



CASE STUDY.

PROJECT PROFILE:

GEN3SYS[®] 4340 Job Shop Oilfield

The end-user is machining spinner jaws for oil rigs using a Haas VF5 milling center, with synthetic coolant operating at 1000 PSI.

+ CHALLENGE:

Previously the customer was using an Kennametal KSEM, running at the following parameters: 1500 RPM, 0.009 IPR, (0,229 mm/rev) which resulted in 13.5 IPM (330,2 mm/min). The tool drilled a 0.688" (17,48 mm) diameter thru hole to a depth of 2.5 inches (63,5 mm). The tool had a cycle time of 11 seconds and a tool life of 180 holes.

Looking to reduce their tooling costs, the customer asked if Allied had a real solution their expenditure concerns.

+ OUR SOLUTION:

Allied recommended the GEN3SYS[®] High Penetration Drilling System using insert item 5C117H-0022 with holder 60517S-075F. The tooling ran at an identical speed of 1500 RPM, along with exactly the same IPR and IPM.

GEN3SYS[®] had an equal cycle time of 11 seconds, but the tool life came out ahead at 220 holes, versus the KSEM tool life of 180, for an 18.2% increase in holes produced.

+ PROJECT DATA:

GEN3SYS[®] delivered a cost per hole of \$.307, a significant decrease from the KSEM cost per hole of \$.503, for a reduction in tooling costs of 39%, providing the satisfied customer what they were looking for.



*REDUCED
CYCLE TIMES*