



Hydraulic Manifold Blocks: AccuPort 432®

A contract machine shop is manufacturing specialized hydraulic manifold blocks made out of low carbon steel. They are using a KIWA HMC with 1000 PSI (69 bar) coolant through the spindle. They are mounting 16 blocks on one tombstone at a time.

Turning to AMEC for improvement, the customer wanted to reduce the costs of machining the manifold blocks.

With the **AccuPort 432®** drill and finish port forms being completed in one operation, pre-drilling was no longer required. Furthermore, the replaceable insert design eliminated regrinding.



		Measure	Competitor	AccuPort 432®
Product:	AccuPort 432®		2 Tool Process	
Objective:	Reduce costs		• Guhring solid carbide drill	• 2000 RPM
Industry:	General machining		• Hartland T-15 port forming too	• 202 SFM (61.57 M/min)
Part:	Specialized hydraulic manifold blocks			• 0.005 IPR (0.127 mm/rev)
Material:	Low carbon steel	Cycle Time	24 min	16 min



► AccuPort 432®
Special AccuPort 432 #4 port with
pilot length .512"

33% cycle time decrease

The AccuPort 432® provided:

- ✓ Decreased cycle time
- ✓ Reduced required tooling