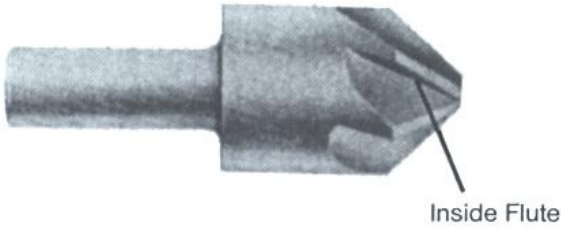




Reamers

Deposit .0002" - .0008" inside flute along cutting edge and then re-sharpen.



Counter-Sinks

Deposit .0002" - .0006" along cutting edge inside flute. Deposit along entire length of cutting edge and then re-sharpen.



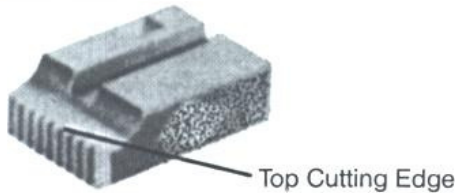
Counter-Bores

Follow same basic procedure as for end mills with deposit of .0002" - .0006". Re-sharpen after deposit.



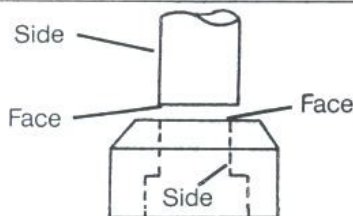
Taps

For sharp tools apply .0002" - .001" inside flute along cutting edge for 2-3 full threads. Take care not to nick cutting edge. Dull tools should be re-sharpened first and then same procedure followed as for sharp tools.



Thread Chasers

Apply .0002" - .001" along top cutting edge. If tool is dull re-sharpen first and then follow same procedure.



Punches and Dies

Apply to sides, face or both depending on area that is wearing. Most commonly the deposit is applied to the sides and the face is then ground. Deposit .0002" - .001" depending on thickness of build-up that can be tolerated.

Miscellaneous Applications - Non-Cutting

For such applications as various types of casting molds and dies, chucks, gripper, collets and general machine parts apply deposit over entire wear or gripping surface with a deposition thickness of .0002" - .004" depending on thickness that can be tolerated. For maximum smoothness of deposit move electrode briskly from side-to-side and apply a light finish coat of .0002" after a heavier coat is deposited.

Note:

In all applications, whether cutting or non-cutting, a light stoning of the deposited surface with a cubic boron nitride or diamond stone is generally beneficial for removal of burrs and optimum sharpness of cutting edge and for smoothness surface.

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