

INSERT LIFE VALIDATION REPORT

Insert Details:-	16IR 1.5 ISO LM M2220 (03 corner)	Spindle speed	1600 rpm
Part Name:-	FP 5TSG	Cutting speed	-
Part Number:-	080FA04033	Feed rate	1.0 mm/rev
Machine No.:-	CNC-07	Coolant concentration	3.0-4.5 %
		Part parameter	M26x1 -6h

Sr. No	Qty produced	Description	Parameter status	Insert status	Remark
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 300nos per corner , and Micro program to be updated. Earlier it was 400nos per corner and micro program also for the same.

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Validation done by

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