GORTON

1-22

MASTERMIL

Operator's Manual

3353

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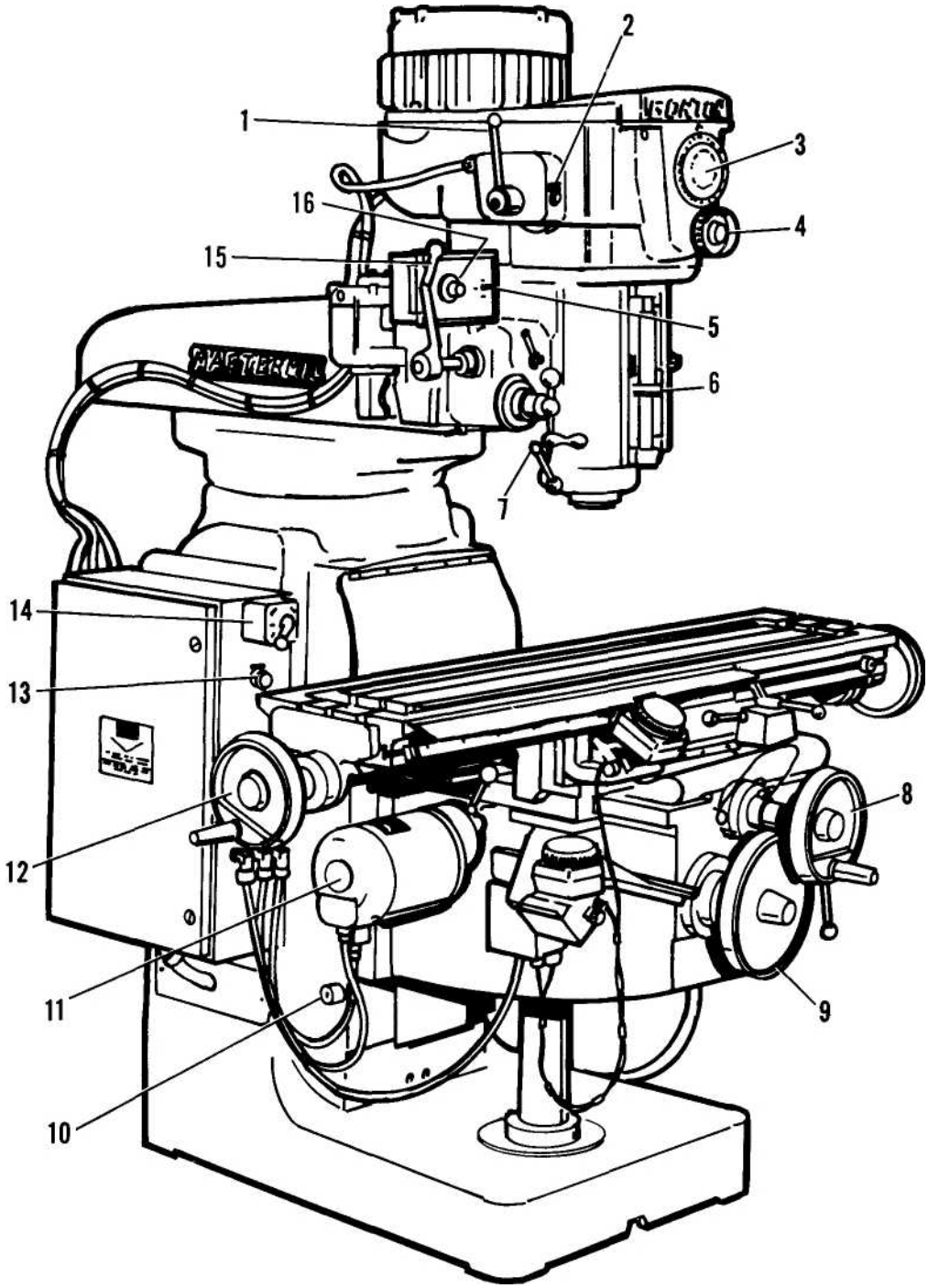

Figure 1. Gorton Model 1-22 Mastermil With Variable Speed Head

1. Spindle Brake Lever
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3. Spindle Speed Indicator Dial
4. Spindle Speed Selector
5. Spindle Feed Direction Switch
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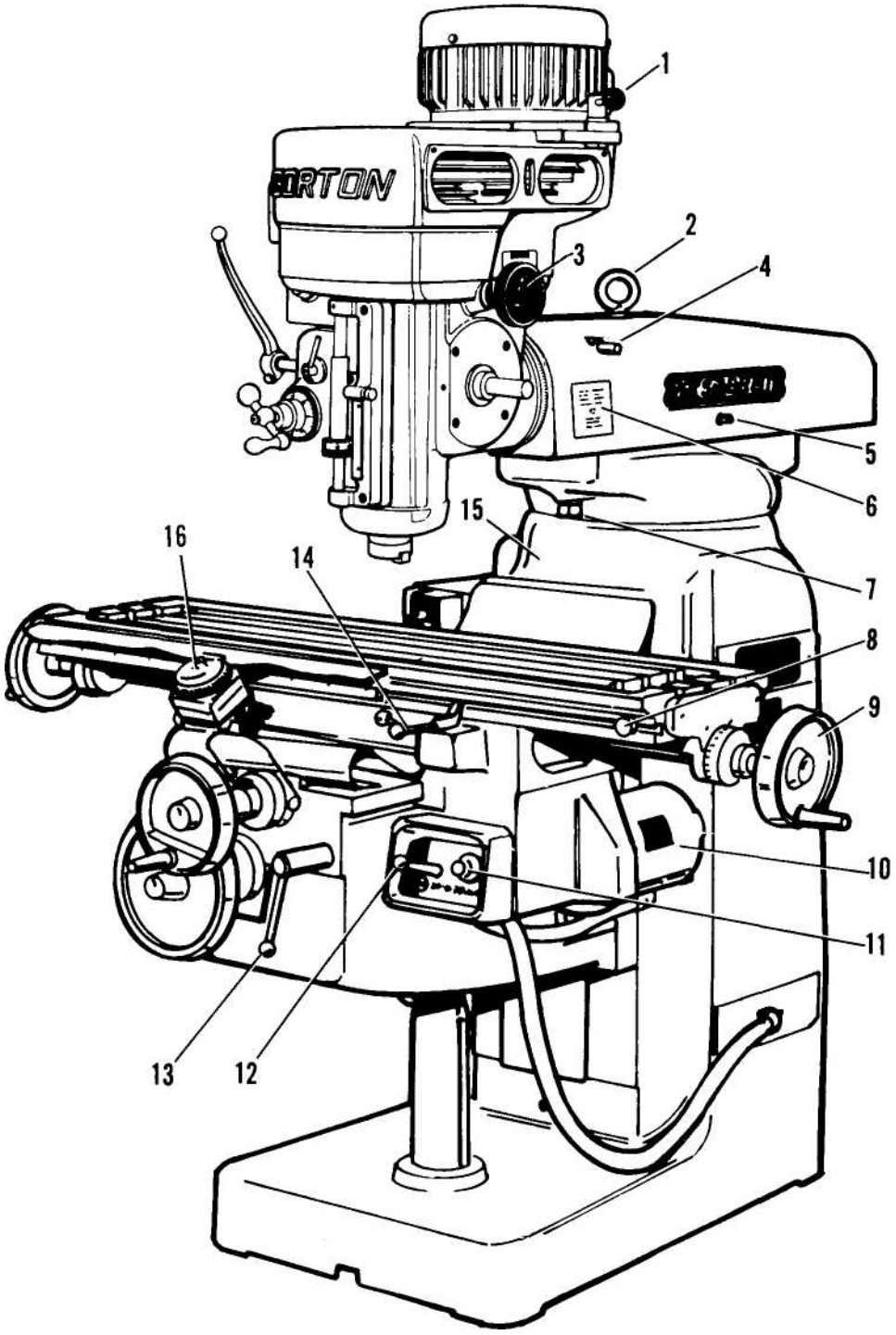

Figure 2. Gorton Model 1-22 Mastermil With Standard Head

1. Motor Locking Lever
2. Lifting Hook
3. High-Neutral-Low Speed Range Selector
4. Head Adjusting Shaft
5. Ram Positioning Gear Shaft
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OPERATION
STANDARD AND VARIABLE SPEED HEADS

