Precision Parts: AccuPort 432®

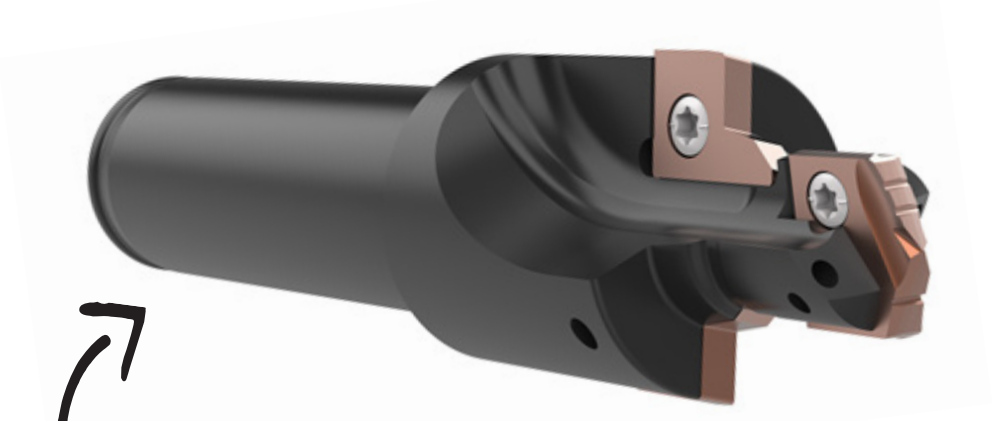
An aerospace manufacturer is producing high quality precision parts for commercial, military, and space components made out of stainless steel. They are using an Okuma NXVA 4 axis VMC with 1,000 PSI *(69 bar)* coolant through the tool.

Using a total of 5 tools to produce their products created several problems for the customer. For example, they had to deal with elevated regrind and stocking fees, increased tool changes, and quality issues due to blending several tool operations. Additionally, the customer was also having a problem producing a quality port because of the required 10" *(254 mm)* reach and needed a better finish.

The **AccuPort 432®** was successful. Not only was the customer was able to significantly reduce their cycle time, but they also dramatically increased tool life. Therefore, the customer greatly decreased their cost of production.

Product: AccuPort 432®
Objective: Reduce required tooling
Industry: Aerospace
Part: Precision parts
Material: Stainless steel

Measure	Competitor	AccuPort 432®
	4 Tool Process • Spot tool • Drill • End mills (2 different sizes) • Special port form	• 650 RPM • 0.006 IPR *(0.152 mm/rev)*
Cycle Time	18 min 41 sec	30 sec



- AccuPort 432®
  J1926-04-063F
- Insert
  J1926-02-05A

97% cycle time decrease

The AccuPort 432® provided:

- ✓ Decreased cycle time
- ✓ Reduced required tooling