



Clutch Castings: AccuPort 432®

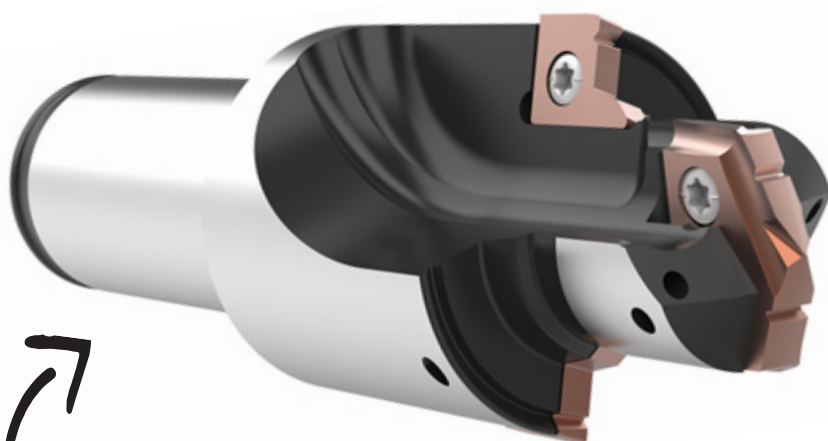
The end-user is machining clutch castings made from 6061 Aluminum, using a horizontal machining center with water soluble coolant.

The customer did not want to use multiple tools for this process. They asked Allied Machine for a solution to complete this application with one tool.

The **AccuPort 432®** finished the job with one pass and eliminated the need for multiple tooling.



Product: AccuPort 432® Objectives: Reduce required tooling Industry: General machining Part: Clutch castings Material: 6061 Aluminum Hole Ø: 0.6496" (16.5 mm) Hole Depth: 0.70" (17.78 mm)	Measure	Competitor	AccuPort 432®
	RPM	3881	8232
	Feed Rate	0.012 IPR (0.305 mm/rev)	0.004 IPR (0.102 mm/rev)
	Penetration Rate	46.5 IPM (1181.1 mm/min)	98.8 IPM (2509.52 mm/min)
	Cycle Time	5.13 sec	5.43 sec
	Tool Life	5,000 holes	5,000 holes
	AccuPort 432 offered 41% cost per hole savings over the competitor tooling.		



- ▶ AccuPort 432®
Item No. 16149-08R0-20FM
- ▶ T-A® Insert
Item No. 4C10H-16.5

41% cost per hole decrease

The AccuPort 432® provided:

- ✓ Decreased cost per hole
- ✓ Reduced required tooling