Diesel Engine Fuel Systems Machining Solutions

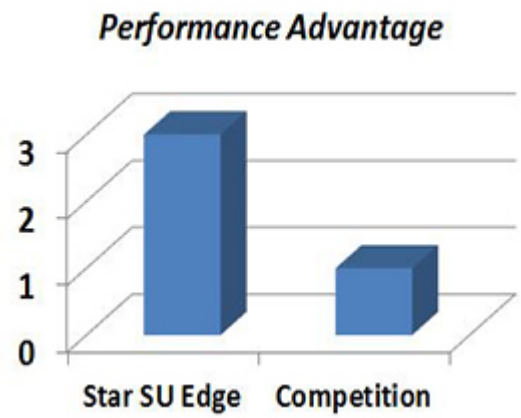
Common Rail Deep Hole Drilling

Work Piece

- Common Rail Drilling
- Ovako Steel
- Hardness 275-300 HB

Work Conditions

- Common Rail Deep Hole Drilling
- Coated Carbide Gundrill
- High Pressure Through Coolant
- 2600 RPM, 100 mm/min



Results

- Increased Tool Life 3x
- Enhanced Size Control
- Eliminated Honing
- Excellent Surface Finish
- Superior True Position
- Reduced Scrap
- Eliminated Drill Breakage
- Lowered CPU

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