

## TensileMill CNC Classic Upgrade and Impact Mill- FAQs

### What are the power and amperage requirements for TensileMill CNC CLASSIC UPGRADE (IMPACTMILL)?

The system requires 220V power supply three phase and 52 amps. The unit has 12.5kW of power.

The CLASSIC UPGRADE (IMPACTMILL) tensile sample preparation machine has a voltage tolerance of 200-240V.

### What type of receptacle would be recommended for the system?

TensileMill CNC CLASSIC UPGRADE (IMPACTMILL) requires a 3 prong, 52A receptacle. You will simply need to plug the receptacle or you can hardwire to to the terminal at the lower left corner of the electric panel.

### Does the CLASSIC UPGRADE (IMPACTMILL) system require a water connection?

The unit is equipped with standard recirculating coolant and way lubrication systems, so no water connection is required.

This is a floor-standing system that can be installed according to your preferences. As an option, we recommend tilting the machine slightly towards the right front side to improve fluid circulation efficiency.

### Does the CLASSIC UPGRADE (IMPACTMILL) system require an air connection?

Yes, the unit requires an air connection with a 10mm OD hose, and the air supply pressure should range between 86 PSI and 116 PSI.

### What are the space requirements (footprint) for TensileMill CNC CLASSIC UPGRADE (IMPACTMILL)?

The suggested floor dimensions are (LxW) 2100 x 2000mm (82.7 x 78.5 inch)



### What is the suggested cooling fluid to be used with the system?

The CLASSIC UPGRADE (IMPACTMILL) is equipped with an internal recirculating fluid chamber. It is recommended that it be changed every 6-12 months. Generally speaking, the spindle cooling fluid only needs to be changed once a year and the cutting fluid needs to be topped off when it gets low. Some of the recommended brands are Cim Cool, Hocut, and Blaser.

### What is the suggested lubrication fluid to be used with TensileMill CNC CLASSIC UPGRADE (IMPACTMILL)?

The CLASSIC UPGRADE (IMPACTMILL) flat specimen preparation machines come standard with a Way Lube system but requires you to purchase your own machine lubricating oil. The oil required is ISO 68 equivalent way lube. Some brand suggestions include Mobil, Shell, Irving, etc.

### What types of tables and clamping fixtures are included as a turnkey package with the CLASSIC UPGRADE (IMPACTMILL)?

Though compact, the CLASSIC UPGRADE (IMPACTMILL) sample preparation machine comes standard with a triple sample fixture. This fixture is designed to maximize production efficiency and Classic Upgrade (ImpactMill) minimize operator involvement time. It allows to stack 3x the samples (or sample stacks) up to 1.5" (32mm)<sup>\*\*\*</sup>. By clicking a pre-set setting in the software, the operator can get the machine started and move on to other projects while the samples are being prepared only to come back to accurate tensile specimens.

The clamping set is supplied with regular, sub-size and large size clamps based on clients' requirements, as part of the Turnkey Solution Package.



The ImpactMill CNC's clamping fixture doubles as an Impact Sample Preparation fixture, allowing operators to prepare 10x10x55 mm and 7.5x10x55 mm impact specimens



efficiently. It is designed to save up to 90% of preparation time and has the capacity to prepare up to 8 samples at once.

The starting blank dimensions to prepare your rectangular impact specimens are:

**For 10 x 10 x 55 samples:**

Min. / Max. on width and gauge is 11.5 mm and 15.5 mm

**NOTE:**

The starting width and gauge of the stock material does not need to be the same.

Length à Min. / Max. Length - 56.5mm to 61mm

**For 10 x 7.5 x 55 samples:**

On the 10mm side à Min. / Max. 11.5 mm and 15.5 mm

On the 7mm side à Min. / Max. 9 mm and 15.5 mm

Length à Min. / Max. Length - 56.5mm to 61mm

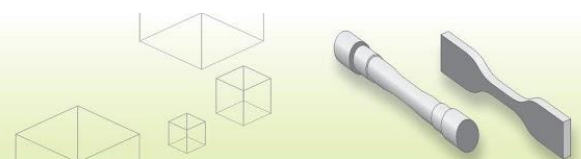


Video Tutorial:

<https://www.youtube.com/watch?v=UsIYVrj0i2Y&t=8s>

**Is it possible to upgrade to the CNC Unlock function after the purchase of the main unit?**

The Classic Upgrade (Impact Mill) models come standard with a FANUC integrated TensileSoft™ 2.0. package. This innovative integration is the world's first to provide a user-friendly tensile and impact sample preparation procedure, catering to both inexperienced and experienced CNC machinists.



## **What are the common consumables for the TensileMill CNC CLASSIC UPGRADE (IMPACTMILL)? Are these readily available?**

The CLASSIC UPGRADE (IMPACTMILL) comes standard with a recommended end-mill for your material application as part of a Turnkey Solution Package. Softer materials require different end mill bits than the harder materials. Our engineers provide the best recommendation based on the type and hardness of the material that you will be milling and the overall milling volume.

All end-mills are designed and manufactured uniquely for tensile sample preparation needs. As a result, the longevity of each unit is superior to any comparable end mill on the market.

The endmills can be purchased with TensileMill CNC, Inc. or through your preferred local tooling distributor.

## **What are the common spare parts for CLASSIC UPGRADE (IMPACTMILL)? Are these readily available?**

Outside of endmills, after a couple years of rigorous use it is possible that the spindle may require replacement.

Most spare parts and consumables are available in-house or can be delivered within a few days/weeks. [Contact us](#) today or submit your request on-line.