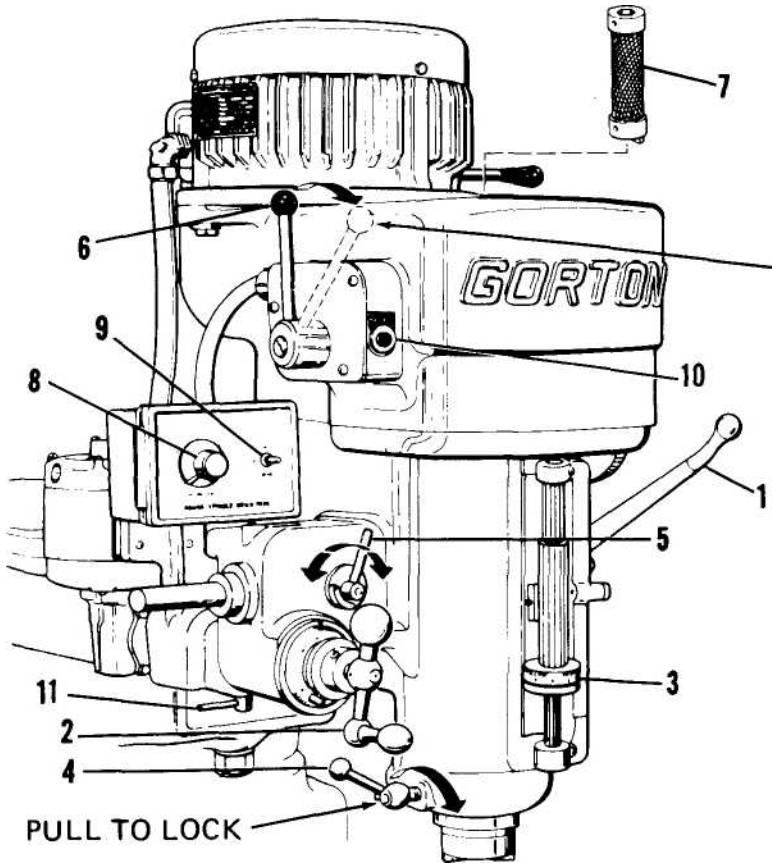

Figure 3. **Standard Head, Left Side**

HAND FEED (Figure 3)

This machine is equipped with a vertical feed lever (1) on the side of the head for fast hand positioning. A micrometer handfeed crank (2) is located on the left side with dial graduated in .100" per revolution for positioning of the spindle/quill within the 4" total travel. A precision micrometer depth stop (3) is mounted on the front of the head housing. This depth stop has a graduated scale and micrometer dial. The dial can be locked in any position by tightening the knurled knob on the center front of the depth stop bracket.

To move spindle by lever (1) unclamp quill lock (4) by pushing to rear. Place operating lever (5) to left position and move spindle to desired position against depth stop (3) with lever. Clamp by pulling lever (4) toward operator.

To move spindle by micrometer handfeed crank, quill lock (4) is pushed to rear to unlock, and operating lever (5) is positioned at right.

NOTE

It may be necessary to move quill slightly with lever (1) to engage clutch.

Quill can then be positioned with micrometer hand crank to desired position. Clamp by pulling lever (4) toward operator.

POWER FEED (Figure 3)

When machine is equipped with infinitely variable power spindle downfeed, a feed rate selector (8), .250" to 3" per minute and direction selector (9) are located on the control panel, and downfeed clutch lever (11) is located beneath the gear box.

OPERATION
STANDARD AND VARIABLE SPEED HEADS

To engage power feed, the hand feed micrometer crank is engaged (steps outlined under Hand Feed) and clutch lever (11) is engaged (back position). The desired downfeed rate is selected (dial 8) and feed is engaged by moving selector (9) to "down" position. Depth is established by micrometer depth stop (3). Upon reaching depth stop, feed motor continues to drive through overriding clutch (clicking noise) until direction is reversed.

CONTROL OPTIONS (Figure 3)

Feed rate can be changed in the cut by moving dial (8). Feed direction can be changed or stopped at any time by resetting direction selector (9). Disengaging clutch (11) only permits movement of quill by hand crank (2). Disengaging lever (5) only permits movement of quill by lever (1). It is suggested that operator check out these options of control prior to actual boring operations.

INSERTING COLLETS/ADAPTERS (Figure 4)

The milling heads are available with No. 9 and 10 B.& S.. No. 30 and 40 N.S. or R-8 spindle tapers. All tapers utilize draw bars to hold collets, cutters or adapters. All spindle draw bars are inserted into the spindle from the top and the thrust collar threaded onto spindle (left-hand thread) with draw bar square end protruding. The thrust collar will retrain in place unless draw bar must be removed. The thrust collar is not used with the 30 N.S. and 40 N.S. spindles.

CAUTION

Be sure inside of spindle nose and shank of adapter are clean and dry before assembling.

With draw bar inserted into spindle, place special draw bar wrench extension (7) into upper spindle opening and engage to head of draw bar.

NOTE

When spindle taper is 9 B.& S. or 10 B.& S., a nut must be threaded (L.H.) onto the top of the spindle. Use key drive of draw bar wrench extension to thread the nut onto spindle. This nut is placed on top of the draw bar.

Pull brake lever (6) forward to lock spindle from rotation. Insert adapter into spindle nose and thread draw bar into adapter - turning draw bar wrench extension with wrench. Draw adapter up into spindle taper until adapter is tight in spindle. Now back off with wrench, then snug up. This is to insure relieving partial tension on draw bar so adapter will not become locked in spindle taper through temperature change of spindle at high R.P.M. REMOVE DRAW BAR WRENCH EXTENSION.

To loosen adapter, set spindle brake lever and apply wrench/extension to draw bar; turn counterclockwise - tapping wrench sideways is permissible. Initial movement loosens draw bar hold on adapter; continued movement forces adapter out of spindle nose. DO NOT USE HAMMER ON TOP OF DRAW BAR.

When inserting adapter into No. 30 or 40 N.S. spindle nose, be sure that driving keys of spindle do not "hang up". The adapter must mate with the key drive of the spindle and be drawn securely into the spindle taper through threading of the draw bar into the adapter.

OPERATION
STANDARD AND VARIABLE SPEED HEADS

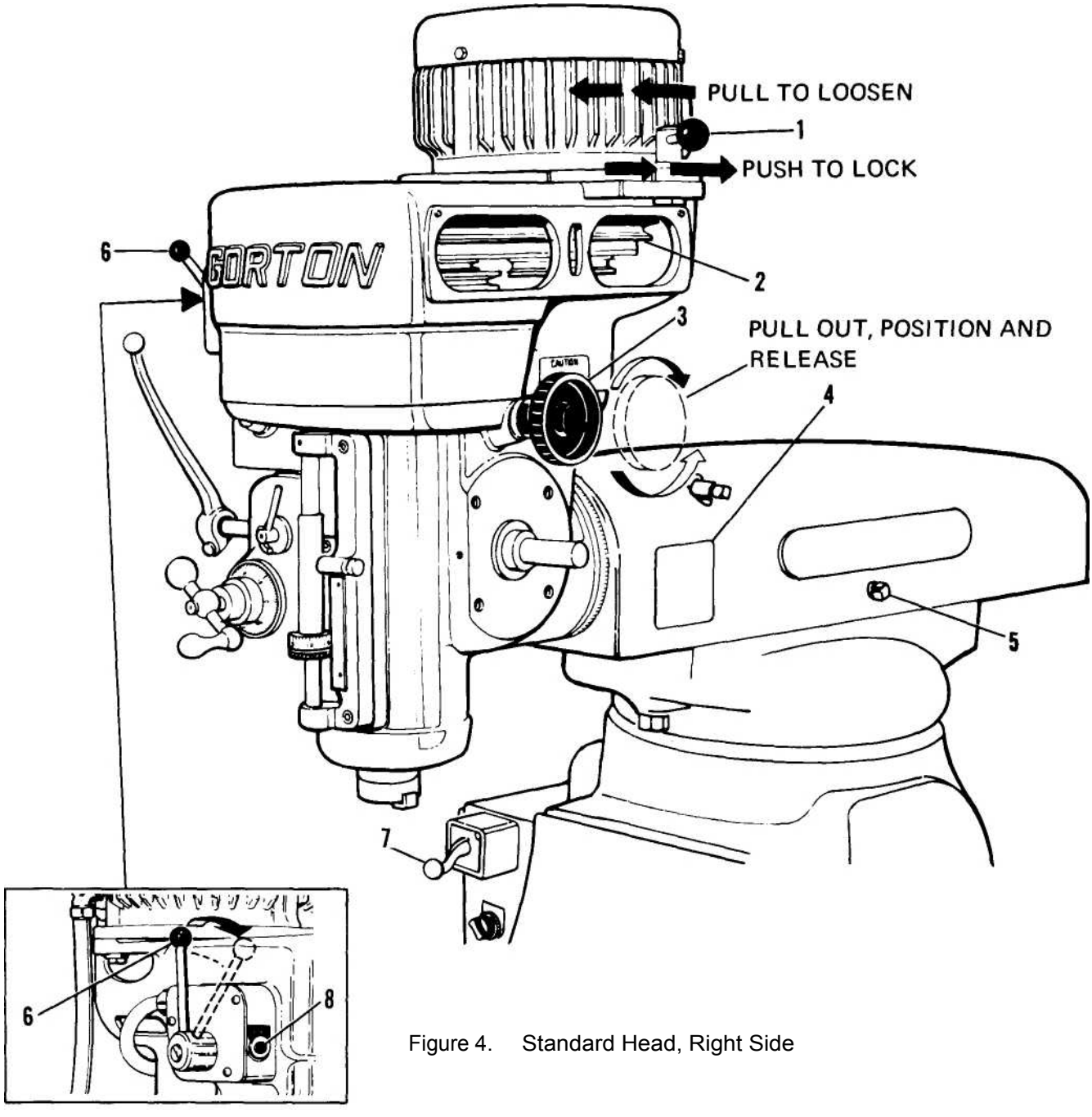

Figure 4. Standard Head, Right Side

TO PLACE IN OPERATION **SPINDLE (Figure 4)**

CAUTION

Before starting spindle, be certain that draw bar is removed or is firmly engaged in adapter, collet or cutter.

