



Valve Choke Body: AccuThread™ 856

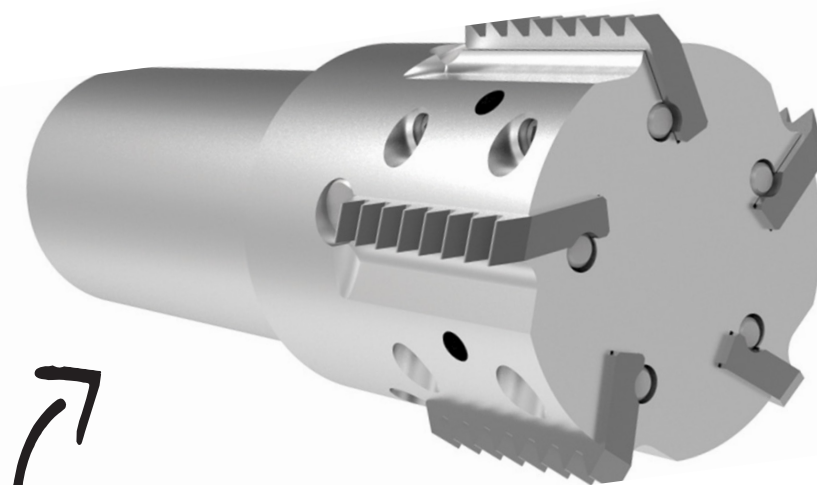
A customer is manufacturing components for the offshore oil industry using a Mazak VMC running with 500 PSI coolant. They are machining a choke body for a valve made of 410 stainless steel.

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	Measure	Competitor	AccuThread™ 856
Objectives:	(1) Decrease cycle time (2) Decrease cost of production	RPM	2500	3087
Industry:	Oil & gas/petrochemical	Speed	324 SFM	400 SFM
Part:	Valve choke body	Feed Rate	0.0045 IPR	0.006 IPR
Material:	410 Stainless steel	Penetration Rate	2.76 IPM	4.55 IPM
Hole Ø:	0.6560"	Cycle Time	1 min 38 sec	1 min 2 sec
Hole Depth:	0.6250"	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