



CASE STUDY.

PROJECT PROFILE:

ASC 320[®]

Bronze

An End-user is manufacturing die sets and components for the tool and die industry using a Haas VF-4 with 300 PSI coolant. The part they are machining is a wearplate made out of bronze.

+ CHALLENGE:

Previously, the customer was using a Guhring solid carbide drill with Firex coating running at the following parameters: 5046 RPM, 454 SFM, 0.008 IPR, and 40.36 IPM. The tool had a cycle time of 1.3 seconds and a life of 6000 holes. To improve their production process, the customer wanted to increase tool life and decrease cycle time.

+ OUR SOLUTION:

AMEC recommended the ASC 320[®] Solid Carbide High Penetration Drill item #335E03438A21M running at: 6000 RPM, 540 SFM, 0.008 IPR, and 48.0 IPM. The tool drilled a 0.90" deep hole with a 0.3438" diameter. The results of the test were excellent. The tool lowered cycle time to 1.1 seconds and dramatically increased tool life to 12,000 holes. The ASC 320[®] tool also lowered the customer's cost of production. The customer received a total cost savings of \$134.25 or 25.5%.

+ PROJECT DATA:

Due to the successful performance of the ASC 320[®] Solid Carbide High Penetration Drill, the customer was able to increase tool life and decrease cycle time while lowering their cost of production.



EXTENDED TOOL LIFE