Valve Choke Body: AccuThread 856

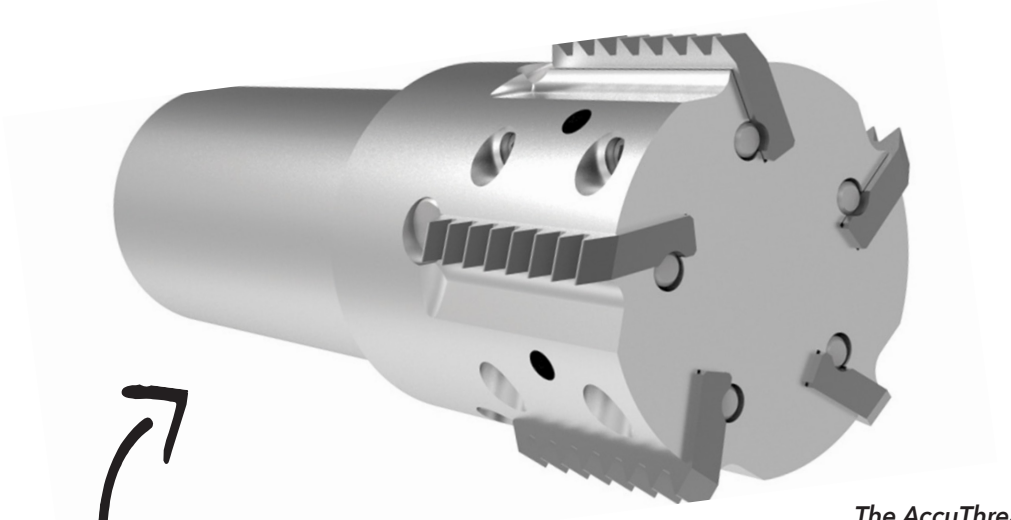
A customer is manufacturing components for the offshore oil industry using a Mazak VMC running with 500 PSI *(34 bar)* coolant. They are machining a choke body for a valve made of 410 stainless steel.

Looking for improvements, the customer needed to reduce cycle time and decrease the cost of production.

The **AccuThread 856** lowered the cost of production.

Product:	AccuThread 856 Indexable
Objectives:	(1) Decrease cycle time (2) Decrease cost of production
Industry:	Oil & gas/petrochemical
Part:	Valve choke body
Material:	410 Stainless steel
Hole Ø:	0.6560" *(16.662 mm)*
Hole Depth:	0.6250" *(15.875 mm)*

Measure	Competitor	AccuThread 856
RPM	2500	3087
Speed	324 SFM *(98.755 M/min)*	400 SFM *(121.92 M/min)*
Feed Rate	0.0045 IPR *(0.114 mm/rev)*	0.006 IPR *(0.152 mm/rev)*
Penetration Rate	2.76 IPM *(70.104 mm/min)*	4.55 IPM *(115.57 mm/min)*
Cycle Time	1 min 38 sec	1 min 2 sec
Tool Life	110 holes	110 holes



AccuThread 856
TMUK0750-10

36% cycle time decrease

The AccuThread 856 Indexable provided:

- ✓ Decreased cycle time
- ✓ Maintained tool life
- ✓ Decreased cost of production