

**Eliminate Thermal Shock & Enhances the Tool Life with  
Sovereign Fortune Force  
The Intelligent High Clarity, High Force Coolant Delivery System**

“With conventional Low-Pressure Low Volume Coolant Delivery (Flood Coolant), the cutting Edge of the Tool attains a very high temperature as it enters the ‘Point of cut’ and stays hot until it finishes the cut and is exposed to an External Thermal Shock with the conventional Flood Coolant that quenches the exposed Tool”.

“Most Cutting Tool Manufacturers recommend ‘Wet Turning’ but they ask you to Mill Dry though the Material of Tool and the Work piece are identical in Milling as in Turning and the fact that there may be only 3 or 4 passes per minute and therefore only 3 or 4 Thermal Shocks. With Milling, every time the Cutter makes a full rotation, each Insert gets Hot and then Quenched. With conventional Flood Coolant, a Face-Mill running at 1000-RPM subjects every insert to a 1000 ‘Damaging Quenches’ every minute.

“This rapid cycling between High Temperature and Quenches can be more damaging than heat or wear. Tooling Manufacturers recommend Dry-milling because they believe that the continual heat and the chip damage is better than Thermal Shock Damage. You don’t have to compromise and settle for such a trade off with **Sovereign Fortune Force** - the Intelligent High-Clarity High-Force Coolant Delivery System”.