



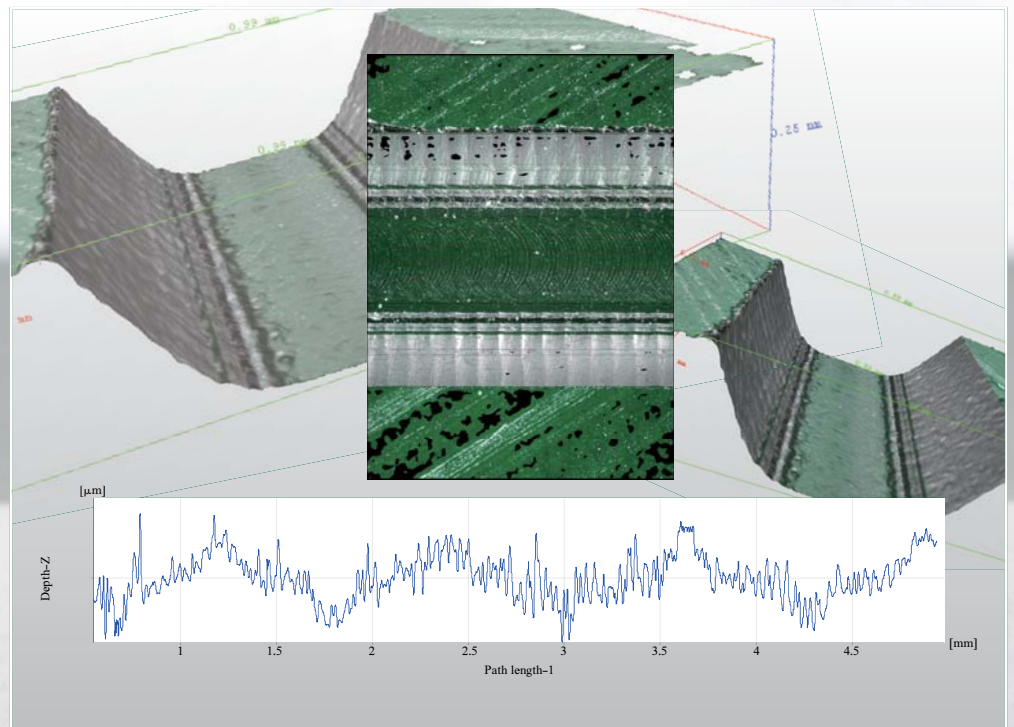
Quarterly Report Of
Tools & Cutting Tools

No. **5**
Autumn 2009

after Morakot Typhoon
we all believe, after a long, dark night,
sun will for eternity shine brightly in the
morning.



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EMO
MILANO





The total production value of Taiwan's machinery industry in the second quarter of 2009 was estimated at US\$ 2.69 billion, a decrease of 47% compared with the same period in 2008. The biggest sector was machining tools production, with an output value of US\$ 280 million, but the amount also shrank 65.7% relative to 2008. The second largest production came from machinery equipment that makes electronics and semiconductor related products. The production value was about US\$ 180 million, which likewise declined 60.2% from last year's. Fortunately, machinery products more closely related to daily necessities which performed noticeably better in the second quarter than the first quarter of 2009. (Data is from www.taiwantrade.com.tw)

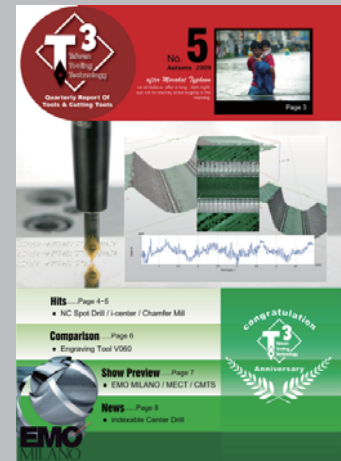
It seems the economy has hit the bottommost of recession and in the rebound since Aug. here in Taiwan. We are seeing some positive signs of industry of the economy picking up. The machine tool is moving slowly, die & mold maker is getting busy, bicycle' industrial is almost recovering to standard level, electronic parts is going up steadily. We are not seeing the orders or contracts picking up yet but definitely more work on the shop floor now. It is still a long way to recover all, but Taiwan's machinery industry is expected to recovering from the recession in the four quarter of 2009.


