



CASE STUDY.

PROJECT PROFILE:

AccuPort 432[®]

Nitronic 50

A medium sized contract machine shop is manufacturing small exotic parts made out of Nitronic 50. They are using a Fadal VMC with through-tool coolant to manufacture their products.

+ CHALLENGE:

Originally, the customer was using 4 tools in order to complete their production process including a center drill, a carbide drill, a Metcut Form Port tool, and an end mill for spot face counter bore. With a cycle time of 2 minutes 24 seconds per hole and with 4 holes per part, the total cycle time was 9 minutes 40 seconds per part. Turning to AMEC for improvements, the customer wanted to reduce cycle time and decrease the amount of tools used.

+ OUR SOLUTION:

AMEC suggested they use an Accuport432[®] item #J1926-04-063F fitted with insert #15YA-.386 and an AccuPort432[®] form insert item #J1926-02-05A. Using this operation, the entire process required only 1 tool instead of the previous 4 tools. The results were excellent. With a new cycle time of 30 seconds per hole and therefore only 2 minutes per part, the customer reduced their cycle time by over 7 minutes 30 seconds per part. For every 1000 holes that were processed, the customer received a total cost savings of \$6,431.69 or 79%.

+ PROJECT DATA:

Receiving a substantial cost savings by switching to the AMEC tools, the customer was exceptionally pleased with the performance of the AccuPort432[®] tooling. The customer also dramatically reduced their cycle time while eliminating 3 tools from the process.



*REDUCED
CYCLE TIME*