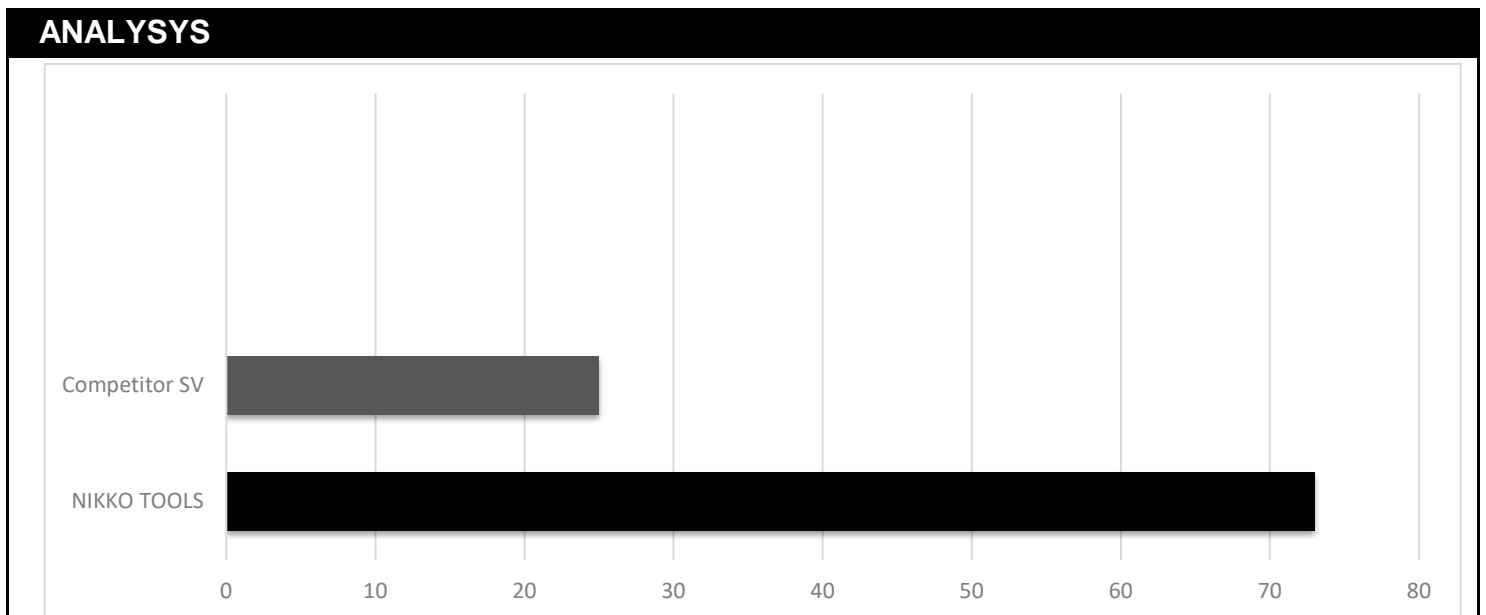


| OPERATION | |
|-------------|-----------------------------------|
| Toolholder | NT-DCLNL2525M12 |
| Insert type | CNGA120408S-WE-4V NBL150C |
| Material | W-stoff 1.7225 - 42CrMo4 56-60HRC |
| Workpiece | ROLL |

| MACHINING CONDITION | | | | | |
|---------------------|--------|---------------|---------------|--|--|
| | | nikkoTOOLS | Competitor SV | | |
| Diameter (D) | mm | 49 | | | |
| Cutting speed (Vc) | m/min | 150 | 100 | | |
| Feed (f) | mm/rev | 0,1 | 0,1 | | |
| Depth of cut (ap) | mm | 0,20 | | | |
| Length of work (L) | mm | 23 | | | |
| Cutting condition | | INTERRUPTED | | | |
| Coolant | | DRY | | | |
| Tool Life | | 73 Min | 25 Min | | |



Note

The wiper solution of Nikko Tools respected the surface finishing value $Ra_{max}=0,4\mu m$. Besides, the cycle time was decreased due to a higher cutting speed.