



## CASE STUDY.

### PROJECT PROFILE:

A steel fabrication shop is drilling I-beams made out of structural steel for the construction industry using a Peddinghaus BDL-1250 with 9 spindles and through-tool coolant. They are drilling 20.64mm diameter holes in 12.7mm deep in structural steel.

### + CHALLENGE:

Previously, the customer was running their drills at a speed of 29.52M/min, 0.216mm/rev, and 82.55mm/min. The tooling had a cycle time of 9.29 seconds and a life of roughly 600-800 holes. The customer was paying \$138.00 per drill and regrinding 5-6 times. Wanting to improve their production process, the customer needed to reduce cycle time, reduce costs, and alleviate problems with regrinding tooling in-house.

### + OUR SOLUTION:

AMEC suggested their structural steel products. They recommended using holder item #24010H-004ISO52 and insert item #151A-0026-NP running at a speed of 38.1M/min, .2286mm/rev, and 138.43mm/min. The results were excellent. The AMEC tooling eliminated the need for regrind and the cycle time decreased to 5.56 seconds. Additionally, the customer received a total cost savings of \$149.64 or 37% for every 1100 holes they processed.

### + PROJECT DATA:

Satisfied with the results of the test, the customer received a 37% savings. The customer has now converted all sizes of drilling to AMEC tooling.

## Specials Structural Steel



*REDUCED  
CYCLE TIME*