Tool Testing	Tool	Size		Grade of Steel	HRC	Speed	Feed	SFM	FPR	Cost	Depth	# of Holes
12/27/07	OSG Exocarb Max Oil			DC-53		496 RPM	3.3 IPM	65	0.0065	$149.04	0.81	1380
	Part# OSG52650011	.500 Dia										
3/1/2008	OSG VPH-GDS Drill	17/32 Dia		DC-53		288 RPM	6.91 IPM	40	0.012		1.25	180
1/3/2008	Seco Round insert cutter	RDHT10T3M0T-M07 T350M	EDP#26116	GF-80	42	1436 RPM	89.8 IPM				DOC .040	
	Application Face Mill 40 min too life		Size of block milled 12x12									
1/2/2008	Hannibal 26mm Reamer			GF-80	42	187 RPM	2.62 IPM	50	0.014		7	16
	Style 429 Reamer			NDS-1		131 RPM	1.048 IPM	35	0.008	$212.60	7	16
12/27/07	OSG EXO-TAP List #312	5/16-18 tap		Toolox-44	44			5 To 10 SFM	0.0555		0.625	
	Plug TICN	2nd Choice thru hole										
12/27/07	Greenfield cobalt drill	F-257 Dia		Toolox-44	45			35	0.003		1.12	70
3/24/2008	OSG EXO-TAP LIST#312	1/4-20 Tap		Toolox-44	44	122	Tap condition OK	8			0.6	189
	Drilled with #5 drill .2055 dia	Plug TICN										
4/16/2008	OSG EXO-TAP LIST#10051	1/4-20 Tap 1/2" of thread	Tap broke at 110	Toolox-44	45			6			0.55	110
	Tested 2 Taps # 5 drill .800 deep 1st Choice Blind or Thru hole		Tap still running					6			0.55	138
1/11/2008	OSG Exocarb Max Oil			Toolox-44	45	1174 RPM	6.9 IPM	80	0.006	$59.41	1.12	260
	Part# OSG52625711	F-257 Dia										
6/6/2008	Seco Tool	1.500 Dia	5-Inserts round	TOOLOX-44	44	1436 RPM	89.8 IPM	563	0.0625		.040 DOC	NA
Mazak V-655/60	R217.29-150-16RE-5.5AR	.950 Step-over application face-mill	RDHT10T3M0T-M07-T350 EDP# 26116 39 min 19 sec tool life 31% spindle load	Block size 9.125 x 12.125 x 1" Deep		Inserts still cutting but need rotated						
6/6/2008	Seco Tool	4"	6-Inserts	TOOLOX-44	44	497 RPM	29.8 IPM	520	0.06		0.08 DOC	NA
Mazak V-655/60	4" OCTOMILL FACE-MILL 3.5 STEP-OVER 50% spindle load		OFENO70405TN-D18-T200M EDP # 04034 TOOL-LIFE 21 min 18 sec	Block size 9.125 x 12.125 x .750 Deep		Inserts still cutting & in fair condition						
6/6/2008	Seco Tool	4"	6-Inserts	TOOLOX-44	44	538	19.3	563	0.036		0.012	NA
Mazak V-655/60	4" OCTOMILL FACE-MILL 3.5 STEP-OVER (Finisher)		OFENO70405TN-D18-T200M EDP # 04034	Block size 9.125 x 12.125 x .012								