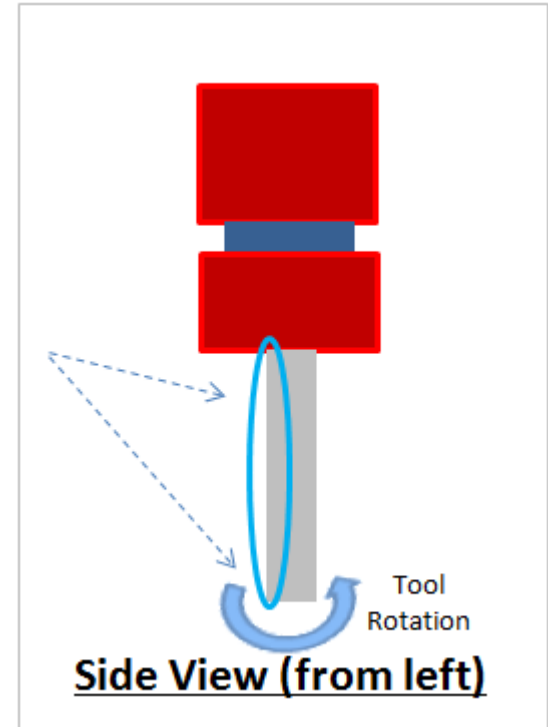
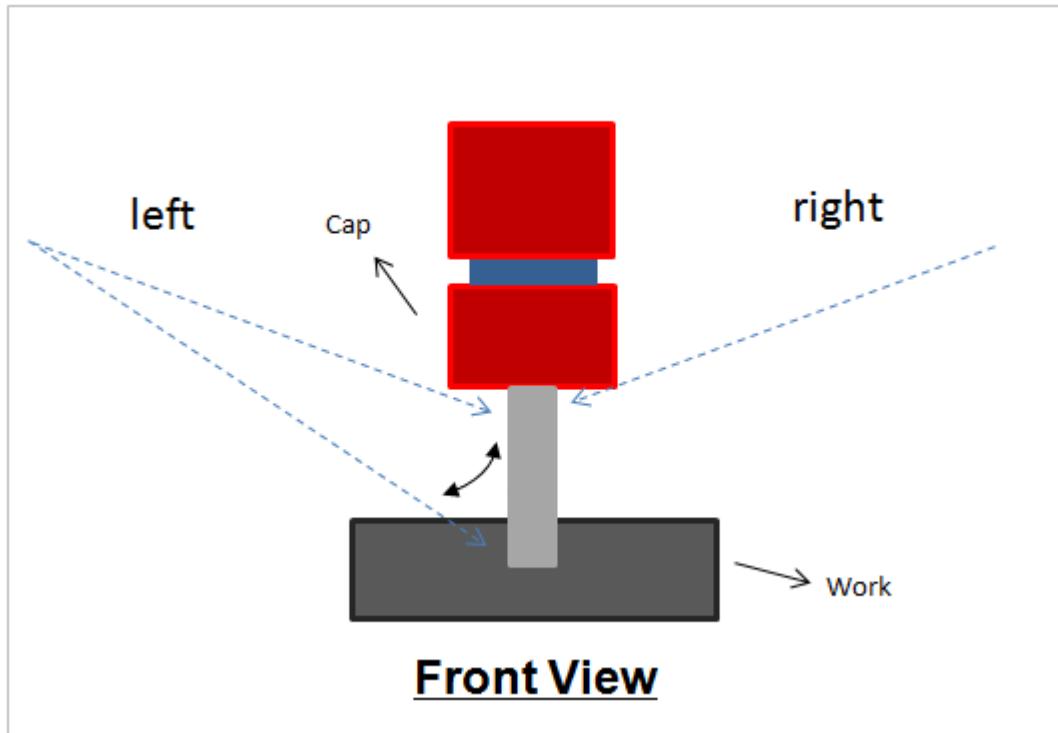
One side :
Mode : SWEEP
ANGLE : Tool blade length
SPEED : 100

FIX side : Prevent chips extend upward
SWEEP side : Remove chips.

Other side:
Mode : FIX
ANGLE: Aim the End-Cap
to prevent chips
extend upward

Tapping

Case of chip remaining to the tool * For the case that chips are hard to remove.

