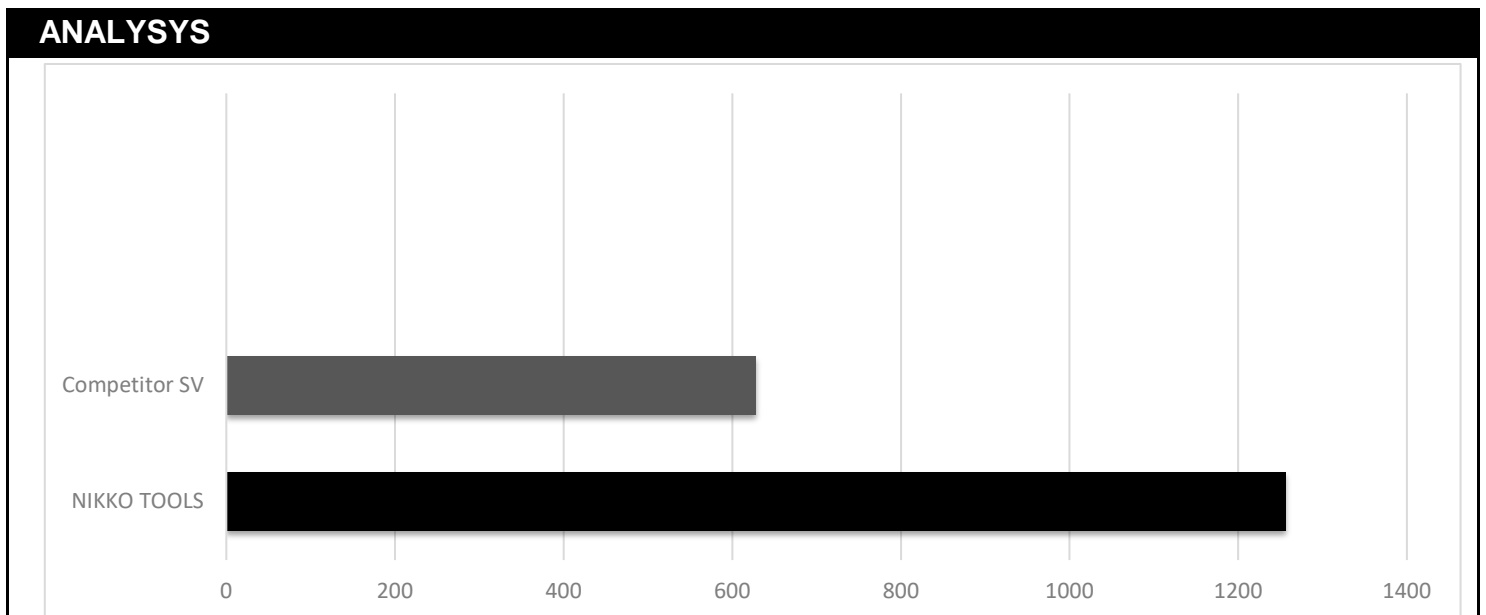


| OPERATION   |                      |
|-------------|----------------------|
| Toolholder  | NT-SVJCR1616K11      |
| Insert type | VCGX110304-CBF ND120 |
| Material    | Copper               |
| Workpiece   | JUNCTION             |

| MACHINING CONDITION |        |                 |                |  |  |
|---------------------|--------|-----------------|----------------|--|--|
|                     |        | nikkoTOOLS      | Competitor SV  |  |  |
| Diameter (D)        | mm     | 10              |                |  |  |
| Cutting speed (Vc)  | m/min  | 100             | 100            |  |  |
| Feed (f)            | mm/rev | 0,15            | 0,15           |  |  |
| Depth of cut (ap)   | mm     | 2,1             |                |  |  |
| Length of work (L)  | mm     | 20              |                |  |  |
| Cutting condition   |        | CONTINUOUS      |                |  |  |
| Coolant             |        | OIL             |                |  |  |
| <b>Tool Life</b>    |        | <b>1256 Min</b> | <b>628 Min</b> |  |  |



#### Note

The insert replacement criterion was the forming of burrs on the workpiece. Nikko Tools' solution gave twice the tool life.