

Programming SOLO 1000

Programming Steps:

1. With No Spindle rotation; pass through the work piece (blade is retracted) EV = Fwd Feed.
2. Activate Spindle in normal clockwise rotation (blade will extend within rated Head Speed i.e. 1000RPM or higher)
3. Dwell a minimum 1 second to allow insert to fully extend
4. Turn Coolant on at this point
5. Back Feed and Machine your work piece. AR = Working Fee
6. Travel out of work piece. EV = Forward Feed
7. Spindle Stop, speed rate:0 (blade will retract)
8. Dwell min. 1-2secs.
9. With stopped spindle retract the tool from the work piece (blade is retracted; speed rate is 0). ER = Rapid Back Feed

Attention:

The Blade will move out sooner than the tool rated but cutting should only be made at the 1000rpm rated speed.

Important: Do not run dry! Coolant to blade must be adequate.

Programming SOLO S2

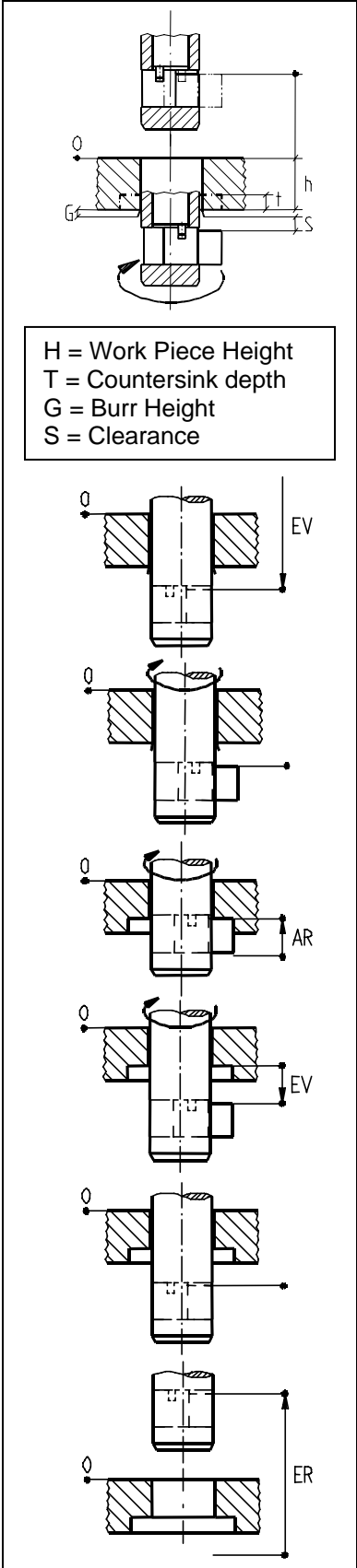
Programming Steps:

1. With 1500 RPM spindle rotation, pass through the work piece (blade is retracted). EV = Fwd Feed.
2. Slow spindle Max 500 RPM in normal clockwise rotation (blade will extend).
3. Dwell a minimum 1 second to allow insert to fully extend.
4. Turn Coolant on at this point.
5. Back Feed and Machine your work piece. AR = Working Feed
6. Travel out of work piece. EV = Forward Feed
7. Increase spindle speed >1500 RPM, speed rat: minimum 1500 RPM (blade will retract).
8. Dwell minimum 1-2 seconds.
9. With spindle rotating at 1500 RPM retract the tool from the work piece (blade is retracted; speed rate is min 1500). ER = Rapid Back Feed

Attention:

The SOLO S2 works on the opposite principle of our standard SOLO tool heads. The cutting blade is always active (in the cutting position) until the spindle speed reaches 1500 RPM or higher. Please remain under 500 RPM when cutting. The blade will move in sooner than the tool head rating but cutting should only be made below 500 RPM.

Important: Do not run dry! Coolant to blade must be adequate.



Material	Speed Surface footage are recommendations only; Remember you must run the minimum of your rate Tool Head (reduce for interrupted cuts)	Feed (ipr) Based on bore Ød : Counterbore ØD ratio Rt=ØD/Ød	
		Rt<1.6	Rt>1.6
Aluminum	600 - 800	.004-.008	.0020-.0030
Stainless Steel	140-300	.003-.005	.0008-.0015
Titanium	60-180	.001-.003	.0008-.0015
Inconel	40-90	.001-.002	.0007-.0012
Cast Iron	260-400	.004-.007	.0010-.0025
Carbon Steel	210 - 350	.003-.006	.0010-.0020