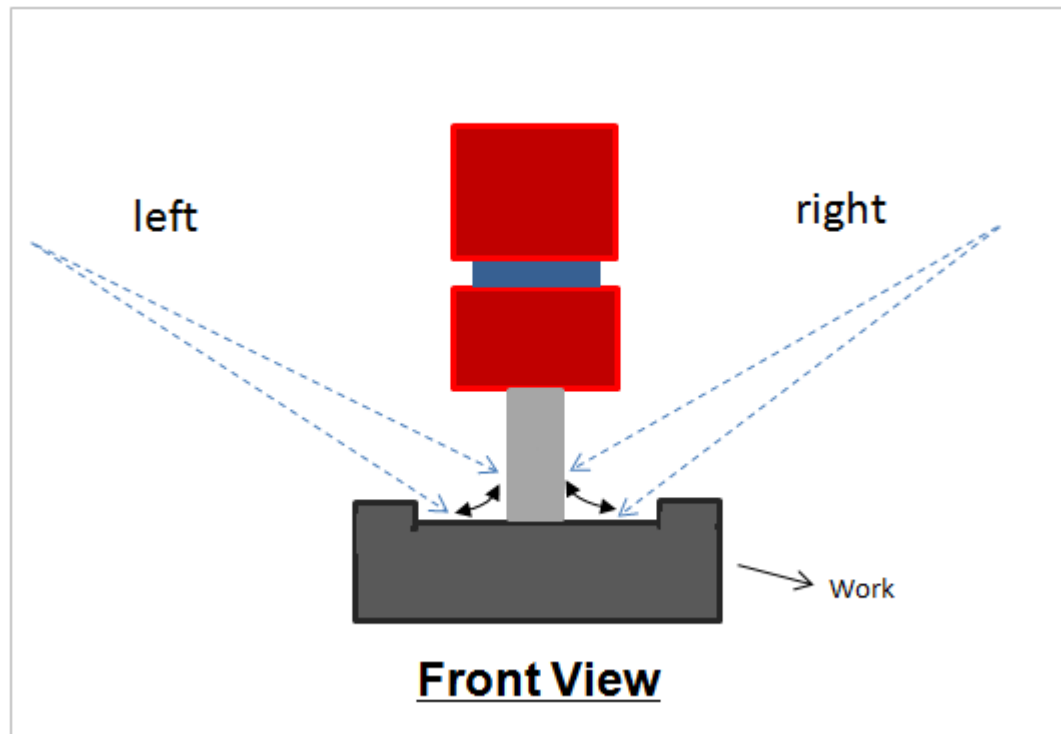


Left side :
 Mode : SWEEP
 ANGLE : Tool length
 SPEED : 100
 (Higher speed)

Right side:
 Mode : FIX
 ANGLE: Aim the End-Cap
 to prevent chips
 extend upward

Oil blow from left side is offset from the center of the tool to prevent chips winding by tool rotation .

Case of chip cleaning

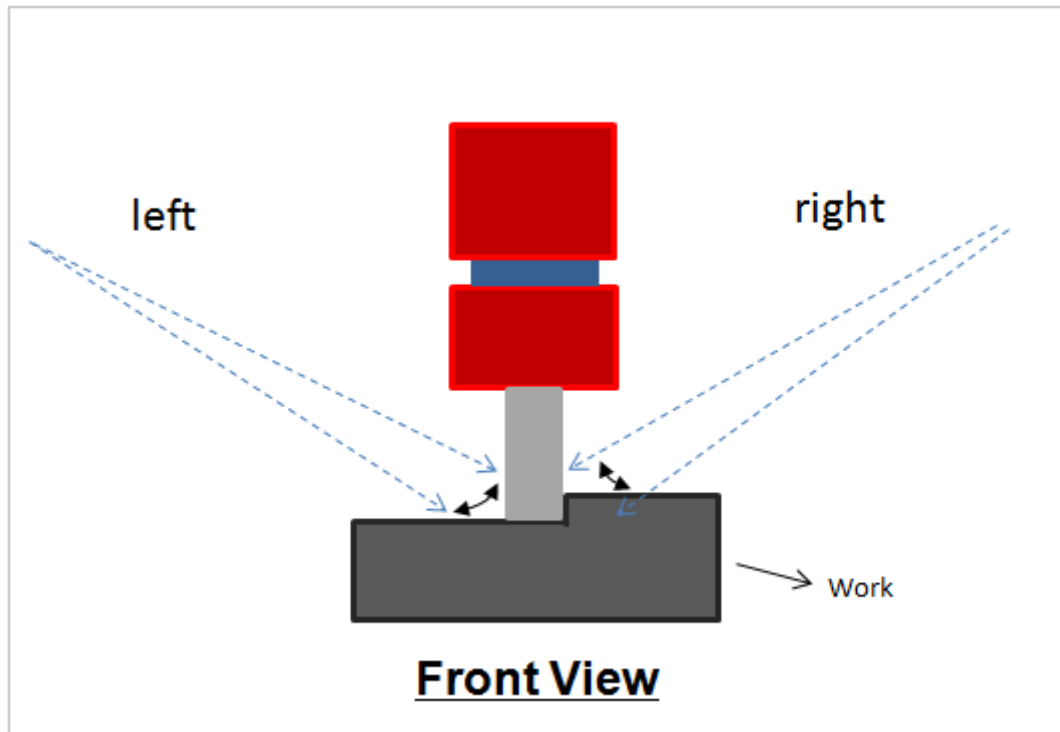


Mode : SWEEP
ANGLE : 4 count
(Depending on cutting depth)
SPEED : 50

Aim the cutting position.
Center angle of nozzle swing is cutting point
Middle speed

Endmill

Case of chip cleaning or chip remaining to the tool



Mode : SWEEP

ANGLE : Depending on
cutting depth

SPEED : 100

Aim the cutting position.

Center angle of nozzle swing is cutting point

Higher speed