Be certain that V-belt (standard head, 2, figure 4) is engaged (spindle motor pushed to rear and locked) and that brake lever (6, figure 4) is released - push to rear. Place High-Neutral-Low speed range selector (3, figure 4) on right side of head in desired position. Refer to spindle speed plate (4)

OPERATION
STANDARD AND VARIABLE SPEED HEADS

for belt position on pulleys to obtain desired speed range setting (for standard head).

CAUTION

Do not attempt to position High-Neutral-Low selector while spindle is running. When "H-N-L" selector is in "N" position, the spindle may be rotated freely for indicating or similar operations to facilitate set-ups.

Place the "FORWARD-REVERSE" switch (7) in the desired position for direction of spindle rotation.

Push spindle start button (8, figure 4) on the head, adjacent to the brake lever, to start spindle motor. To stop the spindle, pull brake lever (6, figure 4) forward. When brake lever is forward (on), push button will not start spindle. Brake lever must be in OFF position to start spindle.

TO CHANGE SPINDLE SPEEDS (STANDARD HEAD) (Figure 4)

Pull brake lever (6) forward to stop spindle motor. Place the High-Neutral-Low selector (3) in desired position - pull out, rotate to desired position and release. Grasp motor locking lever (1, figure 4) and pull to front - motor will pivot on left side mounting bolt until stop is reached. Belt tension will be released and belt will be loose enough to slip into new position.

Reach through openings in right side of head housing and position belt (2) at new pulley position. Refer to spindle speed plate (4) on side of ram for belt position on pulleys to obtain desired speed setting. With belt in proper position, grasp motor locking lever and push to rear. Motor will pivot to place tension on belt. Continue pushing lever to rear to lock spindle motor in position.

Check to determine that brake lever (6) is pushed to rear and cutter area is clear - then push start button (8) next to brake lever to start spindle motor.

TO CHANGE SPINDLE SPEEDS (VARIABLE SPEED HEAD) (Figure 5)

The variable speed head design provides infinitely variable spindle speed ranges of 65 to 460 R.P.M. in low range and 650 to **4600 R.P.M.** in the high range. **SPEED CHANGES SHOULD ALWAYS BE MADE WITH THE SPINDLE RUNNING.**

The High-Neutral-Low selector (1) is utilized to place the head in the desired low or high range. When "H-N-L" selector is in "N" position, the spindle may be rotated freely for indicating or similar operations to facilitate set-ups.

To change speed within a range (spindle rotating), rotate clamping screw (2) clockwise for release. Grasp speed changing knob (3) and rotate clockwise to increase speed - counterclockwise to decrease. Rotate knob until speed dial (4) reaches desired setting. Reclamp screw (2) by rotating counterclockwise.

To change from one range to the other, i.e. 460 to 4600 R.P.M., stop the spindle motor by pulling brake lever forward. Grasp High-Neutral-Low selector, pull out, rotate to desired position and release it.

Check to determine that brake lever (5) is pushed to rear and cutter area is clear - then push start button (8, figure 4) next to brake lever to start spindle motor.

The instructions on the side of the head, "RUN SPINDLE THROUGH THEIR ENTIRE RANGE DAILY" must be done to insure free operation of variable pulleys.

OPERATION
STANDARD AND VARIABLE SPEED HEADS

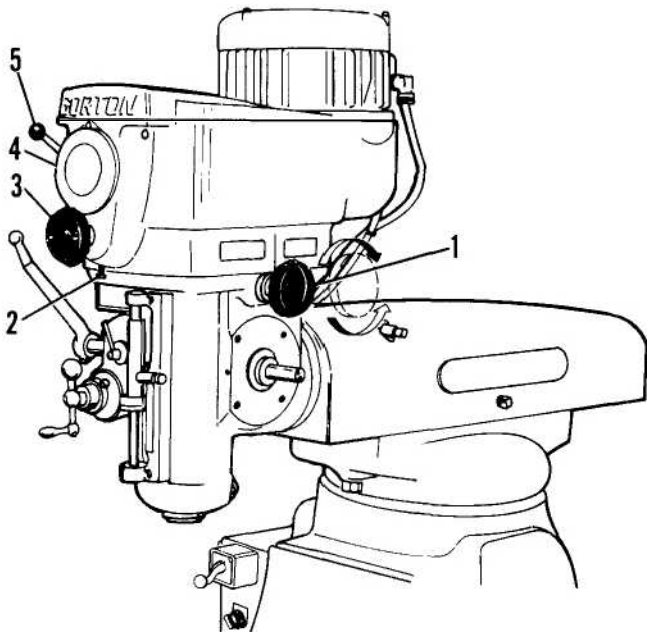

Figure 5. Variable Speed Head

SWIVELING THE MILLING HEAD (Figure 6)

The milling head can be swiveled 90' to the left or right of vertical. For accurate setting, the swivel joint has an index ring (1) graduated in degrees. To swivel the milling head, proceed as follows:

1. Loosen the three nuts (2, one not shown).

2. Use the socket wrench (3) furnished with the machine and rotate the head adjusting shaft (4). This operates a worm and worm gear to swivel the head.

To avoid damage to the worm and gear, exert necessary hand pressure against top or bottom of the milling head when it is being swiveled.

3. Re-tighten the three nuts (2) when desired angle position is reached.

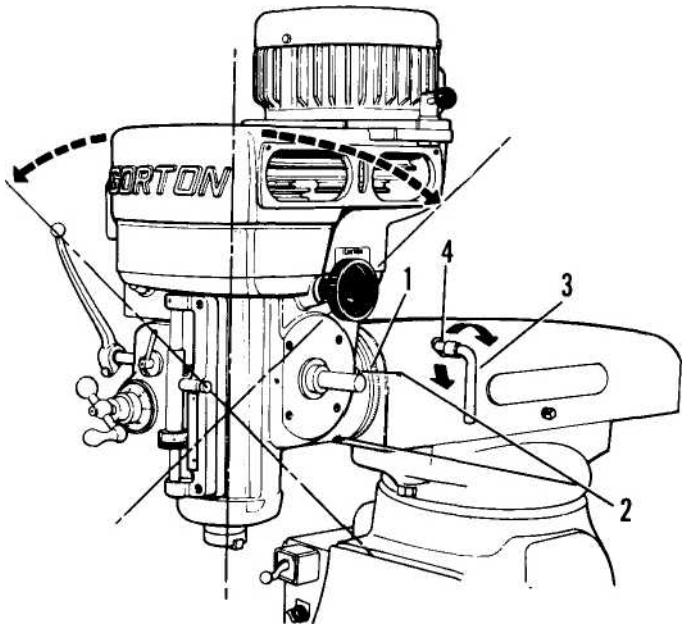

Figure 6. Swiveling The Head

OPERATION
STANDARD AND VARIABLE SPEED HEADS

TO ADJUST RAM (Figure 7)

Loosen front and rear ram clamping bolts (2) with open-end wrench furnished with machine. Ram positioning is accomplished through rotation of ram positioning gear shaft (1) located on right side of rain. Apply socket wrench furnished with machine to shaft extension. Retighten front and rear clamping bolts after ram adjustment.

CAUTION

Clean ram slide before moving. Foreign matter between surfaces will cause spindle to table top misalignment.

