



CASE STUDY.

PROJECT PROFILE:

GEN2 T-A[®]

SK Ductile Iron Major Appliance

The end-user is manufacturing motor housings made out of Ductile Iron using a Kingsbury machine, with flood coolant.

+ CHALLENGE:

Previously the Kingsbury customer was using a CJT carbide-tipped special drill, running at the following parameters: 1860 RPM, 0.017 IPR (0.43mm/rev), which resulted in 31.62 IPM (803.1mm/min). The tool drilled a 1.071" (27.2mm) diameter hole to a depth of 1.250" (31.8mm). The drill had a tool life of 900 holes. Looking for improvements, the customer wanted to increase throughput on their existing equipment.

The previous tooling cost was \$147.91, plus an additional \$67.53 to re-tip the old tools. Tool life averaged 900 holes.

+ OUR SOLUTION:

Allied recommended GEN2 T-A[®] using insert item 4C22H-1.071-SK and a special holder, 070305-3. The tooling ran at the same speed of 1860 RPM, 0.017 IPR which resulted in 31.62 IPM. The outcome was excellent and met the customer's goals. GEN2 T-A[®] was able to drill 4000 holes, an increase in tool life by 4.4 times.

+ PROJECT DATA:

The Cost per Hole was reduced from \$0.044 to \$0.042, a 5% savings.

The number of parts drilled in this application increased from 1,000,000 to 1,250,000, making the savings realized, a very impressive \$39,874.

The customer was able to get more productivity out of his existing production lines without the need to invest in additional machines.



*EXTENDED
TOOL LIFE*