

# Alloy Steel Machining ~ Enhanced Productivity & Process Up-gradation

95% of the Energy consumed in Metal Cutting is converted into Heat which can raise the Temperature at the Point-of-cut causing a Serious Concern !



Heat dissipation & Good Lubricity are of Prime Importance in  
High Speed Machining

## Component – P110 Steel 5 ½ BTC Couplings



Operation – Buttress Threading

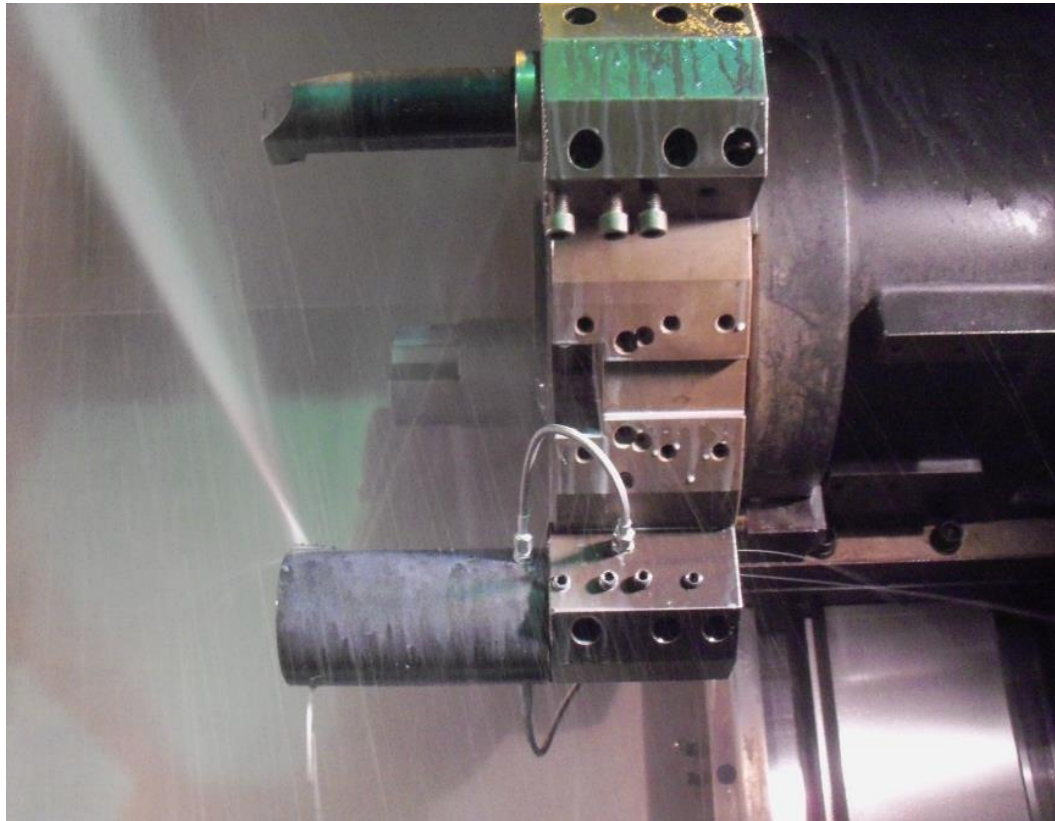
## Customer Concerns



- Low Productivity
- Unpredictable Tool life/performance
- Operator fatigue
- Less output per CNC
- Poor house keeping



## Process Up-gradation with Sovereign Fortune Force



High Clarity High Force Coolant jet right at the point of cut!!

## Mission Accomplished



Chips generated at 85 bar (30 LPM) with Sovereign Fortune Force trials on Doosan Puma 400 B Turning Center.

**Material: P110, Component: 5 ½" BTC Coupling.**

## Rewarding Results

- Generation of Small & Manageable Chips as oppose to previous Long, Curly, Bushy Chips.
- Excelling Finish & Geometry!
- Productivity Increase by +15%
- Tool Life Increase by +100%
- Predictable & Consistent Tool Performance
- Improvement in Thread Surface Finish
- Operator fatigue eliminated
- High Machine Uptime
- Excellent House Keeping

## **Sovereign Fortune Force at Reputed oil Rig Component Manufacturer on Doosan CNC**