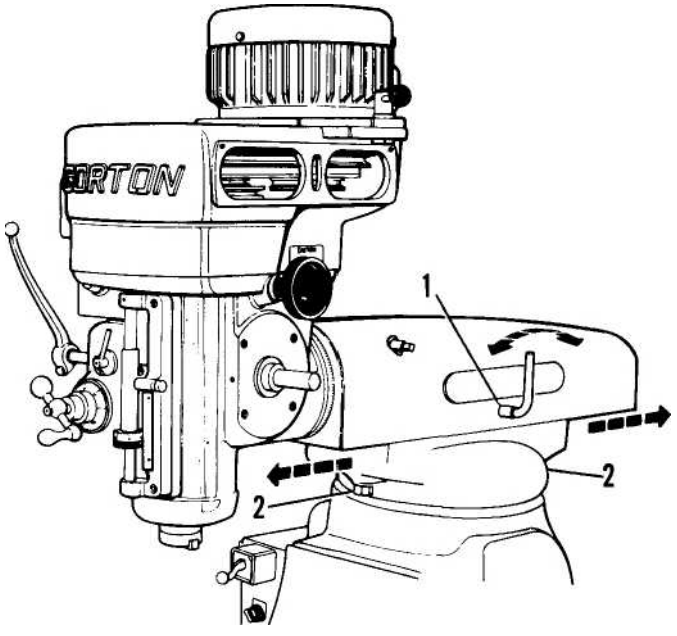

Figure 7. Adjusting The Ram -

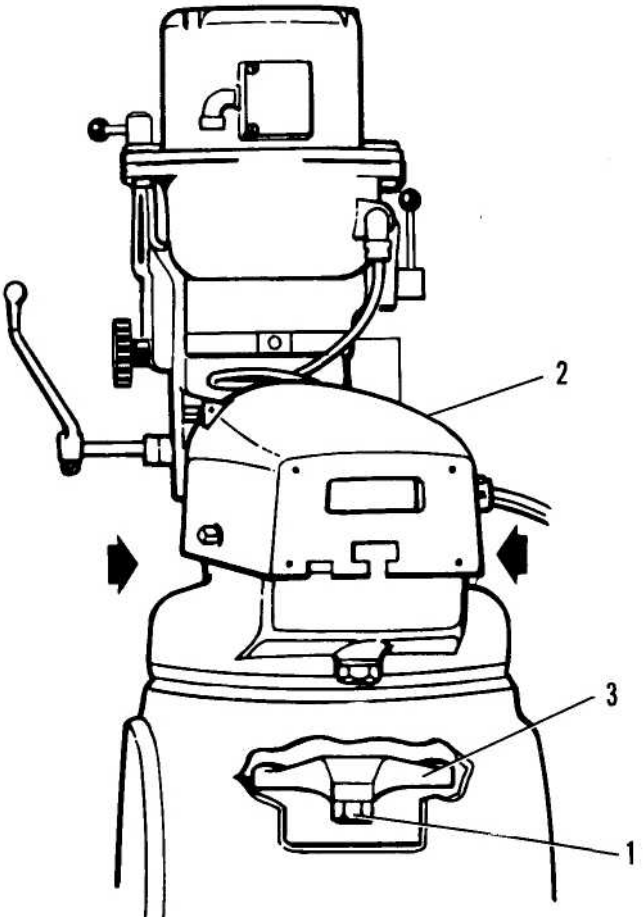

Figure 8. Swiveling The Turret (Cutaway To Show Spider)

SWIVELING THE TURRET (Figure 8)

The ram and turret can be swung 90^{0} to left or right of the center position to aid in working on long parts. To swivel the turret proceed as follows:

1. Loosen the spider clamping screw (1) (accessible through hole at rear of column). Do not loosen the large nut in the center of the spider.

2. Push the ram (2) to the desired position, left or right, and retighten the spider clamping screw.

LONGITUDINAL/ CROSS FEED

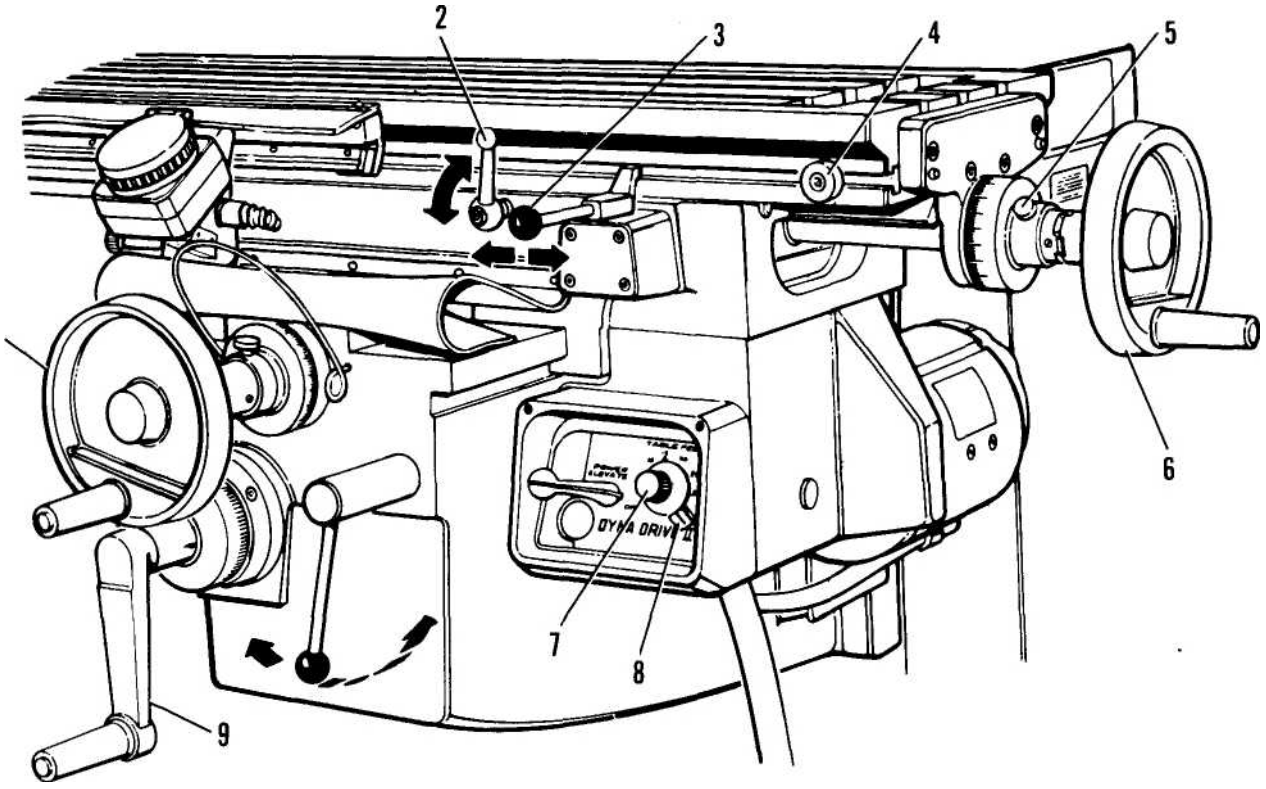

Figure 9. Longitudinal Feed, Manual-Power

MANUAL FEED - TABLE & SADDLE (Figure 9)

Table and saddle feed and positioning are accomplished by means of conveniently located, manually rotated handwheels. The table handwheel (6) is of clutch-type (press in to engage) and the cross feed handwheel (1) is pinned. Both are equipped with adjustable micrometer dials.

The cross feed handwheel (1) is located at front center of knee. The table feed handwheels (6) are located at the ends of the table. The table clamping lever (2) is at center position. The saddle clamping lever is located on the left side of the saddle (not illustrated).

Adjustable longitudinal stops (4) are provided.

CAUTION

When feeding or positioning under manual control, stops should be located against fixed limit stops to avoid damage to power feed mechanism. Stops cannot be positioned beyond limits of travel of longitudinal motion (factory installed fixed limit stops).

Prior to moving either axis, the clamp (s) should be released and location of adjustable stops should be checked. To feed saddle in, rotate handwheel (1) clockwise; to feed out, rotate counter-

clockwise. To feed table to right, rotate handwheel (6) clockwise; to feed left, rotate counterclockwise.

CAUTION

Do not engage and lock handwheels to shafts. This causes overload to motor when operating under power feed and is a hazardous practice which could cause personal injury.

NOTE

For manual/power adjustment of knee, see section ELEVATE-KNEE.

POWER FEED - TABLE (Figure 9)

When the machine is equipped with infinitely variable power feed to table, you can dial any feed range from .6" to 35" per minute. Rapid traverse rate 35" per minute (full feed rate). Feed rate control is by means of selector dial (7) located on Dyna-Drive control.

Suggested sequence to engage power longitudinal feed:

1. Machine power switch (main electrical control panel) in "on" position.

2. Power downfeed switch (8, figure 3) (when installed - located in upper left corner of downfeed control panel) in "click-off" position (electrically interlocked with table drive).

3. Release table clamp (2).

4. Place direction lever (3) for table in neutral position.

5. Rotate feed rate selector dial (7) clockwise to desired setting.

NOTE

When dial is moved from stop setting, the Dyna-Drive is set in motion to longitudinal gear assemblies - ready for feed selection.

