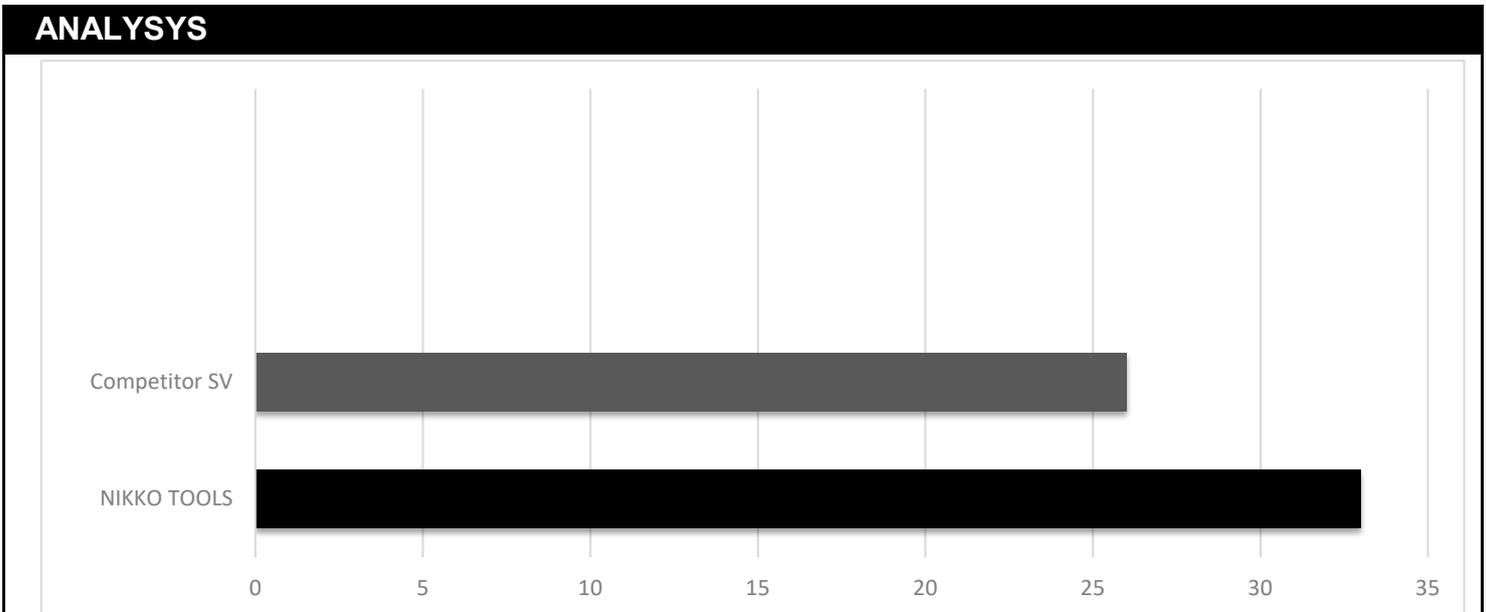


OPERATION	
Toolholder	NT-RKP11 D020-S20-Z3
Insert type	NT-RKP11R08M-HGP JP8625
Material	W-stoff 1.0144 - Fe430
Workpiece	SLIDING BLOCK

MACHINING CONDITION		nikkoTOOLS	Competitor SV		
Cutting speed (Vc) m/min		188	188		
Feed for tooth (fz) mm/z		0,1 Z3	0,1 Z3		
Feed (F) mm/min		900	900		
D Milling cutter (Ds) mm		20			
Depth of cut (ap) mm		2,5			
Width of cut (ae) mm		20			
Length of work (L) mm		6000			
Coolant		WET			
Total Tool Life		33 min	26 min		



Note

The insert of Nikko Nikko has been replaced for safety (due to the 15 passes) but the wear was very little. However, the result has been higher than the competitor, showing a higher reliability.