



CASE STUDY.

PROJECT PROFILE:

GEN3SYS[®] 304 SS Job Shop Automotive

The end-user is manufacturing fuel pumps made out of 304 stainless steel, 275 Bhn, using a Gildemeister GM67 mill turn machine, with water soluble oil coolant.

+ CHALLENGE:

Previously the customer was using a Guhring RT 800 drill running at the following parameters: 530 RPM, 0.008 IPR (0.20 mm/rev), which resulted in 4.24 IPM (107.69 mm/min). The tool drilled a 0.9375" (23.81 mm) diameter thru hole to a 2.125" (53.97 mm) depth. The drill had a tool life of 400 holes. The cost-conscious customer was looking for improved machining costs.

+ OUR SOLUTION:

Allied recommended GEN3SYS using insert item 5C122H-0030 and holder 60322H-100F. The tooling ran at a speed of 610 RPM, 0.008 IPR (0.203 mm/rev), which resulted in 4.88 IPM (123.95 mm/min). The GEN3SYS delivered a 15% increase in penetration rate, and was able to achieve a tool life of 485 holes (1031 linear inches) versus Guhring's 400 holes (850 linear inches) resulting in a 17.5% increase.

+ PROJECT DATA:

The GEN3SYS High Penetration Drilling System delivered what the end-user was looking for, based on the extended tool life and enhanced penetration rates. These performance improvements reduced the cost per hole from \$0.703 to \$0.568 for a cost savings of nearly 20%.

GEN3SYS was the clear all-around winner when matched against the Guhring RT 800 drill.



*INCREASED
PRODUCTION
EFFICIENCY*