6. The lucite (plastic) lever (8) can be moved to the selected feed position. It serves as a memory device to indicate the feed rate being used. The operator can rotate the feed rate selector dial from the setting being used for rapid traverse feed rate and then can turn the dial back until it stops against the lucite indicator. This saves time in locating the exact feed rate being used after going to rapid traverse.

The operator can override the lucite indicator by exerting extra pressure to rotate the feed rate indicator dial back to zero.

7. Select direction of motion of table desired with table direction selector (3). Engage feed lever (3) for direction of travel.

8. Adjust feed dial (7) setting for efficient cutting condition as determined by cutter diameter and material. **FEED RATE CAN BE CHANGED IN THE CUT.**

NOTE

Return dial to stop setting when feeding by hand.

9. Position longitudinal adjustable stops (4) if desired. When engaged in feed motion, the stops contact the actuating lever disengaging feed motion. Permanent limit stops (factory installed fixed stops) determine maximum longitudinal movement. **DO NOT REMOVE THE FIXED STOPS.**

ELEVATE-KNEE

MANUAL ELEVATE **(Figure 10)**

The knee can be positioned manually by the elevate hand crank (1) located on lower left front of the knee. The hand crank which is a clutch type (push in to engage) is equipped with an adjustable micrometer dial.

The knee clamping lever (2) is located on the front of the knee, and should be released when knee is moved.

To raise knee rotate crank (1) clockwise.

To lower knee rotate crank counterclockwise.

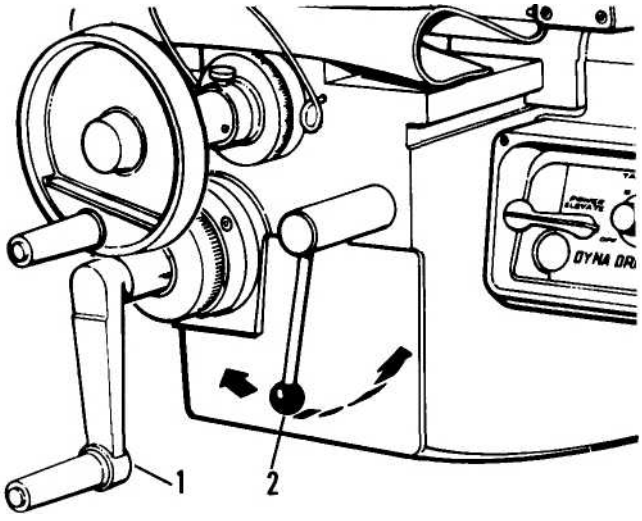

Figure 10. Knee Elevate-Manual

NOTE

When knee is final positioned, rotate crank one turn clockwise to maintain accuracy.

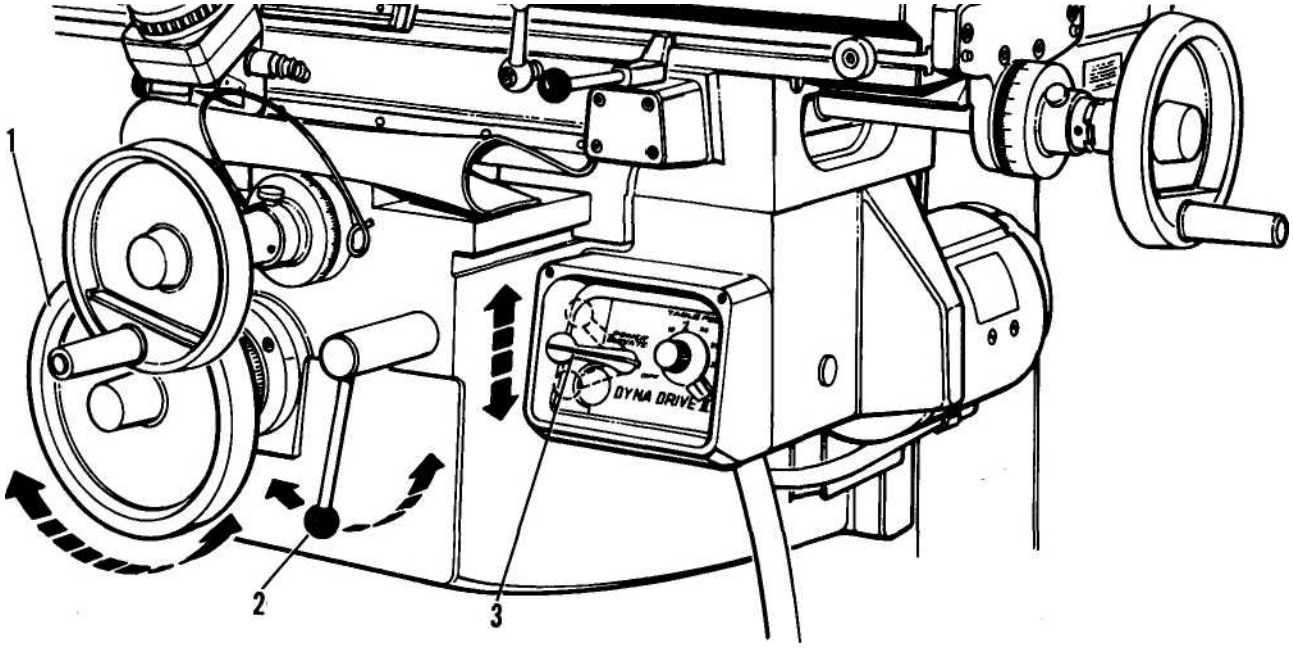

Figure 11. Knee Elevate-Power

ELEVATE-KNEE

POWER ELEVATE **(Figure 11)**

The machine can be provided with power actuated knee for positioning as optional equipment. This control is an assist to the operator in set-up and operation. Positioning is at a fixed rate of 20" per minute. Power elevate is through a separate motor -- not connected to table feed motor.

Directional control (3) for knee power elevate is conveniently located in Dyna-Drive control panel mounted on right side of the knee. Knee clamping lever (2) is located at upper right-hand corner of knee. Manual positioning handwheel (1) is located at left center position.

NOTE

Handwheel is clutch type -- press in toward knee to engage.

Suggested sequence of operation of power elevate control:

1. Machine power switch (main electrical control panel) in "on" position.

2. Release knee clamp (2) rotating lever clockwise (to left).

3. Move control lever (3) in desired direction of travel. Switch is directional. If lever pulled up, knee will move up; pushed down, knee will move down. When released, control lever will return to neutral position.

NOTE

Coasting of knee following release of lever is to be expected.

Usual operator practice is to rough position with power elevate control and make final setting with manual handwheel. Manual handwheel has adjustable micrometer graduated dial.

CAUTION

Do not move fixed limit stops or limit switches. These units have been located in position for maximum travel. Any change in the location can result in major damage to the feed components.

KNEE LIMIT STOPS (POWER ELEVATE ONLY) (Figure 12)

Limit stops (1, figure 12) are fixed in position on column by factory to determine maximum vertical travel of knee under power. Limit switch (2) on left side (rear) of knee engages stops. Limit stops **do not** allow for cutter or workpiece clearances.

Should the limit switch be actuated by either stop -- the power elevate control will be inoperative through control lever (11). To restore power control, the knee is moved by manual handwheel (11) in an opposite direction until the limit switch is free of the stop. Power control will then be available again through control lever (3, figure 11).

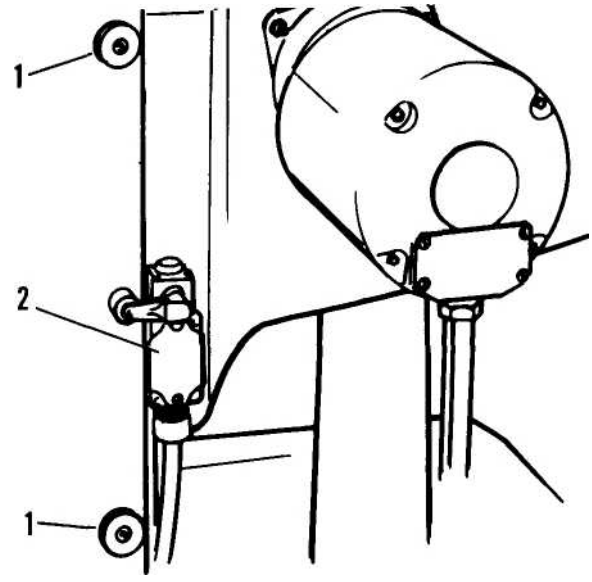

Figure 12. Knee Limit Stops (Power Elevate)

COOLANT SYSTEMS

FLOOD COOLANT SYSTEM

The flood coolant system is self-contained within the machine. The pump/reservoir unit is located within the rear lower column with access provided through the removable plate. The coolant return line is connected to the left table bracket and to the reservoir. A screen is provided in the table to collect chips and foreign material. The supply line has a flexible nozzle and shut-off valve.