In October, you can find Nine9 products are presented in Milan (EMO 2009), in Toronto (CMTS 2009) and in Nagoya (MECT 2009) exhibitions. We will again present new technology and concept tool from Nine9. It meets two important factors-simple and economic which bring the production immediately value by using "indexable" tools instead of the solid tools in money saving.

We plan to increase Nine9 tools presence in specific exhibitions even they are smaller but the responses are better and focus. Thanks to our strong partnerships to promote Nine9 tools in each market.

Wish you all great success,

Vivian Yu / Manager
International Business Department



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Post-Disaster Reconstruction in Taiwan after Typhoon

Thank all the Friends

from 12 to 17 degrees Celsius (54-63 Fahrenheit). Nevertheless, during the summer (June to August) typhoons sometimes reach the island.

We all know that a typhoon comes with strong wind and torrential rain, and with these it brings terrible damage to people. Victims to typhoon disasters will never forget the severe destruction they have experienced. Yet, what in fact is a typhoon? In terms of meteorology, a typhoon is a tropical cyclone, i.e. a low pressure system developed over tropical seas.

Most typhoons that come to Taiwan originate in the western North Pacific Ocean, most frequently from the tropical sea around the Caroline Islands and the Philippines. Sometimes typhoons also originate in the South China Sea; however, they are less frequent and less powerful. Since Taiwan is in the paths of many typhoons over the western-North Pacific, Taiwan suffers severe damage caused by a typhoon invasion almost every year.

This year's Morakot typhoon was one of the most alarmed. After forming as a tropical depression over the Pacific Ocean about 1,000 km east of the Philippines on August 2nd, Typhoon Morakot built in power and moved quickly west. Over the past several days, the storm has passed over the Philippines, Taiwan and Mainland China, causing hundreds of millions of dollars in damage due to high winds, flooding and mudslides. Southeast China evacuated nearly 1 million

people ahead of the storm, after Morakot broke many records in Taiwan, dumping a total of 2.5 meters (100 inches) of rain on the island. At least 500 people are known to have died so far, but hundreds remain missing - many from one village in Taiwan, reportedly engulfed by a mudslide during the storm. It was on August 8th 2009.

Through this brief message, Jimmore would like to inform all our friends in the world who are concerned about us that at this moment, we are rebuilding our homes with the same kind of spirit and continuing to provide all sorts of outstanding products and services to you who have always trusted in us. Right now most businesses around the island have returned to normal.

Jimmore would like to wholeheartedly thank all the friends around the world who have expressed warm concerns or offered generous assistance in the rescuing efforts. At the same time, Jimmore grieves and prays with those friends who have also endured losses during this typhoon disaster, because we all believe, after a long, dark night, sun will for eternity shine brightly in the morning.

Taiwan located along the southeast coast of the Asian Continent at the western edge of the Pacific Ocean,

between Japan and the Philippines and right in the center of the East-Asian island arc, Taiwan forms a vital line of communication in the Asia-Pacific region.

Taiwan enjoys warm weather all year round. The strongest fluctuations in weather conditions are during spring and winter, while during summer and autumn the weather is relatively stable. as the annual average temperature is a comfortable 22 degrees Celsius with lowest temperatures ranging

Excerpt from
* Central Weather Bureau (Taiwan)
<http://www.cwb.gov.tw/eng/index.htm>

* Taiwantrade
<http://www.taiwantrade.com.tw>

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After using Nine9 NC Spot Drill...



ユーザーはNine9製の工具に置き換えることに決定しました。以前使っていた工具は、バリが多いことが難点でした。その難点を振り払ったのが、Nine9製の工具でした。

さらにユーザーはNine9のいい点を語っています。チップが4面使用の為、コストダウンできる今まで出逢ったことのない、送り・回転の早さユーザーはNine9のファンになりました。

Mr. Makoto Oyabu (left) /
Mr. Yuji Ikehata (right)



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"One customer has been disturbed by burrs on surface impacting their part's performance a long time. After using Nine9 NC Spot Drill, they are happy and find the performance is better than ever!" said Mr. Makoto Oyabu, the sales manager of G.C.T. Co., Ltd.

