



7792 Case Histories



Material: 4140 steel – 280 - 320 HBN
 Industry: Die/Mold
 Job: 17 holes – 51,59mm diameter, 67,74mm deep
 Cycle time: 4.5 hours

7792 Solution:
 Cutter: Modular 7792VXD09 (25mm Cutter)
 Extension: Anti-vibration, heavy-alloy Modular Shank
 Insert Grade: X400
 Process: High Feed Helical Interpolation
 Cycle time: 1 minute 45 seconds per hole
 Total Cycle time: 30 minutes

90% Reduction in Cycle Time



Material: 6-4 Titanium
 Job: Machine pockets in aerospace component
 Cycle time: 5.5 hours

7792 Solution:
 Cutter: 7792VXD12 (160mm Cutter)
 Insert Grade: X500
 Cycle time: 1 hour 20 minutes

75% Reduction in Cycle Time



Material: 6-4 Titanium
 Job: Turn a 1463mm diameter by 340mm deep ring
 Industry: Aerospace
 Turning Cycle time: 4 hours 35 minutes

7792 Solution:
 Cutter: 7792VXE16 (125mm Cutter)
 Insert Grade: X500
 Process: Mill turning
 Workpiece rotates on B axis at 0,26 RPM
 Spiral milling feed rate of 60mm per revolution
 Cycle time: 2 hours 24 minutes

Spiral Milling Cuts Cycle Time 48%