



## Valves and Fittings: AccuThread 856

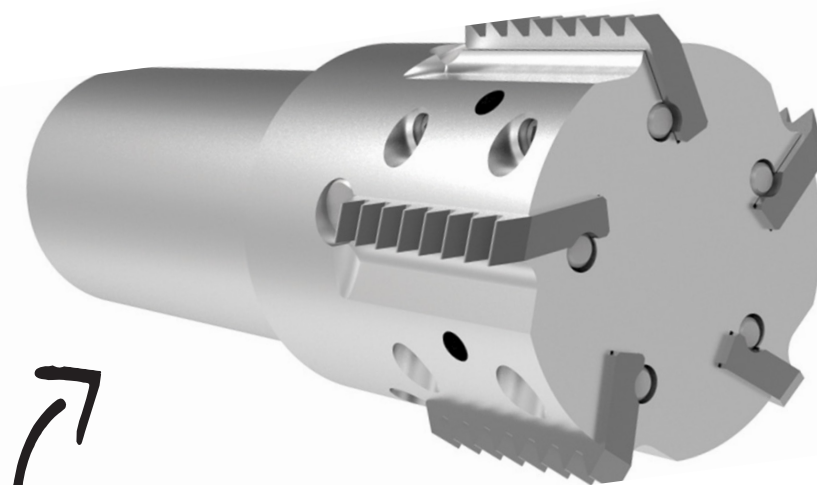
The customer is machining valves made from 4140, using an OKK HM800S horizontal machining center, with 800 PSI (55 bar) water soluble coolant.

The customer was having issues with the thread quality and invited Allied to test its thread mill against Xactform.

The **AccuThread 856** made a significant difference for the customer by meeting the goals of improved thread quality.



		Measure	Competitor	AccuThread 856
Product:	AccuThread 856 Indexable	RPM	1300	1800
Objectives:	Improve thread quality	Feed Rate	0.004 IPR (0.102 mm/rev)	0.006 IPR (0.152 mm/rev)
Industry:	General machining	Penetration Rate	2.6 IPM (66.04 mm/min)	5.98 IPM (151.892 mm/min)
Part:	Valves & fittings	Cycle Time	6 min 2 sec	1 min 19 sec
Material:	4140	Tool Life	475 holes	1000 holes
Hole Depth:	2.0" (50.8 mm)			



▶ AccuThread 856  
TN150K-UN14I  
THP-1116-3F150

110% tool life increase

The AccuThread 856 Indexable provided:

- ✓ Decreased cycle time
- ✓ Increased tool life
- ✓ Improved thread quality