ALLIED MACHINE & ENGINEERING

Holemaking Solutions for Today's Manufacturing

Case Study **Solutions**

ASC 320®

Case Study: 3011

Industry: Oil & Gas/Petrochemical

Part: Locking Collar Component

Material: Alloy Steel

Diameter: 0.421"

Depth: 1.20"

Item: 335E04219A21M

The Challenge

A customer manufactures and maintains components for offshore oil rigs. They use a Johnsford VMC with 1000 PSI coolant through the tool. The part they are machining is a component for a locking collar for an offshore pipe wrench made out of alloy steel.

Seeking to improve their production process, the customer wanted to decrease machine cycle time.

The Advantages

The ASC 320 not only reduced cycle time, but it also decreased the cost of production while increasing shop capacity.

- Decreased cycle time by 60%
- Increased tool life by 330%
- Eliminated spot drill operation
- Total cost savings = $564.45 or 63.76%

Previous Tooling

27/64 Cobalt Drill

- 110 SFM
- 0.004 IPR
- Cycle time = 23.53 seconds
- Tool life = 468 inches

Allied Machine Solution

ASC 320®

- 300 SFM
- 0.011 IPR
- Cycle time = 9.4 seconds
- Tool life = 2016 inches