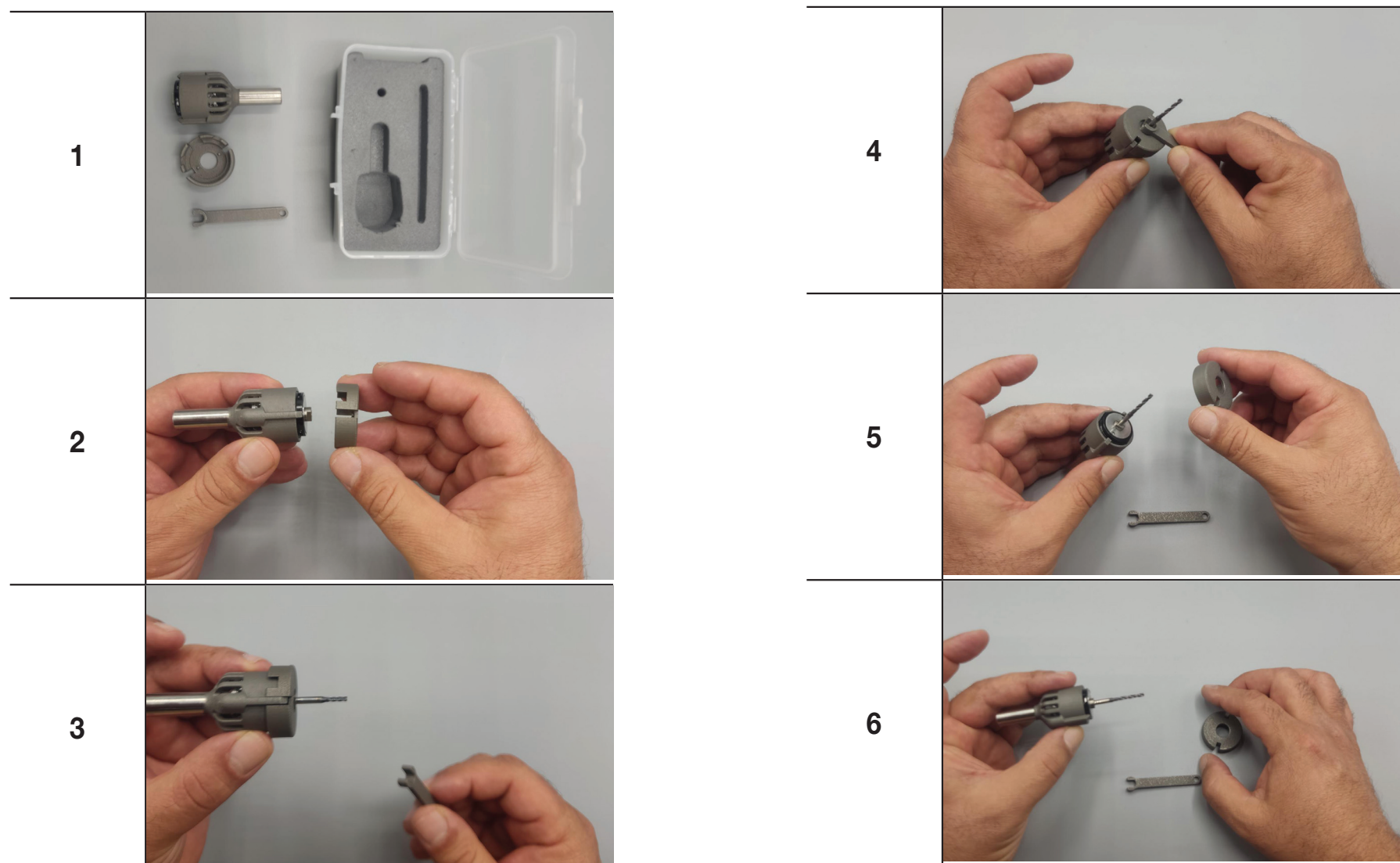


## Tool Installation

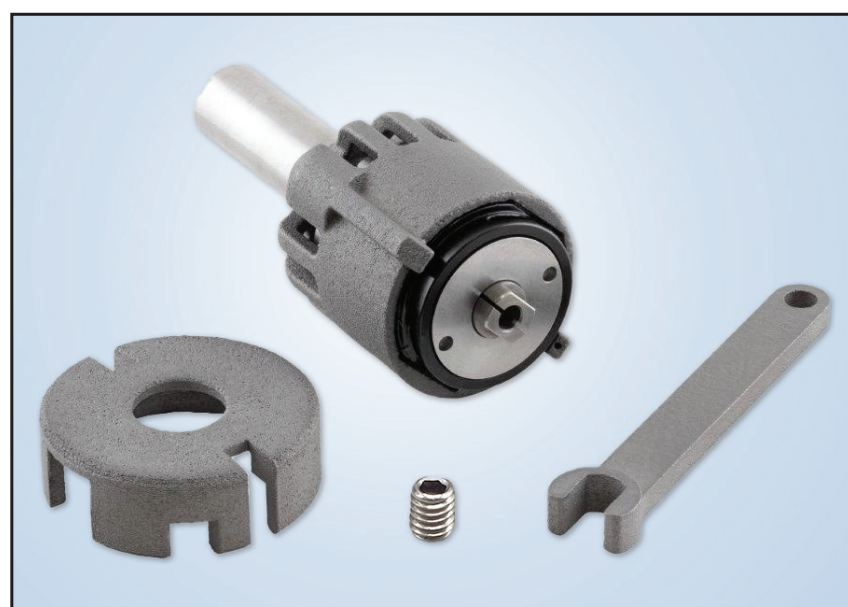


**Click Link to See Short Video** ▶

<https://vimeo.com/854888477/bd5a43b43e>

## Operating Data

JET SPINDLE OPERATING PARAMETERS				MICRO 00	
HIGH PRESSURE COOLANT (BAR)	15 BAR	40 BAR	TERMS OF USE		
Min Coolant Supply Diameter [mm]	4		Collet	3.175 ,3.0 ,2.0 ,1.6	
Min flow rate (L/min)	12	20	Accessories	ST 20X100 ER16	
Rotational spindle speed [RPM]*	18,000	40,000		ER16 SEAL 10	



\*Insert the cutting tool completely in the collet, then retract the tool to 1XD and tighten it using both keys as shown in the picture.

\*Plug with a hole to pass coolant through the unit



### JET SPINDLE OPERATING PARAMETERS

#### MILLING

- Slotting - up to  $D=3.0\text{mm}$  &  $a_p=0.05D$
- Shouldering - up to  $D=3.0\text{mm}$ ,  $a_e=0.1D$  &  $a_p=0.1D$

#### THREAD MILLING

- Max. M3 thread

#### DRILLING

- Max drill dia. 2.00mm

#### DEBURRING

- Max tool dia. 2.00mm
- Can use 45 to 60 degree end-mill

#### ENGRAVING

- Max tool dia. 3.00mm
- Max  $A_p$  0.25mm

### BAR

### Idle Speed RPM

15	18,000
20	23,000
25	27,000
30	31,000
40	40,000

Cutter [mm]	P	M	SST	N	S
Drilling	2.0 - 0.1				
Ball-Nose	3.0 - 0.1				
Chamfering	3.0 - 0.1				
Lollipop	3.0 - 0.3				
Milling	3.0 - 0.3				
Deburring	2.0 - 0.1				
Engraving 45 / 60 Degree	3.0 - 0.1				