The selector switch controlling the pump motor is located on the front surface of the machine electrical cabinet. The pump motor is electrically interlocked with the spindle motor. Stopping the spindle motor will cause the pump motor to stop.

The shut-off on the flexible nozzle should be in the "off position" when starting spindle and prior to stopping spindle. "Prime" will be lost if pump motor is stopped prior to shutting off flow at nozzle.

Keep return line open through removal of material over table screen and from table channels. Clean screen periodically.

Remove reservoir from column periodically and inspect for presence of foreign material. Remove if present to prevent damage to pump.

SPRAY MIST COOLANT SYSTEM

The spray mist coolant system is self-contained with exception of attachment of plant air line to reservoir unit. The unit is mounted to the machine column with air and coolant lines extending to a flexible nozzle with magnetic holder. A thumb screw needle control on the nozzle controls the volume of coolant.

The plant air line connects to the left side of the unit. Pressure should not exceed 125 lbs. The air and coolant lines connect to the right side of the unit. A slotted screw, under the acorn nut on the top left of the unit can be turned to regulate air pressure to the nozzle. A gage indicates air pressure.

The selector switch controlling the unit is located on the front surface of the machine electrical cabinet. The flow of air/coolant is electrically interlocked with the spindle motor. Stopping the spindle motor will halt the flow of air/coolant.

OPERATION

Fill reservoir with water soluble oil (to coolant manufacturer's specifications and consistency to insure non-rust and non-clogging conditions) through filler cap on top right of unit. DO NOT REMOVE CAP WHILE UNIT IS ACTIVATED. A sight gage on front of unit provides visual means of checking coolant level. The drain plug is located directly below the sight gage.

Position magnetic holder/nozzle convenient to cutter. Turn selector switch to "mist", start spindle motor and open thumb screw needle control on nozzle. Direct flexible nozzle at cutter/work position. Spray mist has dual effect, cooling the cutter and moving chips away from cutter.

NOTE

A fine mist directed properly to the cutter will be satisfactory on the majority of materials. Do not reuse coolant.

OPTICAL MEASURING

OPTICAL MEASURING

The Vernac measuring system (optional equipment, figure 13) incorporated into the machine is a direct reading optical measuring instrument for indicating longitudinal and lateral position. Readings from the precision scales affixed to the machine table and saddle are transmitted through a lens system and projected onto illuminated direct-reading dials. Readings projected are in .025" intervals. Fine adjustment of the dial provides measurement to .0001".

The reader unit is mounted to slide with 1" adjustment range. A clamp lever is provided on the reader slide for position clamping. Positioning of the reader slide permits operator to start from even number reading on reader (ref. 10.000) with .0000 " on tenth scale.

NOTE

Considering the units of the system as components of a micrometer will greatly simplify the adjustments in the operator's mind. The scale readings in .025" increments are like the barrel of a micrometer and the double spiral reticle the thimble.

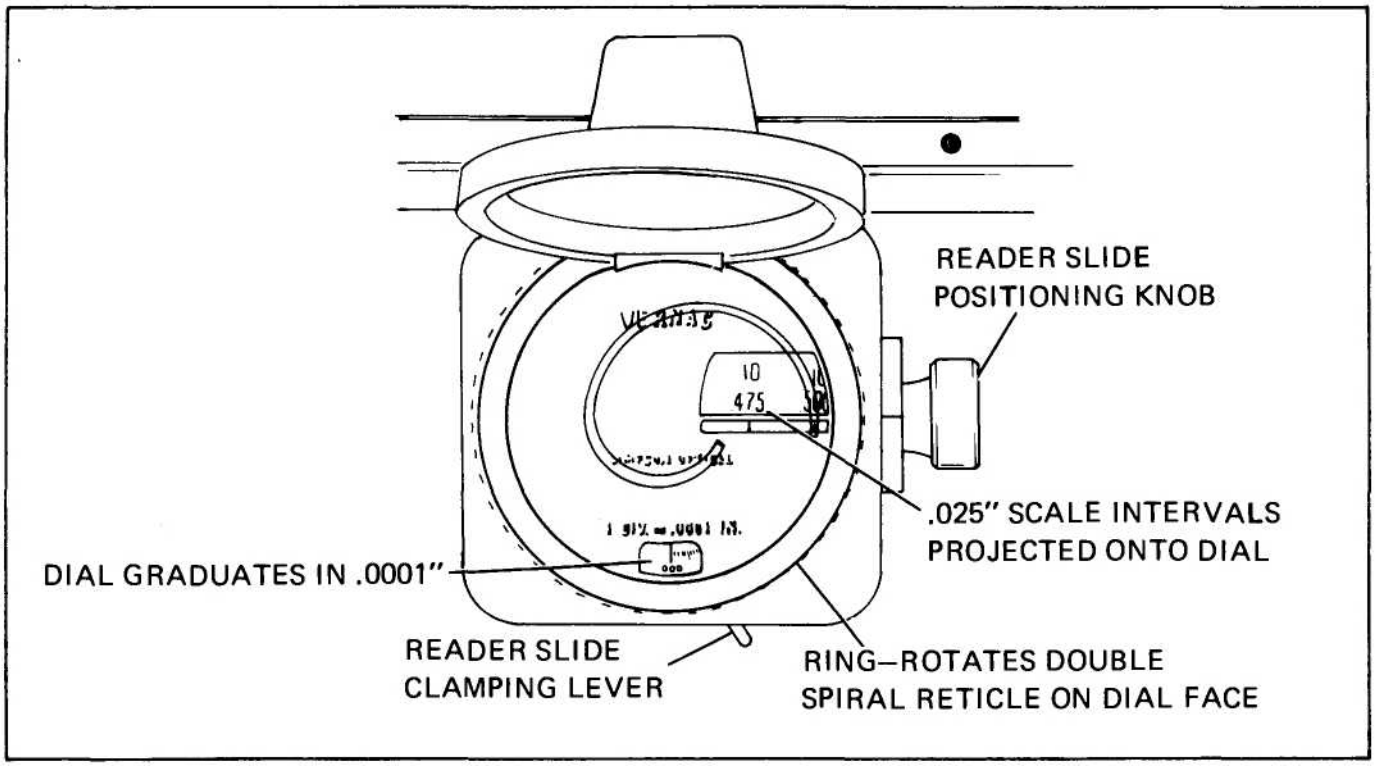

Figure 13. Optical Measuring

OPTICAL MEASURING

OPERATION (Figure 13)

1. Turn on power switch for optic system (switch located on front face of machine electrical cabinet) which will illuminate readers.

2. Set up a reference point on the readers for the cutting tool in relationship to the workpiece.

3. Rotate outer ring of reader to position the double spiral reticle at .000" on the reticle scale.

4. Position the reader on its slide to bracket the .025" mark with the parallel lines of the double reticle and clamp.

5. Note the reading on the scale as this will be the reference point from which all measurements are made.

MOVING TABLE TO LEFT OF REFERENCE POINT

To move the machine table to the left of the reference point, you ADD the dimension to the reference point. Example: reference point 10.500", move 2.0154" to left. Rotate reticle clockwise until .015 mark lines up with line in reading area at bottom of dial. Then continue to rotate dial four division lines for the .0004". total = .0154". Now move table to left with handwheel and bracket the 12.500 line with the parallel lines of the double spiral reticle. Total movement is 2.0154".

MOVING TABLE TO RIGHT OF REFERENCE POINT

When moving the machine table to right, you SUBTRACT the desired movement from the reference point. Example: reference point 10.500", move 2.0154" to right. Move table to right from 10.500" and bracket 8.475" scale mark with double reticle lines (10.500" minus 2.025").

NOTE

With reticle scale at .000", you must go beyond the desired increment (2.0154") to the next .025" scale mark, in this case 8.4750". Then rotate reticle scale clockwise to .0096" (.0250" minus .0154"). Now move table to LEFT and bracket 8.475" scale line.

NOTE

If reticle dial is at any reading beyond .000" which will permit subtraction of increment of movement, it is not necessary to go .025" beyond mark.

OPERATING NOTE

Dial cover should be in closed position whenever reader is not in use. Wipe off immediately any coolant, chips etc., accumulating on the readers and scales. Clean with soft tissue.

OPERATOR TIPS

GENERAL

1. END MILLS that have hand of helix opposite to hand of cut are ideal for profiling. When the cut is on the peripheral teeth only, as when milling disc cams, there is less tendency to chatter, because the thrust of the cut pushes the tool against the spindle thrust bearings. However, when used for an end cut, the left-right design throws the chips down against the work surface, which may be objectionable from a finish standpoint. Also, the end teeth are relatively inefficient because of the pronounced negative rake. On the other hand, if the operator is working to a scribed line, a right-hand helix, left-hand cut tool will allow him to see the line better because the chips and burr will be thrown down along the flute, rather than up on the top surface of the work.

