

Significant Advantages in Milling with Sovereign Fortune Force The Intelligent High Clarity, High Force Coolant Delivery System

- Problem with Conventional Milling methods such as Dry or with Low Pressure – Flood Coolant is really about Managing Heat.
- Softer Metals such as Aluminum melts, and sticks to the 'Cutting Edge' as a 'Build-up-Edge'.
- This 'Build-up-Edge' gets larger and breaks to shock the 'Tool-Edge' and the Work Piece.
- This rugged 'Build-up-Edge' gets dragged before breaking up causing Inconsistent Finish. This is one reason, there are Dull-Streaks in Mild Steel where there are build up edges and Shiny-Streak where the 'Tool-Edge' is Clean.
- The Surface Finish with **Sovereign Fortune Force** in Milling is many times superior, as it provides substantial Lubrication through High Force Volume Flow.
- Few simple yet common requirements of **Sovereign Fortune Force** - High Clarity High Force Coolant Delivery on:
 1. **Spindle Power**
 2. **RPM**
 3. **Tool Rigidity** – The Tooling must be Designed for High Force Coolant.
- There are few options with End Mills & Holders
 1. Coolant Nozzles in the End Mill will be an Excellent Option.
 2. Shrink-Fit Holder or Collets with Seal Disk is a requirement.
 3. The Simple and Efficient Option can be Collect with Seal Disk just a Size Larger with 'O' ring removed - This ensures Desired Coolant Force while Milling.
- Exotic Alloys respond much favorably while Milling with High Force Coolant. With Titanium the results are Spectacular.
- Milling Inconel with carbide is 3 Times Faster with Tool-life Enhanced Many Times More.
- Slots of pockets in Milling cause a problem of Chip Re-Cutting, But with **Sovereign Fortune Force** - High Clarity High Force Coolant through feed delivery, Milling virtually to any depth is no more a challenge.
- **Sovereign Fortune Force** - High Clarity High Force Coolant Delivery does not work harden and often helps to cut at twice as fast.
- With **Sovereign Fortune Force** - High Clarity High Force Coolant Delivery, there is an Effective and Efficient Temperature Control and no built up edges. However, the Coolant must Hit the Cutting Edge at a Correct Angle and Point where the chip is cut.