

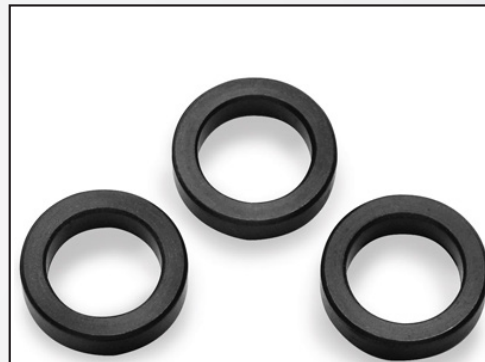


## Torque Converter Spacers: Revolution Drill®

The customer makes spacers for torque converters made from 1045 using a CNC lathe IKEGAI-Fx 25N with external coolant.

Because the Kennametal tool was expensive and had lengthy lead times, the customer asked Allied for a solution that would also improve cycle times and lower the cost per hole.

The **Revolution Drill®** met the customer's needs and provided twice as many drilled holes in half the time.



		Measure	Competitor Tooling	Revolution Drill®
<b>Product:</b>	Revolution Drill®	RPM	500	900
<b>Objectives:</b>	(1) Decrease cycle time (2) Decrease cost	Feed Rate	0.003 IPR (0.076 mm/rev)	0.0035 IPR (0.089 mm/rev)
<b>Industry:</b>	Automotive	Penetration Rate	1.5 IPM (38.1 mm/min)	3.15 IPM (80.01 mm/min)
<b>Part:</b>	Torque converter spacers	Cycle Time	2 min	1 min
<b>Material:</b>	1045	Tool Life	300 holes	600 holes
<b>Hole Ø:</b>	1.9" (48.26 mm)	The Revolution Drill offered <b>54.21%</b> cost per hole savings over the competitor tooling.		
<b>Hole Depth:</b>	3" (76.2 mm)			



► Revolution Drill  
Holder: **R34X22-150L**  
Inserts: **OP-05T308-H**

54% cost savings

**The Revolution Drill® provided:**

- ✓ Decreased cost per hole
- ✓ Decreased cycle time
- ✓ Increased tool life

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