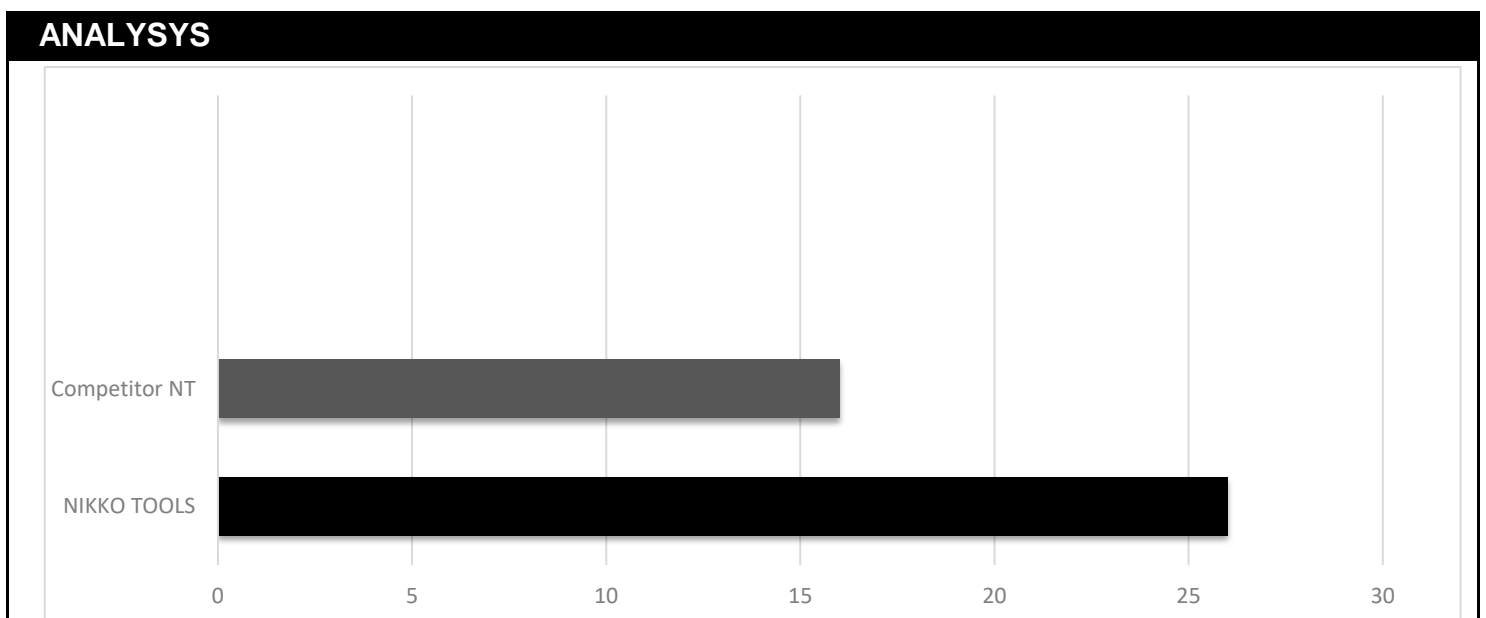


OPERATION	
Toolholder	NT-DCLNL2525M12
Insert type	CNMA120412-GP NSN400
Material	W-stoff 0.6025 - GJL250
Workpiece	PISTON

MACHINING CONDITION					
		nikkoTOOLS	Competitor NT		
Diameter (D)	mm	190			
Cutting speed (Vc)	m/min	350	180		
Feed (f)	mm/rev	0,15	0,23		
Depth of cut (ap)	mm	2,0			
Length of work (L)	mm	30			
Cutting condition		INTERRUPTED			
Coolant		DRY	EMULSION		
<b>Tool Life</b>		<b>26 min</b>	<b>16 min</b>		



#### Note

The test highlights the higher performance in productivity and tool life of the Nikko Tools' ceramic insert at the expense of the competitor's carbide.