



End Cap: AccuThread 856

A customer is producing job shop blue print work for the automotive, agriculture, and plastic industries. They are manufacturing end caps from structural steel using a Mazak AJV 6080 VMC running with water soluble coolant. The end cap requires 4 tapped holes per part.

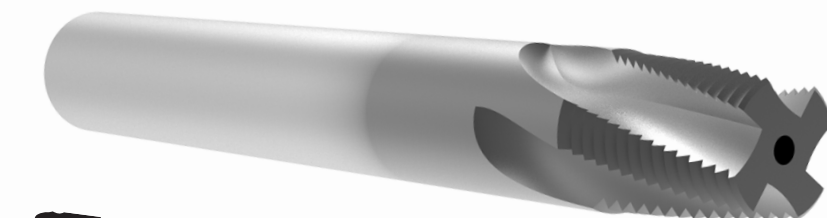
The pipe tap was being torn by the thread, which resulted in the poor tool life. Unsatisfied with their current process, the customer needed to reduce the cost of production and increase tool life.

The **AccuThread 856** blew the customer away by the increase in productivity.



Product: AccuThread 856 Solid Carbide Objectives: (1) Increase tool life (2) Decrease costs Industry: General machining Part: End Cap Material: Structural Steel Hole Ø: 1.20" (30.48 mm) Hole Depth: 0.7515" (19.088 mm)	Measure	Competitor	AccuThread 856
	RPM	10	2156
	Speed	0 SFM	350 SFM (106.68 M/min)
	Feed Rate	0.010 IPR (0.254 mm/rev)	0.002 IPR (0.0508 mm/rev)
	Penetration Rate	0.10 IPM (2.54 mm/min)	2.17 IPM (55.118 mm/min)
	Cycle Time	39 min 15 sec	3 min 36 sec
	Tool Life	1 hole	192 holes
	AccuThread 856 offered 96% cost per hole savings over the competitor tooling.		

► AccuThread 856
Item No. TMNK1000-NPT



96% cost per hole decrease

The AccuThread 856 Solid Carbide provided:

- ✓ Increased tool life
- ✓ Decreased cycle time
- ✓ Decreased cost per hole