The customer appreciated and stated that "Nine9 indexable insert with 4 cutting edges optimized their cost effectiveness. The cutting speed and feed rate is the best one they had never met."

Now they want Nine9 tools for their all solutions! They become the fans of Nine9 tools.

- * Tool : 99616-10
- * Working piece : PIPE, PILLAR DC2400
- * Material : SUS304
- * Insert : N9MT080204CT-NC10
- * C1 Chamfering :
S: 2400 r.p.m.
Vc : 75.36 m/min
F : 360mm/min.
- * Tool life : 210mm x 2sides x 40pcs
Total 16.8 meters

99619-V142 142° NC Spot Drill.

H & G relies on the Nine
99619-V142 142° NC Spot Drill.

Hermesmeyer & Greweling GmbH & Co. KG relies on Nine9 Cutting Tools. Hermesmeyer & Greweling GmbH & Co. KG (H&G) is a well-known contract manufacturer for tool making as well as machine building.

The use of the 142° Nine9 NC Spot Drill gives H&G the chance to dispense the pilot boring very often. H&G do not have to do the pre-drilling anymore.

H&G can abstain from reduced feed rate when they have adverse conditions on the surface. A high speed centering tool shows a lot less abrasion than usually. The tool life of the high performance drill increase cause of the reduced vibration during the first cut.

It saves about 20 minutes in changing times and cutting times. H&G is very satisfied with the use of Nine9 99619-V142 NC Spot Drill and would like to take further actions to implement other tools of the Nine9 portfolio into the company.



Tool: 00-99619-V142-16
Material: 1.2379 (900N/mm²)
Insert : V1420803-NC2071
Vc= 59 m/min
N= 2350 rpm.
F= 210 mm/min
Ap: 2 mm

Result: Saving 20 minutes
in changing time and
cutting time per
workpiece (150 holes).

"i-center" runs well both in high & low spindle speed machines!

The "i-center" indexable center drill has good performance for drilling center holes at high spindle speed and feed rate. In order to covering the whole market, we should not forget there are still a lot of turning machines and special purpose machines have only low spindle speed. Here we are pleased to inform you that "i-center" is also possible to drill at low spindle speed without any problem!

Result:
Running well in different machine conditions. Cutting steadily without vibration. Lower feed rate is required when the spindle speed is low as well as the cutting chip is longer and the surface is a little rougher.

Run in high spindle speed:
S= 3500 r.p.m.
f= 0.2 mm/rev.
F= 700mm/min.



Run in low spindle speed:
S=500 r.p.m.
f=0.08 mm/rev.
F=40 mm/min.



Tool life is expected and machining time is dramatically shortened than HSS drill.





Making easy, easier

Mr. Peter Malm, owner of a sub-contract machine shop, MCM Automation in Canada, already used a lot of Nine9 spot drills in his company. When his local supplier, Caliber Industrial Supply showed him the latest indexable chamfer mill from Nine9, he had just the part for it.

He was regularly producing a range of blocks which were part of a welded assembly. They had a tolerance of 0.025mm on position and diameter of a hole which also needed a 0.8mm chamfer top and bottom.



Though this seemed like a relatively easy part it presented its own problems. Mr. Malm used to have his operators chamfer the second side with a countersink in a battery operated drill. This was inconsistent and caused rejections when it reached his customer. They would try and put the blocks on the welded assembly and they would get stuck on the chamfer. The customer would then send back the whole batch for checking.

In conjunction with Caliber Industrial's Sales manager, Mr. Gareth Rhys-Jones, they instigated some changes in the tooling. They job was taking 2 minutes and 40 seconds to produce with a series of HSS drills, a carbide end mill and a standard Nine9 spot drill.



SOLUTION

before

They job was taking 2 minutes and 40 seconds to produce

now

The cycle time was reduced to 1 minute and 6 seconds.

Tool life on the chamfer mill has been excellent.

They replaced the HSS drills and the Nine9 spot drill with a 3xD Power Drill and an index-able Chamfer Mill from Nine9. The cycle time was reduced to 1 minute and 6 seconds. They now produce a batch of 1,200 parts in two days where it used to take a week.

