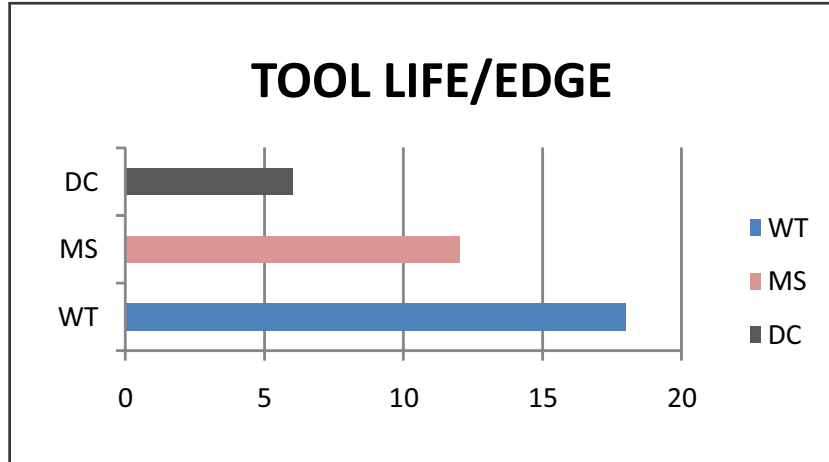


CASE 1	27-06-2017
WORKPIECE MATERIAL	GRAY CAST IRON
COMPONENT NAME	CLUTCH COVER
WORKPIECE HARDNESS	200 BHN
PROCESS	ID ROUGH
COOLANT	WATER BASE
CUTTING PARAMETERES	Vc = 200 m/min
	f = 0.3 mm/rev
	Ap = 2.5 ~ 3 mm
INSERT	CNMG120408-HK-C1125
CUTTER	S40U-DCLNL-12



↑
WT tool life is 200%
higher than DC

↑
WT tool life is 50%
higher than MS

BEFORE



AFTER

