



## CASE STUDY.

### PROJECT PROFILE:

## ASC 320<sup>®</sup> Free Machining Steel

A machine shop that utilizes screw and rotary transfer machines to produce valves and pressure connectors for the automotive industry is looking to maximize the capabilities of a new machine to increase production. The production increase is key to opening the door to additional orders with their largest customer.

#### + CHALLENGE:

Previously, an 8.8 mm carbide Iscar drill was being run at 2036 RPM, 0.006 IPR and 12.21 IPM and getting a tool life of 11,000 holes.

#### + OUR SOLUTION:

AMEC suggested using an ASC 320<sup>®</sup> Hi-Pen 3.5xD drill item #335M8800A21M. The drill was to be run at 3300 RPM, 0.008 IPR and 26.4 IPM.

#### + PROJECT DATA:

The Allied ASC 320<sup>®</sup> drill increased tool life from 11,000 holes to 21,000 holes while decreasing cycle time from 3 minutes 4 seconds to 1 minute 50 seconds. IPM doubled from 12.21 to 26.41. With cost per hole savings of \$11,932.12 annually, the customer not only took on new jobs, they purchased an additional Hydromat machine!



## INCREASED PRODUCTIVITY