Mr. Malm stated "Though the drill probably gave me the biggest portion of the time saving it wasn't the main benefit. I now make a part without any secondary operations and I have zero rejects. I now can put anyone on the machine and get a consistent part off it".

Material:
1018 Steel

Tools:
99616-C20 Chamfer Mill

Insert:
N9GX04T002 NC2032

S=5000rpm
F=500mm/min.

"I have also freed up over a week of production time a month to make other parts" said Mr. Malm. "Tool life on the chamfer mill has been excellent, we have hardly done any indexes since we started using it a couple of months ago.



Mr. Rhys-Jones of Caliber Industrial (left), alongside Mr. Malm and Mr. Lijiu Wang of MCM Automation



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Fax : +(1) 416-626-7170

<http://www.caliberindustrial.com>

E-mail : sales@caliberindustrial.com



"Ultra high speed and feed rate is the biggest advantage of Nine9 Chamfer Mills."

It is not a traditional chamfer tool, it runs 4 times faster in cutting speed and 10 time higher in feed rate. It is the most efficient tool you ever met. Do not miss this tool to optimize the performance and reduce the cutting time.

Time is Money!



Engraving Tool V060

Nine9 Engraving !

To optimize engraving characters on CNC machine by Nine9 Indexable engraving tool!

The tools to engrave character on work piece by NC program can be done by Nine9 Engraving tool 00-99616-V060 (Fig. 1), engraving tool (Fig. 2) and the ball nose end mill (Fig. 3).

The engraving result was measured by Alicona Infinite Focus System, the form and roughness can be measured on the same machine and same operation.




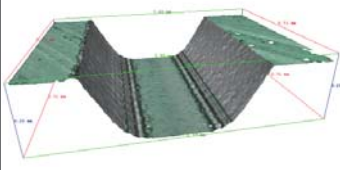
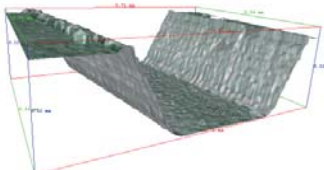
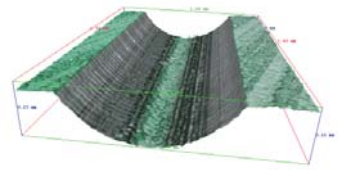
1234567890 V (Fig. 1)

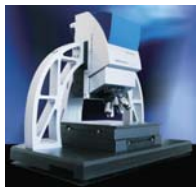
1234567890 A (Fig. 2)

1234567890 R (Fig. 3)

Test result :

Work piece material : Tool steel SKD 61 (JIS G 4404)
Hardness: HRB92~93 (≒ HB 200)
Engraving depth: 0.2 mm

Tool	 00-99616-V060 (Fig. 1)	 Engraving tool (Fig. 2)	 Ball nose end mill Radius 0.4 mm (Fig. 3)
Cutting data			
Spindle speed r.p.m.	10000	10000	10000
Feed rate mm/min.	100	100	300
Cutting depth Ap	0.2 mm	0.2 mm	0.05 mm, 4 times to cut to 0.2 μm
Roughness of bottom Ra	0.36 μm	0.83 μm	0.46 μm
Result of the groove	Good, burr is less than 2 μm.	Acceptable, burr is 15 μm	Less burr, but longer cutting time.
Tool life	Long	Short	Short
Measured result by Alicona IFM system			



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Show Preview

7

EMO MILANO

Show Dates : October 5-10, 2009

Show Location : FIERAMILANO, Italy

In any case, the internationality of the event - held in Milan every six years - is witnessed by impressive attendance of international exhibitors: 70% of total representing 34 countries.

Metal forming and metal cutting machine tools, machines for welding, for thermal and surface treatments, robots, automation hardware and software, assembling, tools, parts, components, accessories, metrology, quality control, systems for safety and environmental protection ...

All the ways, even the most difficultly definable ones, by which the "know-how" of the sector universe can find a quite appropriate expression, are presented at EMO, making the exhibition, promoted by CECIMO, the most eagerly awaited event for the operators of the worldwide manufacturing industry.



NINE-9 CUTTING TOOLS CO., LTD.

