**Objective & Results**
The increasing use of Compacted Graphite Iron (CGI) for state-of-the-art, high-powered engines has created challenges for cylinder block and cylinder head manufacturing. The high-strength CGI material wears out tools a minimum of 30% faster and has eliminated higher speed machining that was possible in Gray Iron. By applying through-the-spindle and through-the-tool Cryogenic Machining Technology, the cutting edge is cooled while maintaining normal cutting temperatures. The end result is a clean environment and, for the first time, the ability to high-speed machine CGI while still improving tool life.

**Cryogenic Advantages**
- High-Speed Finish Machining Parameters of 500 m/min
- Negligible Tool Wear After 60 min at 500 m/min
- Easy to Manage Dry Chips
Testing SOW

> Material: Compacted Graphite Iron (CGI)
> Test Part: Bar Stock
> Tool: 5ME™ Cryogenic Single Point, Indexable Turning Tool
> Parameters: 500M/min, 1649 SFM, 0.008” per Rev, 0.006” DOC
> Machine: Hawk 150 HTC
> Location: 5ME Technology Center