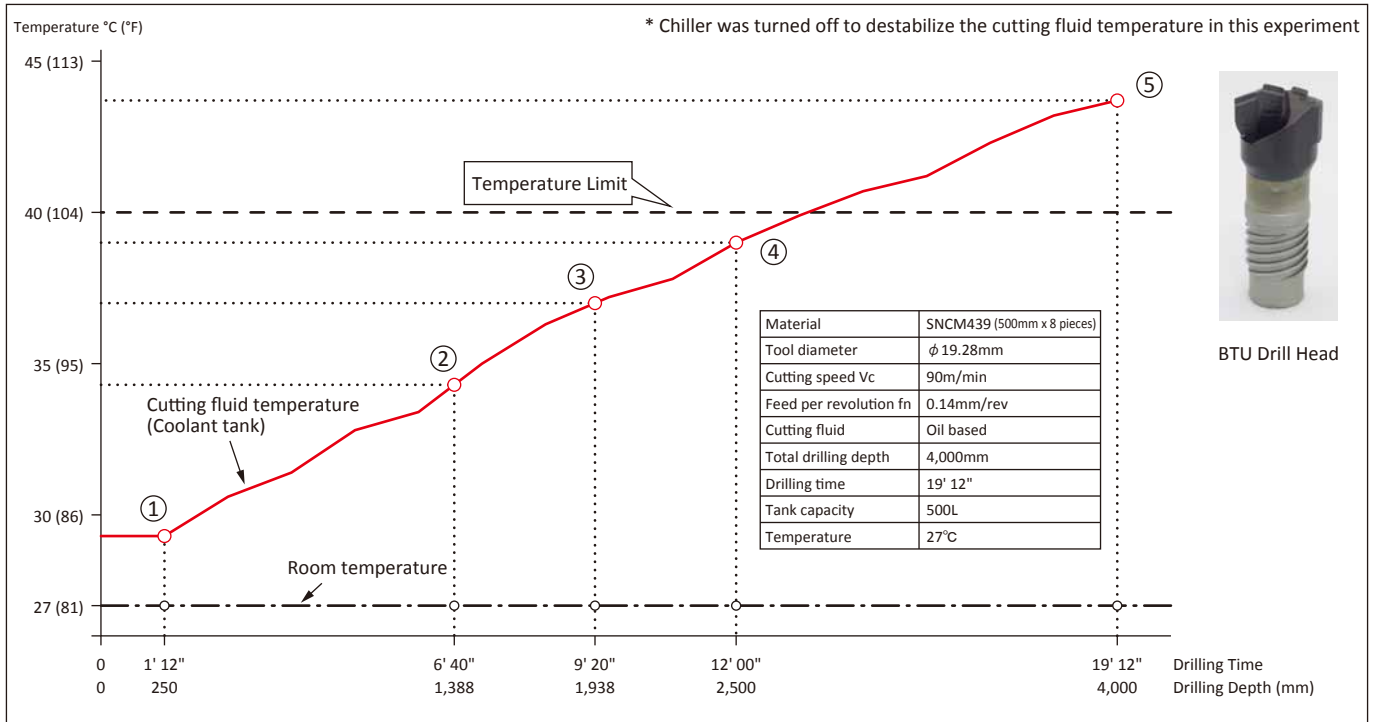


# Cutting Fluid Temperature and Chip Formation

## Cutting Fluid Temperature Change

Cutting fluid temperature keeps rising if a chiller is not used in deep hole drilling.



## Cutting Fluid Temperature and Chip Formation



*Chip evacuation is much more essential for successful deep hole drilling than for general metal working. It is very important to keep cutting fluid temperature constant using a chiller during the drilling operation so that stable chip formation can be maintained which contributes to good chip evacuation.*

Please refer to our technical information "Cutting Fluid Management" for cutting fluid function. (<http://www.unitac.co.jp/pdf/UT10004E-A.pdf>)