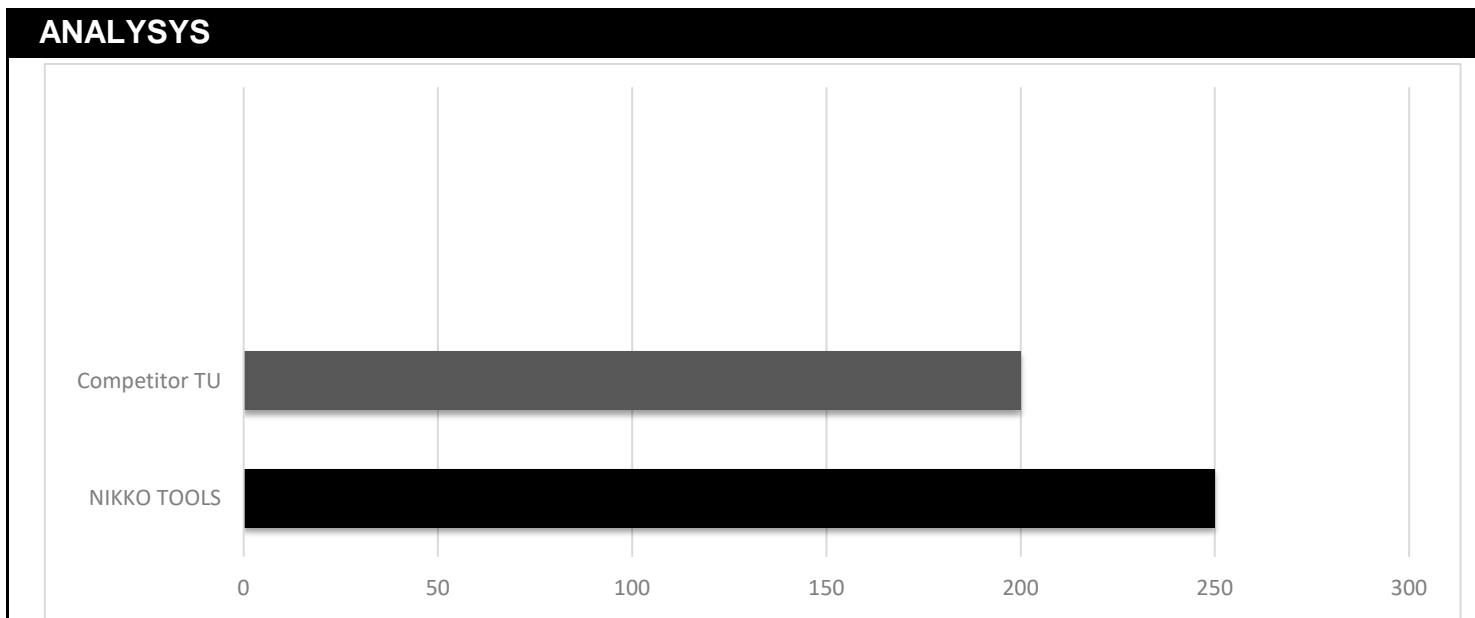


OPERATION	
Toolholder	NT-DRS-2D D20-S25-06
Insert type	SPMX060204-GP JP9635
Material	W-stoff 1.4350 - Aisi 304
Workpiece	BUSHING

MACHINING CONDITION				
	nikkoTOOLS	Competitor TU		
Cutting speed (Vc) m/min	138	138		
S (Spindle Rev.) rpm	2200	2200		
Feed (f) mm/rev	0,06	0,06		
Length of work (L) mm	20			
Hole type	THROUGH			
Hole direction	HORIZONTAL			
Coolant	EMULSION (10bar)			
<b>Tool Life</b>	<b>250 holes</b>	<b>200 holes</b>		



**Note**

Nikko Tool's solution performed +25%.