2. RUNOUT OF AN END MILL (beyond .001") will result in a hammering effect and increase the tendency to chatter. The effect can be noticed on the work by a waviness in the surface finish.

3. RIGHT-HAND CUT, RIGHT-HAND HELIX END MILLS tend to pull out of their holders. This is one reason why the set screw type adapter is preferred by many operators over a spring collet.

4. TO ELIMINATE CHATTER, try one or all of these methods: tighten Bibs, use a more rigid workholder, vary the speed and feed rate a bit, move the cutter nearer to the spindle. If all else fails, try using a cutter with a smaller number of teeth. Even a few less will often eliminate a harmonic.

5. STRAIGHT-TOOTH END MILLS do not "pull over". They mill a parallel and vertical keyway, whereas helical flute two-lipped end mills bend and produce slots which lean to one side.

6. TWO-FLUTE END MILLS excel where an end feed is needed, as in plunging to depth in a keyway or pocket. Three and four-flute center cut mills will plunge, but not as freely as the two-flute.

7. FOR SLOT MILLING from an open end four-flute mills are better than two: the slot can be cut faster and more accurately in one pass.

8. CARBIDE END MILLS for keyway milling stand up longer, with less wear, if they have an odd number of teeth. With an odd number, the condition of one tooth just starting to cut and one just finishing directly across is eliminated. The pressures involved are reduced and likewise the cutting edge wear.

9. END MILLS are made to standard tolerances on cut diameter. These tolerances range from plus .000 minus .0015" to plus .005" minus .000" with each manufacturer choosing his own sizes within this range. Check the diameter of the end mill prior to attempting to mill a slot or keyway of a definite size.

10. CLIMB OR CONVENTIONAL MILL-Climb milling offers the advantage of better finish, greater feed per tooth, and a lower rate of tool wear than conventional milling. It is particularly suitable for heat-treated alloy steels and non-free- machining stainless steels because it gives better tool life and reduces work hardening.

It is not recommended for work having a hard scale, because abrasion quickly ruins the cutting edges. In addition, some very soft steels have a tendency to drag and tear. Climb milling should not be used on thin or frail workpieces.

SPEEDS AND FEEDS

SPEED is measured in peripheral feet per minute (revolutions per minute times cutter circumference in feet). This is referred to as "peripheral speed", "cutting speed" or "surface speed". The figures in the table below are suggested starting speeds only. They will have to be adjusted to suit the particular job requirements.

USE HIGHER SPEED RANGES FOR:

Softer materials	Non-metallics
Better finishes	Frail workpieces or set-ups
Small diameter cutters	Hand feed operations
Light cuts	Maximum production rates

USE LOWER SPEED RANGES FOR:

Hard materials	Heavy Cuts
Tough materials	Minimum tool wear
Abrasive materials	Maximum cutter life

FEED is measured in inches per minute. It is the product of feed per tooth times revolutions per minute times the number of teeth in the cutter. Due to variations in cutter sizes, number of teeth and revolutions per minute. all feed rates should be calculated from feed per tooth. Feed per tooth is the basis of all feed rates per minute, whether the cutters are large or small, fine or coarse tooth, and are run at high or low peripheral speed. Because feed per tooth affects chip thickness, it is a very important factor in cutter life. The following should be kept in mind when using the recommended starting feed per tooth.

USE HIGHER FEEDS FOR:

Easy-to-machine materials	High tensile strength materials
Roughing cuts	Coarse tooth cutters
Rigid set-ups	Abrasive materials
Rugged cutters	

USE LOWER FEEDS FOR:

Light and finishing cuts	Frail and small cutters
Frail set-ups	Deep slots
Hard-to-machine materials	Low tensile strength materials
Fine tooth cutters	

SPEED CHART----IN REVOLUTIONS PER MINUTE

Surface Feet Per Minute

Dia.	30	40	50	60	70	80	100	125	150	175	200	250	300	400	500	700	900
1/16	1833	2445	3056	3667	4278	4889	6112	7641	9169	10714	12224	15281	18337	24450	30562	42787	55012
1/8	917	1222	1528	1833	2139	2445	3056	3820	4584	5348	6112	7640	9168	12224	15280	21392	27504
3/16	611	815	1019	1222	1426	1630	2037	2546	3056	3565	4074	5092	6111	8148	10185	14259	18333
1/4	458	611	764	917	1070	1222	1528	1910	2292	2674	3056	3820	4584	6112	7640	10696	13752
5/16	367	489	611	733	856	978	1222	1528	1833	2139	2444	3055	3666	4888	6110	8554	10998
3/8	306	408	509	611	713	815	1019	1274	1527	1784	2036	2548	3057	4076	5095	7133	9170
7/16	262	349	437	524	611	699	874	1092	1311	1530	1748	2185	2622	3496	4370	6118	7866
1/2	229	306	382	459	535	611	764	955	1146	1337	1528	1910	2292	3056	3820	5348	6876
3/4	153	203	254	306	357	408	508	635	762	889	1016	1270	1524	2032	2540	3556	4572
1	115	153	191	229	267	306	382	477	573	668	764	955	1146	1528	1910	2675	3439
1 1/4	92	123	153	183	214	245	306	382	459	536	612	764	918	1224	1530	2142	2754
1 1/2	76	102	128	152	178	204	254	318	382	446	508	636	764	1016	1272	1778	2286
1 3/4	65	87	109	133	153	175	218	272	328	382	436	544	656	872	1088	1527	1962
2	57	76	95	115	134	153	191	239	287	334	382	477	573	764	955	1337	1719
2 1/4	51	68	84	100	119	136	170	212	256	297	340	424	510	680	848	1190	1530
2 1/2	46	61	76	92	107	122	153	190	230	268	306	382	459	612	764	1070	1377
2 3/4	42	56	70	83	97	112	139	174	208	244	278	348	416	556	696	972	1248
3	38	51	64	76	89	102	127	159	191	223	254	318	382	509	637	891	1146
3 1/2	33	44	54	66	76	88	109	136	164	191	218	272	328	436	546	764	984
4	29	38	48	57	67	76	96	119	143	167	191	239	286	381	477	668	858
4 1/2	25	34	42	51	59	68	85	106	128	148	172	212	254	340	424	594	762

CUTTING CHART

MATERIAL	Tensile Strength	Tungsten Carbide Tantalum Carbide Ft. per Min.			High Speed Steel Ft. per Min.		
		Dry	Wet	Type of Coolant	Dry	Wet	Type of Coolant
Cast Iron Average Brinell 150-170	18000 26000	250 275			90 110		
C. I. up to 1½% Nickel Brinell 170-195	20000 28000	275 300			70 80		
C. I. up to 1% Cr. 3½% Ni. Brinell 200-210	30000 36000	210 230			65 70		
Semi Steel. 20 to 30% Steel Scrap with 2% Si. or Better Brinell 170-195	30000 36000	175 200			62 72		
Steels Bessemer Screw Stock S. A. E. #1112	70000 90000		220 230	Cutting Oil		160 170	Cutting Oil
Free Cutting Bessemer Screw Stock High Sulphur Content	70000 90000		240 260	Cutting Oil		175 185	Cutting Oil
#2 Bessemer High Sulphur	70000 90000		270 300	Cutting Oil		165 175	Cutting Oil
Ultra Cut High Manganese, Same Machinability as #2 Bessemer	90000 110000		270 300	Cutting Oil		180 200	Cutting Oil
Open Hearth Screw Stock S. A. E. #1120	70000 85000		250 260	Cutting Oil		135 145	Soda Compound
Soft Forging Steel S. A. E. #1020 Low Sulphur For Carburizing	63000 80000		240 250	Soda Compound		110 120	Soda Compound
S. A. E. #1045	95000 125000		200 240	Soda Compound		80 90	Soda Compound
Alloy Steels 3½% Ni. S. A. E. # 2315 for Gear Blanks	80000 115000		165 175	Soda Compound		110 120	Soda Compound
Chrome Ni. up to .90 Cr. and 1.5 Ni. S. A. E. #3120 For Heat Treated Bolts and Gear Blanks	80000 110000		140 160	Soda Compound		90 100	Soda Compound
Aluminum Pure Cast Aluminum #43	19000		400 Up	Kerosene & Lard Oil		220 230	Kerosene & Lard Oil
Commercially Hard Temper Aluminum #2 SH.	24000		200 250	Kerosene & Lard Oil		130 140	Kerosene & Lard Oil
Dural High Tensile #17 ST.	58000		275 300	Soluble Oil		190 200	Soluble Oil
Copper Copper One-Half Hard Com- mercial	31000		180 200	Soluble Oil		100 120	Soluble Oil
Brass Brass. Cast Yellow	20000		400 600	Soluble Oil	200 220		
Brass One-Half Hard Com- mercial			250 300	Soluble Oil	135 165		
Bronze Bronze, Gun Metal	35000		200 220	Soluble Oil		130 150	Soluble Oil
Bronze, Phosphor	50000		160 180	Soluble Oil		95 115	Soluble Oil

