



CASE STUDY.

PROJECT PROFILE:

ASC 320[®]

High Temperature Alloy Steel

A job shop is manufacturing small bushings made out of 625 Inconel round bar stock for the aircraft industry. They are using an Okuma Cadet LNC-8C with low pressure coolant to manufacture their products.

+ CHALLENGE:

Previously, the customer was using a 19/64" cobalt drill to drill a pilot hole while using a peck cycle. They ran the tool at a speed of 40 SFPM, 514 RPM, 0.006 IPR, and 3.08 IPM. The tool had a life of 12 parts. This process was followed by a 5/16" diameter carbide tipped reamer running at a speed of 38 SFPM, 475 RPM, 0.006 IPR, and 2.85 IPM. This tool had a life of 50 parts. Seeking to improve their production, the customer was having concerns about cycle time and tool life and was also having difficulty drilling.

+ OUR SOLUTION:

AMEC recommended using the ASC 320[®] High Penetration Drill item #335E3125A21M. The results were excellent. Not only did the ASC 320[®] tool eliminate the reaming operation, it also saved valuable spindle time by eliminating the peck cycle. Additionally, the ASC 320[®] drill produced excellent chip control, increased the tool life to 150 parts, and saved over 4 minutes in cycle time. With the cost per hole reduced from \$1.17 to \$0.50, the AMEC tooling created a savings of \$0.67 per part. The customer received a total cost savings of \$99.90 or 43%.

+ PROJECT DATA:

By reducing the customer's cycle time and cost of production and increasing tool life, AMEC succeeded in providing the customer with an effective solution to their needs.



*INCREASED
PRODUCTIVITY*