



**BOELUBE®**



*A BOEING DEVELOPED LUBRICANT*



**The Orelube Corporation**  
Specialty Industrial Lubricants Since 1958

### **Introduction:**

Under request by one of our customers we proceeded with the following test to determine the amount of **Boelube** lubricant used with Oil Hole Tools. For the test we used the following setup:



To simulate the positive feed drill working scenario the air pressure was regulated to 55-60 PSI and adjusted the amount of lubricant with Unist Piggy-back portable cutter lubricant system.

The cartridge was measure 1 cm of length the equivalent of approx. 5 cc.

### **Final results:**

In approximately 8min 35sec, 2 cm or 10 cc of Coolant was used.



### **Conclusions:**

In case of the usage of the Zephyr ZT4000 positive feed drill, with 2200 rpm, 0.006 feed rate, drilling 1.00" thickness of aluminum with 1/2" drill bit diameter and knowing the drilling time in average of 8-10 sec per hole a full cartridge of 15cc, it will last up to 150 holes (1.17 ml/min).