



77 Family Case Histories

7710 Case History

Material: 600 Series High Temperature Alloy
 Cutter: 7710VRD20 (100mm Cutter)
 Component: Heat Exchanger Pump Housing
 Industry: Power Generation - Nuclear
 Insert Grade: X500
 RPM: 105
 Cutting Speed V_C : 33,5 m/min
 Feed per Tooth f_z : 0,323mm
 Feed Rate: 203 mm/min
 Depth of Cut a_p : 6,35mm

60% Reduction in Cycle Time

- 150% Productivity Increase
- 60% Reduction in Tooling Costs
- Zero Failures
- Zero Defects
- Finishing Operation Eliminated

7713 Case History

Material: Stainless Steel 300 Series
 Cutter: 7713VR12 (63mm Cutter)
 Component: Turbine Blade
 Industry: Power Generation
 Insert Grade: SP6519
 RPM: 909
 Cutting Speed V_C : 180 m/min
 Feed per Tooth f_z : 0,3mm
 Feed Rate: 1,636 m/min
 Depth of Cut a_p : 2,2mm

80% Increase in Tool Life!

