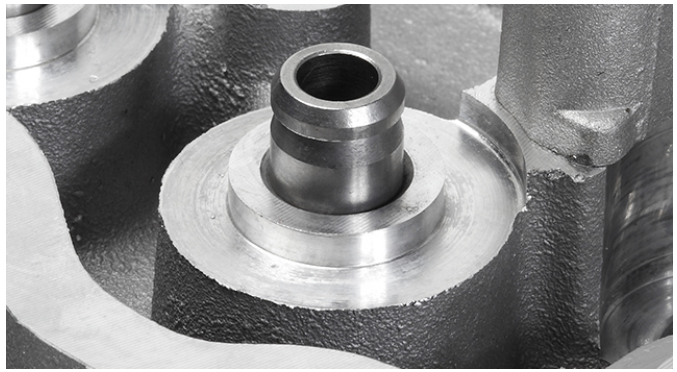
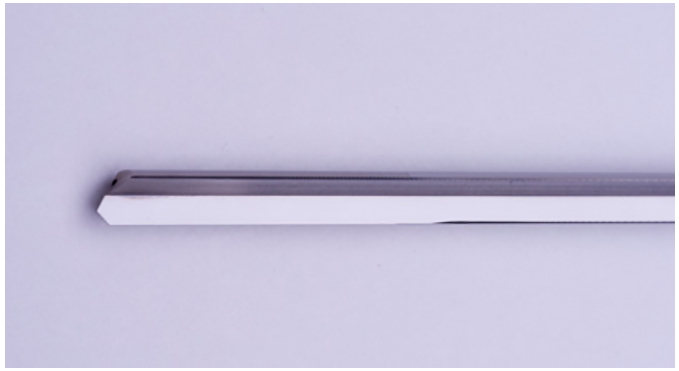
Valve Guide Drilling Solutions

Valve Guide Gundrilling



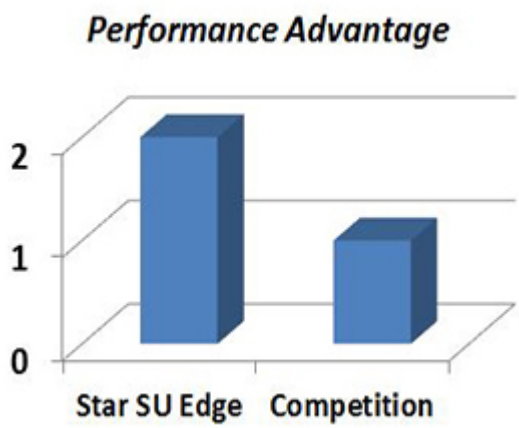


Work Piece

- Powder Metal Valve Guide
- FM Sintered Material
- 80-110 HRB

Work Conditions

- Drill Valve Guide ID
- Coated Solid Carbide Gundrill
- High Pressure Through Coolant
- 10 mm diameter X 98 mm deep
- 2160 RPM, 770 mm/min



Results

- Increased Tool Life 2x
- Enhanced Bore Roundness
- Excellent Size Control
- Improved ID straightness
- Improved reaming operation
- Tool Life 3400 Pieces
- Lowered CPU

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