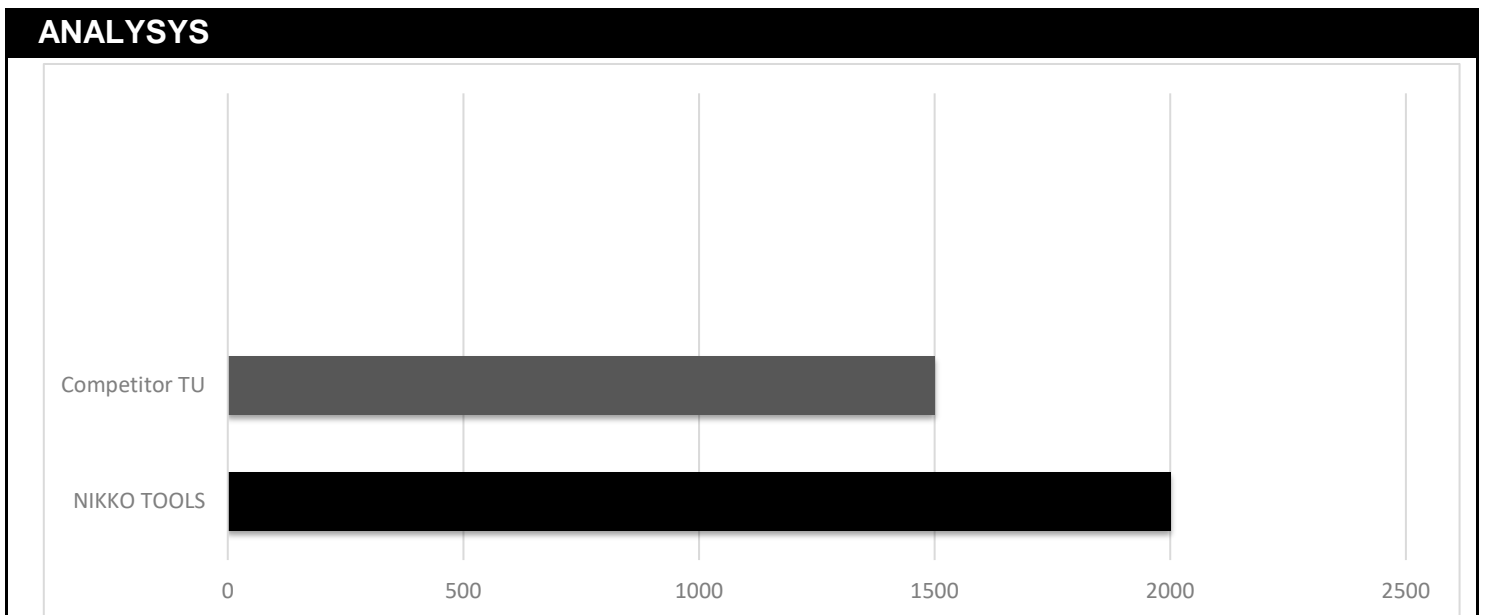


OPERATION	
Toolholder	NT-DRS-3D-D19-S25-06
Insert type	SPGX060204-AL JU6520
Material	W-stoff 3.4365 - ERGAL 7075
Workpiece	SPACER

MACHINING CONDITION				
	nikkoTOOLS	Competitor TU		
Cutting speed (Vc) m/min	268	268		
S (Spindle Rev.) rpm	4500	4500		
Feed (f) mm/rev	0,25	0,25		
Length of work (L) mm	20			
Hole type	BLIND			
Hole direction	ORIZONTAL			
Coolant	EMULSION (25bar)			
<b>Tool Life</b>	<b>2000 holes</b>	<b>1500 holes</b>		



### Note

The Nikko Tools' insert performed a perfect chip control.