



Service Bulletin

Enabling Your Ideas

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Product Identification: PCNC I 100 Milling Machine & Duality Lathe

Oil

When you need oil for your PCNC I 100, any type of oil will work – even motor oil. However, the best oil to use would be oil designed specifically for lubricating machine ways. This type of oil has an additive that helps the oil stick to the surface. We suggest Perkins Perlube WL-68 which is available from Tormach as **PN 31386**. We have also used Waylube 68 Way Oil 300-350 SUS at 100F SAE 20, primarily because it is easy to find.

Coolant

When you need to replace coolant in your PCNC I 100, you should look for a coolant that contains biocide but does not contain oil. Ideally, the coolant you use should be something you can dispose of easily, which means that you will most likely be using a biodegradable synthetic coolant. Some coolants are designed for certain materials and some are designed for a large variety of materials. What you plan to machine ultimately determines which coolant is best for you.

Regardless of coolant type, it is important to maintain the correct concentration level of coolant and water in order to maintain the corrosion protection properties of the coolant. Typically, a refractometer is used to check the concentration level. The concentration level can change in a very short time even when the coolant is not in use, because the water evaporates and the coolant does not. Most times, simply adding water to the coolant tank can maintain the concentration level. **PN 31366** is a Portable Refractometer that we recommend for monitoring coolant concentration.

Note: Water soluble coolant will leave a residue when it dries. Don't worry about cleaning this residue up – it helps protect the machine parts from corrosion and will eventually wash away with the new coolant!