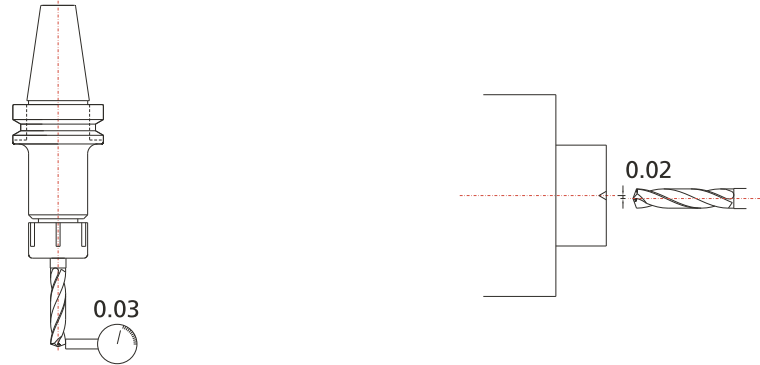


Concentricity, Coolant supply

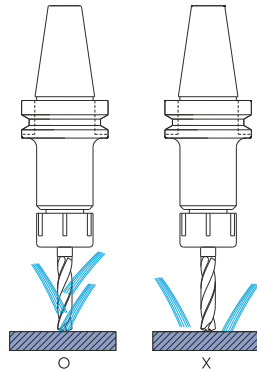
Concentricity

▶ To achieve the tolerance required or eliminate trouble, total run out between the center line of tool and workpiece must not exceed the below value.

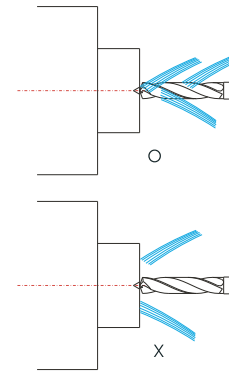


External coolant supply

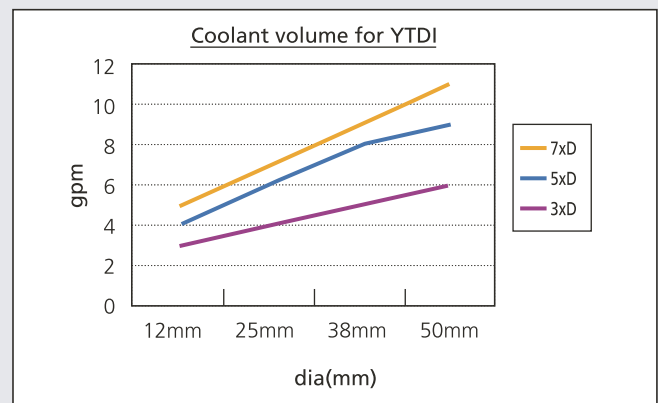
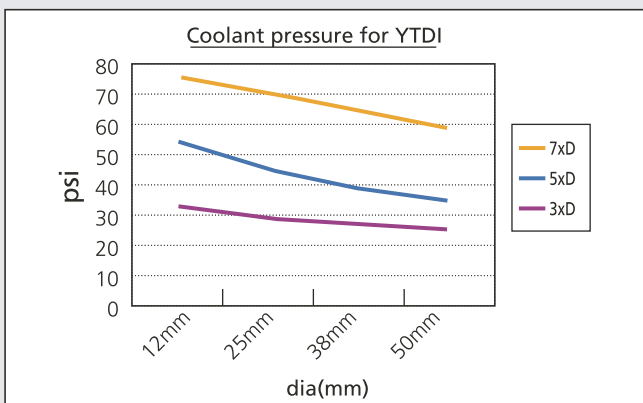
Milling



Turning



Internal Coolant supply



Coolant Pressure(psi) for YTDI drill

	12mm	25mm	38mm	50mm
3xD	33	29	27	25
5xD	54	45	39	35
7xD	75	70	64	59

Coolant Volume(gpm) for YTDI drill

	12mm	25mm	38mm	50mm
3xD	3	4	5	6
5xD	4	6	8	9
7xD	5	7	9	11