

ASC 320®

Case Study: 3004
Industry: Military/Defense
Part: Humvee Bracket
Material: High Strength Alloy Steel
Diameter: 0.4490"
Depth: 0.75"
Item: 335M11400A21M



The Challenge

The customer manufactures components for military Humvee vehicles. The part is a bracket made from high strength alloy steel using a Mazak Nexus 510C VMC running with water soluble coolant.

Unsatisfied with this production process, the customer needs to decrease the overall costs of the application.

The Advantages

The increased productivity of the ASC 320 provided the cost savings the customer desired.

- Decreased cycle time by 34%
- Total cost savings = \$166.40 (32%) per 2,500 holes

Previous Tooling

OSG Solid Carbide Drill

- 766 RPM
- 90 SFM
- 0.007 IPR
- 5.36 IPM
- Cycle time = 8.5 seconds
- Tool life = 2,500 holes

Allied Machine Solution

ASC 320®

- 995 RPM
- 117 SFM
- 0.008 IPR
- 7.96 IPM
- Cycle time = 5.6 seconds
- Tool life = 2,500 holes

