CASE STUDY. GEN3SYS®

PROJECT PROFILE: **316 Stainless Steel Process Control Instruments**

The end-user is manufacturing industrial level switches made from 316 stainless steel. They were using a 15 horsepower Okuma Mac Turn 350-W with semi synthetic coolant.

TOOL PERFORMANCE CONSISTENCY

+ CHALLENGE:

Previously the customer was using a KSEM drill running at the following parameters: 800 RPM, .003 IPR (0,076 mm/rev), which resulted in 2.4 IPM (60,96 mm/min). The tool drilled a 1.25" (31,75 mm) diameter blind hole to a 3.375" (85,73 mm) depth. The cycle time per hole was 1 minute and 24 seconds. Problem: The KSEM tools produced an erratic number of holes that averaged 45 holes before having to be replaced. Due to the customer's production schedule, this inconsistency had to be resolved, and fast. The customer

+ OUR SOLUTION:

Allied recommended the GEN3SYS® High Penetration Drilling System using insert item 5C129H-0108 and holder 605295-125F. The tooling ran at identical parameters: 800 RPM, .003 IPR (0,076 mm/rev), which resulted in 2.4 IPM (60,96 mm/min). Even though the GEN3SYS® tool was operating at identical parameters as the KSEM tool, including the cycle time, key variables weighed heavily in favor of the Allied tool. GEN3SYS® ran consistently, producing 350 holes every time at a lower cost. Customers love consistency. GEN3SYS® provided plenty of that, and at an upfront cost that made the Allied tool the best tool choice and the best value for this application.

+ PROJECT DATA:

GEN3SYS® met the customer's goals of delivering a better cost per hole and of course, hole-making consistency. The cost per hole was reduced from $5.32 to $2.22, for an enormous cost savings of over 59%.