



CASE STUDY.

PROJECT PROFILE:

GEN3SYS[®] 12L15 Automotive

The end-user is machining axle spacers for trucks, made from 12L15 using a Haas VF3 horizontal machining center, with flood coolant.

+ CHALLENGE:

Previously the customer was using an Seco Crownloc drill, running at the following parameters: 2000 RPM, 0.005 IPR, (0,13 mm/rev) which resulted in 10 IPM (254,0 mm/min). The tool drilled a 0.500" (12,7 mm) hole through 0.500" (12,7 mm) material. The tool had a cycle time of 3.0 seconds and a tool life of 3600 holes. The customer was experiencing alignment inconsistency in the tool, plus he wanted to improve tool life. Allied was contacted and offered the opportunity to provide a solution to this problem.

+ OUR SOLUTION:

Allied recommended the GEN3SYS[®] High Penetration System using insert item 5C112H-0016 and holder 60312S-075F. The tooling ran at a speed of 2200 RPM, 0.007 IPR (0,18 mm/rev) which resulted in 15.4 IPM (391,16 mm/min). GEN3SYS[®] delivered a cycle time of 1.9 seconds and a tool life of over 9000 holes.

+ PROJECT DATA:

Allied and GEN3SYS[®] made a difference for the customer by nearly tripling the tool life over that of the Seco tool while delivering a 50% increase in the penetration rate. As a result, the cost per hole dropped from \$0.075 to \$0.043, for a considerable cost savings of 43.5%.



*EXTENDED
TOOL LIFE*