CASE STUDY.

ASC 320®

PROJECT PROFILE: Stainless Steel

An End-user is manufacturing aerospace fittings made out of stainless steel. They are using a Nakamura-Tome with a Valcool semi-synthetic coolant to manufacture their products.

REDUCED COST OF PRODUCTION

+ CHALLENGE:

Previously, the customer was using a Guhring 3x diameter 5510 series drill running at a speed of 1500 RPM, 0.003 IPR, and 165 SFM. The tool had a cycle time of 27 seconds. Seeking to beat their competition, the customer wanted to reduce their cost of production.

+ OUR SOLUTION:

In response to the customer's desire for improvement, AMEC suggested using an ASC 320® 27/64" 3.5x diameter drill item #335E04219A21M. They recommended running the tool at a speed of 1800 RPM, 0.0045 IPR and 198 SFM. The results were outstanding. The AMEC tool exceeded the tool life of the previously used Guhring drill. After machining 2500 pieces, the ASC 320® drill was still in excellent condition. Additionally the tool was able to reduce cycle time to 15 seconds and improve hole quality. Also, since the customer was saving $0.25 per part and producing approximately 100,000 parts per year, they were able to receive an annual savings of $25,000.

+ PROJECT DATA:

Not only was the ASC 320® drill able to provide the customer with a substantial cost savings and better hole quality, it also reduced the machine's cycle time.