LUBRICATION

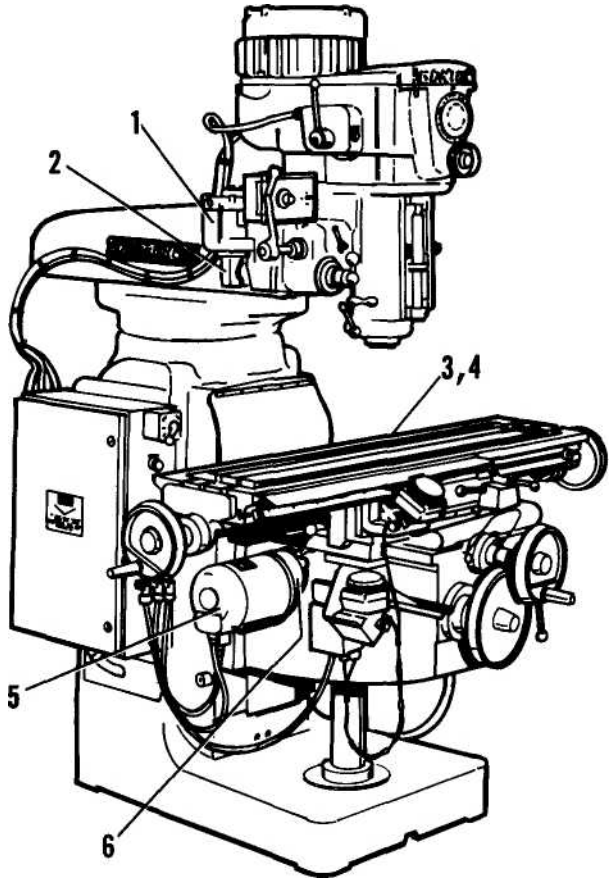

Figure 14. Lubrication

GENERAL

The 1-22 Mastermil must be properly lubricated before placing in operation and during operation to insure continued trouble-free operation. The illustrations locate lubrication points on the machine and the lubrication plate. Due to the advanced design, a minimum number of units require daily attention. However, adherence to the lubrication schedule is of major importance in obtaining maximum performance and long life of the machine.

1. SPINDLE DOWNFEED MOTOR

Spindle downfeed motor bearings are lubricated at factory - for two (2) year period. When repacking use Socony BRB No. 4 or Sun Oil Prestige No. 42. Repeat at two (2) year intervals.

2. SPINDLE DOWN FEED MOTOR GEAR CASE

Spindle downfeed gear case lubricated at factory - for two (2) year period. When repacking use Socony Mobilplex EP-24 or Sun Oil Prestige 740 AEP. Repeat at two (2) year intervals.

3, 4. SADDLE/TABLE AND KNEE/COLUMN

Saddle/table slide lubrication pump and reservoir unit is located on left side of saddle. Hand pump should be operated once, twice daily. Pull out handle and allow pump to return slowly. The oil level of the reservoir should be checked daily and kept filled at all times.

Knee/column slide lubrication is through oil cups on knee. Check daily and keep filled. Use Socony Vactra No. 2 or Sun Oil SWL No. 80.

5. POWER ELEVATE MOTOR

Power elevate motor bearings are permanently grease packed and do not require replenishment or change.

6. POWER ELEVATE GEAR BOX

The power elevate gear box is filled at factory for two (2) year period. When repacking the gear housing, cover must be dismantled. Use Socony Mobilplex EP-24 or Sun Oil Prestige 740 AEP.

LUBRICATION

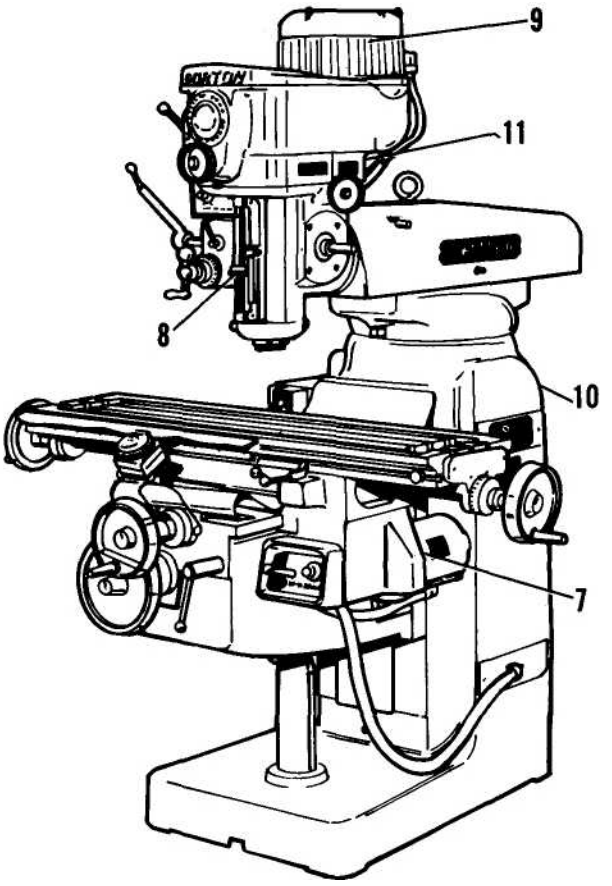

Figure 15. Lubrication

7. DNYA-DRIVE II

Dnya-Drive II motor bearings are grease packed at factory. Repack after three (3) years of operation -under severe conditions, after approximately 18 months. Use Socony Mobilux No. 2 or Sun Oil Prestige No. 42.

8. SPINDLE BARREL AND DEPTH STOP

The spindle barrel and depth stop should be thoroughly cleaned and lightly oiled once a week. Use Socony Velocity No. 10 or Sun Oil Solnus No. 70.

NOTE: At same time lubricate the spindle splines with Fisk Refinery Lubriplate.

9. SPINDLE DRIVE MOTOR

Spindle drive motor bearings are lubricated at factory. Requires no additional lubrication.

10. LUBRICATION PLATE

The lubrication plate which indicates type and frequency of lubrication as outlined above, is located on rear curved section of column.

For maximum efficiency and minimum downtime, always follow the directions as outlined. It is important to use fresh, clean lubricants at all times and to follow the specifications. Specific lubricants have been developed through extensive testing. Do not substitute unless equivalent product is available.

11. SPINDLE HEAD

Lubricate the spindle head through the grease fitting at the back of the head once a week. Use three (3) shots of Keystone No. 122 grease.

CAUSES OF MILLING PROBLEMS

PROBLEM	CAUSE	SOLUTION
Chatter	1. Lack of rigidity in the machine, fixtures, adapter or workpiece.	1. Improve rigidity.
	2. Cutting load too great. (Chip per tooth).	2. Increase number of teeth in contact with workpiece.
	3. Dull cutter.	3. Resharpen.
	4. Poor lubrication.	4. Improve lubrication.
	5. Straight tooth cutter.	5. Use helical tooth cutter.
	6. Peripheral relief angle too great.	6. Decrease relief angle.
Cnnot hold size.	1. Cutting load too great causing deflection.	1. Increase number of teeth in contact with workpiece.
	2. May be due to chip packing.	2. Increase oil pressure or redirect flow so as to wash chips out of teeth.
	3. Chips causing misalignment of work.	3. Brush all chips away before mounting new workpiece.
Premature cutting dulling.	1. Chip load too small.	1. Decrease number of teeth in contact with workpiece.
	2. Insufficient coolant.	2. Add blending oil to lubricant.
Poor surface finish.	1. Feed too high.	1. Decrease feed and increase speed.
	2. Dull tool.	2. Resharpen.
	3. Speed too low.	3. Increase S.F.M.
	4. Insufficient number of cutter teeth.	4. Use cutter with more closely spaced teeth.
Cutter "Hogs in"	1. Peripheral relief too great.	1. Use recommended angles.
	2. Rake angle too large.	2. Decrease rake angle.
	3. Improper speed.	3. Check and adjust.
	4. Screw backlash.	4. Adjust anti-backlash.
Vibration	1. Insufficient clearance causing rubbing.	1. Use recommended clearance angles.
	2. Machine at fault.	2. Check machine slides, gibs, etc.
Work burnishing.	1. Cut is too light.	1. Increase feed rate.
	2. Insufficient peripheral relief.	2. Increase peripheral relief angle.
	3. Land too wide.	3. Decrease width of land.
Cutter burns.	1. Insufficient lubricant.	1. Add more sulphur base oil.
	2. Speed too fast.	2. Decrease speed.
Teeth breaking	1. Feed too high.	1. Decrease feed per tooth. May be possible to maintain rate by increasing the number of teeth.