

HPC milling cutter

for MQL machining

MQL distributor

Advantages MQL distributor:

- absolutely uniform distribution of the oil / air mixture
- „smooth transport“ by special plastic hoses
→ therefore significantly faster response time



protected by patents!



Example MQL:

Workpiece	Cylinder head – fire face
Material	G-AlSi9
Tools	HPC milling cutter, dia. = 125 mm, cutting edges = 27, HSK 63-A
Cutting speed	$v_c = 4,710 \text{ m/min}$
Revolution	$n = 12,000 \text{ rev/min}$
Feed per tooth	0.11 mm
Feed rate	35,640 mm/min
Achieved surface finish quality	$R_z = 2-4$