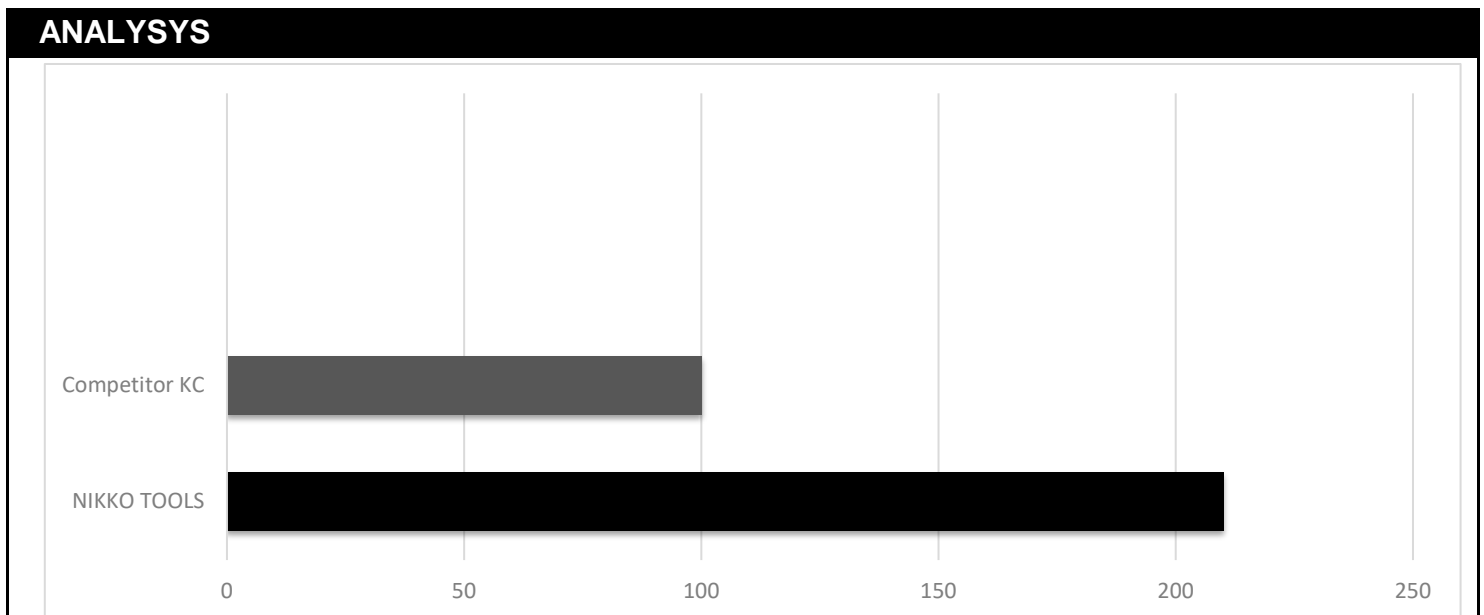


OPERATION	
Toolholder	NT-V32S-SIR16-37
Insert type	16IR11W-TPM JP5125
Material	W-stoff 1.0037 - F360
Workpiece	PIPE

MACHINING CONDITION				
	nikkoTOOLS	Competitor KC		
Cutting speed (Vc) m/min	140	140		
S (Spindle Rev.) rpm	455	455		
Number of Passes	10	10		
D Part's diameter mm	100			
Length of work (L) mm	30			
External / Internal	EXTERNAL			
Coolant	EMULSION			
Tool Life	210 pcs	100 pcs		



Note

There were weldings on the surface of the workpiece. The Nikko Tools' insert gave an excellent perform (more than twice the competitor) proving, at the same time, a good reliability even in these difficult conditions.