Visit Booth Hall 10, Booth B26

MECHATRONICS TECHNOLOGY JAPAN 2009 < MECT 2009 >

Show Dates : October 14-17, 2009

Show Location : Port Messe Nagoya(Nagoya Int'l Exhibition Hall), Nagoya, Japan

Introducing advanced machine tools and related products at the center of Japan's manufacturing industry for upgrading of manufacturing technologies and further expansion of domestic and international businesses.

Following is the list of Pavilions:

Machine tools, plastic processing machinery, machine tools, cutting tools, abrasives, grinding wheel, and instruments, CAD / CAM / CAE, FA equipment related equipment software, and other related services.



Visit Booth No. 2A02

Canadian Manufacturing Technology Show 2009

Show Dates : October 19-22, 2009

Show Location : Direct Energy Centre Toronto ON CAN

Canada's definitive event for manufacturing technology & innovation. In 2007, CMTS attracted over 8,000 manufacturing professionals. In a June 2009 survey by SME, 75% of past CMTS attendees indicated they made a purchase as a result of attending the show. Make sure your company is there this year to reach qualified decision makers who are looking for new equipment and solutions.

Reach these professionals from several key industries including aerospace, automotive, defence, energy, medical, pharmaceutical, and transportation. CMTS—Canada's Definitive Event for Manufacturing Technology and Innovation—attracts every industry looking for the latest technologies.

CMTS

Canadian Manufacturing Technology Show



**CALIBER
INDUSTRIAL SUPPLY
COMPANY LIMITED**

Visit Booth No. 30015

indexable Center Drill

- **Highly Efficient Tools**
- **Time Saving**
- **No Re-setting,
No Resharpener**
- **Long Tool Life**
- **Improve your Process Performance**

Undeniable benefits of i-center

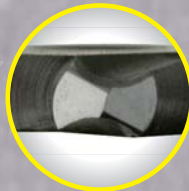
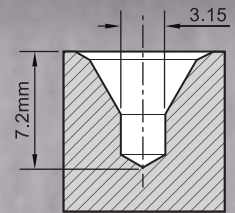
i-center is the unique solution in the world to up grade the center drill process into the indexable generation leaving HSS and solid carbide centering as ancient history.

Example of comparison:

Work piece: Low carbon alloy steel, 850 N/mm²

Diameter of tool: Ø3.15 mm Depth of drilling: 7.2 mm

Machine: Vertical Machining Center, BT40 with internal coolant



2 cutting edges



i-center



HSS
Center drill



Solid carbide
center drill

		i-center	HSS Center drill	Solid carbide center drill
Cutting speed	m/min.	65	15	52
Spindle speed	r.p.m.	6570	1516	5257
Feed rate f =	mm/rev.	0.12	0.02	0.1
Feed rate F=	mm/min.	788.4	30.32	525.7
Coolant	Emulsion	External / Internal	External	External
Drilling time	sec.	0.55	14.25	0.82
Holes of drilling per edge		3000	200	2000

Chinese language teaching

第五課 不好意思!我迷路了! Lesson 5 Excuse me, I'm lost!

課文 TEXT

安迪：不好意思! 可以 幫我嗎?

An Di : Bu Hau Yi Sz ! Ke Yi Bang Wo Ma?

我迷路了!

Wo Mi Lu Le !

Andy : Excuse me, Could you help me? Please.
I'm lost!

洛克：你要去哪裡呢?

Luo Ke : Ni Yau Chiu Na Li Ne ?

Rocky : Where are you going?

安迪：我要到火車站!

An Di : Wo Yau Dau Huo Che Jan !

Andy : I'm going to the train station.

洛克：沿著這條路繼續走十分鐘，

Luo Ke : Yan Jau Je Tiau Lu Ji Shiu Tzou Shr Fen Jung,

你就會看到火車站了

Ni Jiou Huei Kan Dau Huo Che Jan Le

Rocky : Walk down the street for about 10 minutes and you
will see the train station.

安迪：好的! 謝謝你!

An Di : Hau De ! Shie Shie Ni !

Andy : Okay! Thank you very much!

洛克：不客氣! 路上小心車子!

Luo Ke : Bu Ke Chi ! Lu Shang Shiau Shin Che Tz !

Rocky : You are welcome! Watch out the cars on your way.