

## **Drilling with Solid Carbide Drill & Sovereign Fortune Force The Intelligent High Clarity, High Force Coolant Delivery System**

“One can get many times greater Speed, Feed and Tool life with **Sovereign Fortune Force** while drilling with carbide”.

“Few simple things needed are”:

- Drills with acceptable Run-Outs
- High quality Tool Holders – Shrink Fit Holder OR Collect with Seal Disc is recommended
- Minimum 8% concentration for normal Mineral Oil Based Emulsion and Higher Concentration for Synthetic Coolant to provide the desired Lubricity.
- Coolant Flow in the ratio of 45 lpm per 25 mm Drill Diameter
- Coolant Hole preferably in Secondary Grind to ensure Good Coolant Flow

“With C5 Tin Coated Carbide, one can drill at approx. 250 Mpm on Stainless Steel Component and at 610 Mpm on Aluminum – this you will agree is a Remarkable Surface Speed”.

“With **Sovereign Fortune Force** it is possible to Feed the Drills Harder & Faster”.

“Feed up to 150% of Tool Manufacturer’s Recommendation is Normal and Possible”.

“It is common to get up to 100% Productivity Increase with **Sovereign Fortune Force**”.

“It certainly helps to do things right and do it the modern way with **Sovereign Fortune Force** to stay ahead in business”