

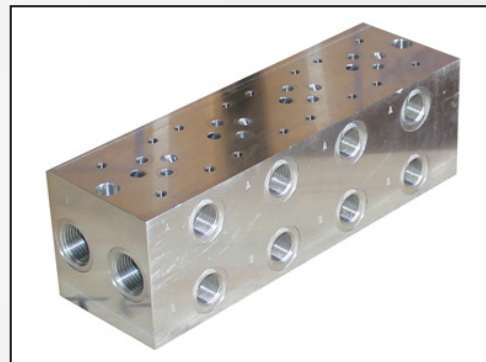


## Hydraulic Manifold Port Block: AccuPort 432®

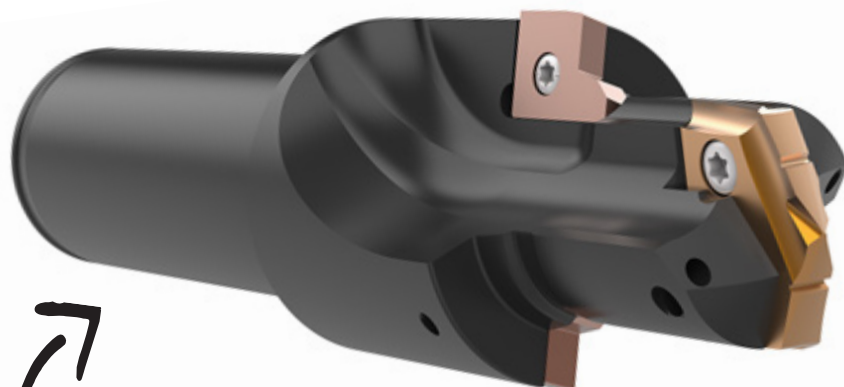
A production job shop is manufacturing hydraulic manifolds for various companies. They were using a Mazak 15HP horizontal CNC machining center with CAT 40 taper spindle and 200 PSI (14 bar) water soluble oil coolant through the spindle. The part being machined is a hydraulic manifold port block made out of nonheat treated wrought bar aluminum.

Seeking a better way to produce the hydraulic manifolds, the customer wanted to manufacture their products at a lower cost with fewer tools.

With the **AccuPort 432®** tool, the customer was able to produce their products at a very low cost. They were also able to reduce their tooling to just one tool instead of the previous three.



		Competitor	AccuPort 432®
<b>Product:</b>	AccuPort 432®		
<b>Objective:</b>	Decrease costs		
<b>Industry:</b>	General machining		
<b>Part:</b>	Hydraulic manifold port block		
<b>Material:</b>	Non-heat treated wrought aluminum bar	<ul style="list-style-type: none"><li>• 90° drill point (initial spot drill in 5 locations)</li><li>• Carbide tipped drill (20.5 mm deep)</li><li>• Special Metcut carbide tipped form tool (produced a spot face O-ring seat contour)</li></ul>	AccuPort 432 holder (item X1926-101-100F) with an extended length port contour cutter outfitted with a CPM-M4 TiN coated drill insert and port form inserts (item J1926-07-C5A)



► AccuPort 432®  
X1926-101-100F

► Insert  
J1926-07-C5A

67% total cost savings

The AccuPort 432® provided:

- ✓ Increased cost savings
- ✓ Reduced required tooling