



UNITurn & **UNI**Mill
The cool tool

VERTICAL MILLING TABLE

P/N 1185 (Inch)
P/N 1184 (Metric)

Whether you're milling with the Vertical Milling Column or the Vertical Milling Table, some of the same basic rules apply. Here is a brief summary of those rules:

1. This is a small, light duty mill and shouldn't be used to remove vast amounts of unnecessary stock that could be easily removed with a hacksaw. Get stock as close to size as possible before starting.
2. Loads involved for milling are a lot higher than lathe turning. Vibration level is also a lot higher; therefore, more attention must be paid to gib adjustments. They should be kept snug, but not overtightened.
3. End mills must run true and must be sharp. Holding end mills in a drill chuck is a poor method. Milling collets should be used for this purpose. When cutting aluminum, run the motor at top speed and take light cuts.
4. Fly cutting is an excellent way of cutting stock from flat surfaces.
5. Learn to use a dial indicator.
6. Shims may be required to properly align the machine. Normally, standard machine alignment will be good enough for most work unless it is exceptionally large or has to be extremely accurate.
7. A good vise is a must.
8. Often more time will be spent making fixtures to hold work than doing the actual work. There aren't any short cuts in this type of work. If your part comes loose while it is being machined and is destroyed, more time is lost than that saved in a quick set-up.
9. Always try to have one point to measure from. Don't machine this point off half way through the job and leave yourself with no way of measuring the next operation. **PLAN AHEAD!**
10. A good rule for machining operations is, if the tool chatters, reduce speed and increase feed.

It takes a long time to accumulate the knowledge, tools and fixtures to do the tremendous amount of different types of operations involved in milling. Don't get discouraged by starting a job that is too complex.

Refer to **UNI**Turn INSTRUCTION
 GUIDE (P/N 5326)
 for Milling Setup and Operations.

VERTICAL MILLING TABLE PARTS LIST

NO. REQ.	PART NO.	DESCRIPTION
1	1183	Milling Table Base
1	4005	Handwheel, Inch (P/N 4105, Metric)
1	4021	Slide Screw, Inch (P/N 4121, Metric)
2	4025	Tee Nut
3	4052	Cone Point Set Screw, 10-32 x 3/16"
2	4073	Skt Hd Cap Screw, 10-32 x 2"
1	4082	Gib Lock
1	4088	Crossslide
1	4089	Slide Screw Insert, Inch (P/N 4189, Met.)
1	4098	Crossslide Gib

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