

**TEST TOOL EVALUATION REPORT**

<b>DATE:</b>	<b>13/08/2008</b>
<b>REPORT# :</b>	<b>1</b>

<b>COMPANY:</b>		<b>REPRESENTATIVE:</b>	<i>Vishal Patel</i>
<b>CONTACT:</b>		<b>PART DESCRIPTION:</b>	<b>OutPut Shaft - PULSAR</b>
<b>TEL:</b>		<b>WORK MATERIAL:</b>	<b>SCM420H</b>
<b>FAX:</b>		<b>MAT'L HARDNESS:</b>	<b>220 - 280 BHN</b>

<b>TYPE OF OPERATION</b>	<b>OD Turning</b>	<b>MACHINING OPERATION (SKETCH)</b> 
<b>MACHINE TOOL &amp; TYPE</b>	<b>CNC Lathe</b>	
<b>RIGIDITY</b>	<b>GOOD</b>	
<b>COOLANT TYPE</b>	<b>EMUSION</b>	
<b>COOLANT METHOD</b>	<b>THROUGH</b>	

TOOLING REQUIRED	COMPANY / COMPETITOR	Competitor	TUNGALOY	
		CURRENT	FIRST TEST	SECOND TEST
	TOOL DESCRIPTION	Turning Tool	Turning Tool	Turning Tool
	HOLDER/BODY TYPE	MTJNL 2525	MTJNL 2525	MTJNL 2525
	INSERT	TNMG 160408 PS	TNMG 160408 TM	TNMG 160408 TM
	INSERT GRADE		6030	6030
CUTTING PARAMETERS	WORKPIECE/CUTTER DIAMETER	15 / 25	15 / 25	15 / 25
	FEED RATE (IPR = f or IPM = F)	0.3	0.3	0.3
	CUTTING SPEED (RPM=R or SFM=V)	380	380	380
	DEPTH OF CUT (mm)	1.5	1.5	1.5
TOOL PERFORMANCE	CYCLE TIME FOR TOOL (min)	45Sec	45Sec	45Sec
	AVERAGE TOOL LIFE ( per edge)	170	350	350
	Edge No 1	-	337	440
	Edge No 2	-	430	380
	Edge No 3	-	383	413
	Edge No 4	-	383	350
	Edge No 5	-	390	350
Edge No 6	-	395	350	
COST EVALUATION	INSERT COST	-		
	NUMBER OF INSERTS IN TOOL (multi)	1	1	1
	INSERT COST PER PIECE	-	INR 0.16	INR 0.16
	INSERT INDEX TIME (min)	1Min	1Min	1min
	HOURLY MACHINE DEPT. COST	550Rs / Hour	550Rs / Hour	550Rs / Hour
	TOTAL ANNUAL PIECES			
	MACH TIME + TOOL COST FOR TOOL WON or LOST			

**COMMENTS:**

**Increase in TOOL life resulting in increase production. Production of 50 Comps increased with increase in the tool Life**