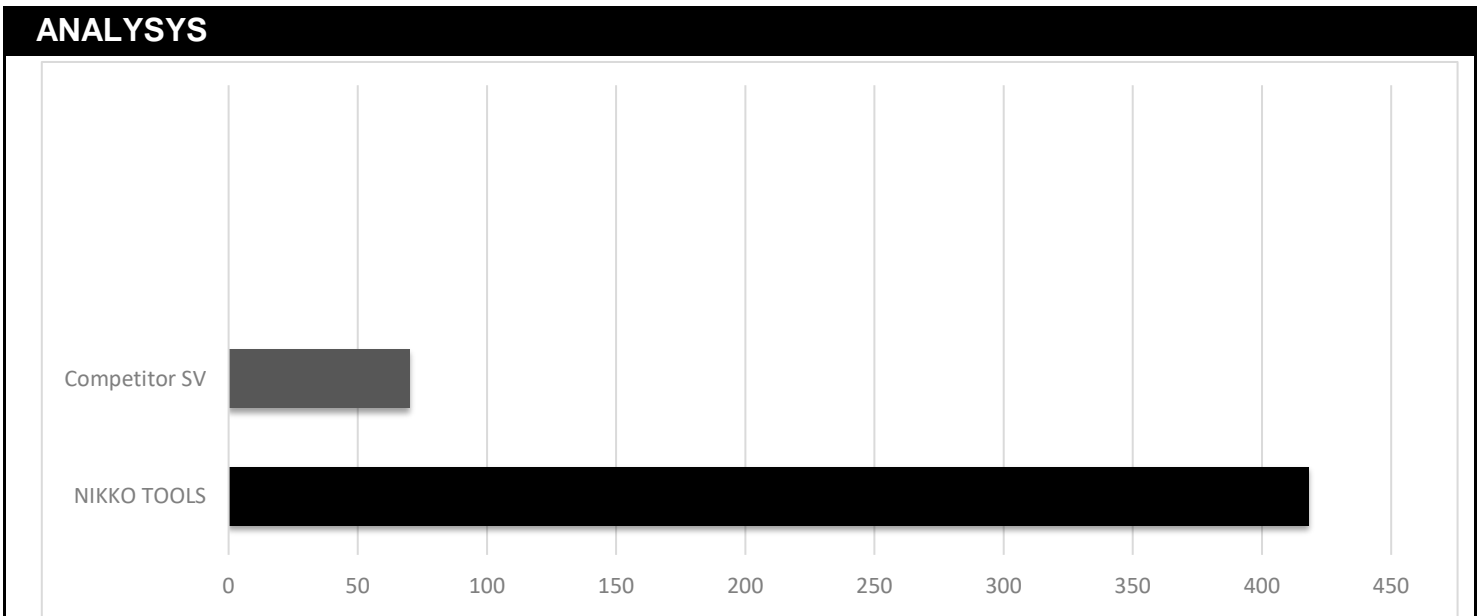


OPERATION	
Toolholder	NT-S20R-SDQCR11
Insert type	DCGT11T304 ND100
Material	Die-cast Aluminium (9% Si)
Workpiece	WASHING MACHINE COMPONENT

MACHINING CONDITION					
		nikkoTOOLS	Competitor SV		
Diameter (D)	mm	62			
Cutting speed (Vc)	m/min	950	950		
Feed (f)	mm/rev	0,05	0,03		
Depth of cut (ap)	mm	0,1			
Length of work (L)	mm	34			
Cutting condition		CONTINUOUS			
Coolant		EMULSION			
Tool Life		418 min	70 min		



Note

Ra max acceptable value = 0,4µm.

The competitor didn't respect anymore this value after 500 pieces, Nikko Tools' insert did it after six times more.