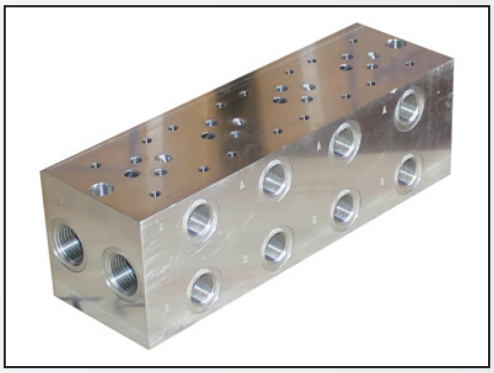
## Hydraulic Manifold Port Block: AccuPort 432®

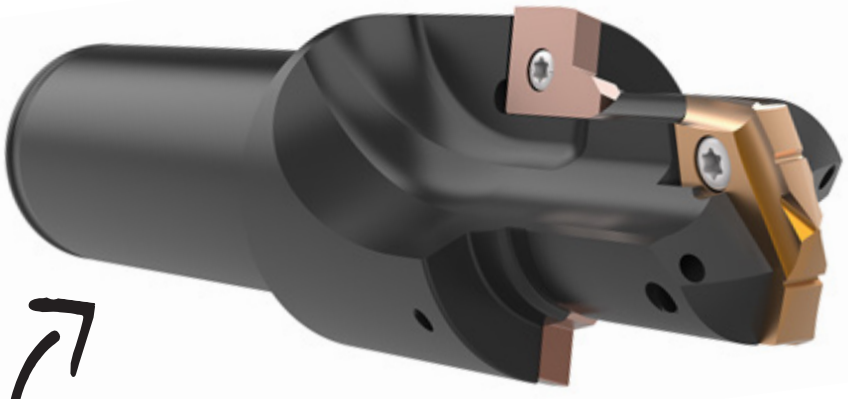
A production job shop is manufacturing hydraulic manifolds for various companies. They were using a Mazak 15HP horizontal CNC machining center with CAT 40 taper spindle and 200 PSI water soluble oil coolant through the spindle. The part being machined is a hydraulic manifold port block made out of nonheat 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® |
|---|---|---|---|
| **Product:** | AccuPort 432® | | |
| **Objective:** | Decrease costs | • 90° drill point (initial spot drill in 5 locations)<br>• Carbide tipped drill (20.5 mm deep)<br>• Special Metcut carbide tipped form tool (produced a spot face O-ring seat contour) | 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) |
| **Industry:** | General machining | | |
| **Part:** | Hydraulic manifold port block | | |
| **Material:** | Non-heat treated wrought aluminum bar | | |



- AccuPort 432®
  ***X1926-101-100F***
- Insert
  ***J1926-07-C5A***

67% total cost savings

***The AccuPort 432® provided:***

- ✓ Increased cost savings
- ✓ Reduced required tooling