

## INSERT LIFE VALIDATION REPORT

|                  |                                   |                       |
|------------------|-----------------------------------|-----------------------|
| Insert Details:- | 16IR 1.5 ISO LM M2220 (03 corner) | Spindle speed         |
| Part Name:-      | FP 5TSG                           | Cutting speed         |
| Part Number:-    | 080FA04033                        | Feed rate             |
| Machine No.:-    | CNC-07                            | Coolant concentration |
|                  |                                   | Part parameter        |

| Sr. No | Qty produced | Description    | Parameter status                   | Insert status | Remarks |
|--------|--------------|----------------|------------------------------------|---------------|---------|
| 1      | 0            | Insert mounted | -                                  | ok            | ok      |
| 2      | 50           | Run            | ok                                 | ok            | ok      |
| 3      | 100          | Run            | ok                                 | ok            | ok      |
| 4      | 150          | Run            | ok                                 | ok            | ok      |
| 5      | 200          | Run            | ok                                 | ok            | ok      |
| 6      | 250          | Run            | ok                                 | ok            | ok      |
| 7      | 300          | Run            | ok                                 | ok            | ok      |
| 8      | 350          | Run            | GO gauge started to not qualifying | ok            | ok      |
| 9      | 400          | Run            | GO gauge not qualifying            | worn out      | ok      |
| 10     | 450          | stop           | ok                                 | ok            | ok      |

**Conclusion**

Insert life defined as 250nos per corner , and Micro program to be updated. Earlier it was 400nos per corner and micro program was the same.

Krushna Phuke

Kishor Ir

Validation done by

Validation verified

1

1600 rpm

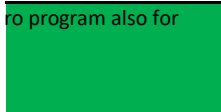
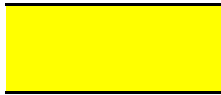
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1.0 mm/rev

3.0-4.5 %

M26x1 -6h

rk



ngle

ed by