



Humvee Bracket: ASC 320®

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



| | | Measure | Competitor Drill | ASC 320® |
|--------------------|---------------------------|------------------|---------------------------|---------------------------|
| Product: | ASC 320® | RPM | 766 | 995 |
| Objective: | Decrease production costs | Speed | 90 SFM (27.432 M/min) | 117 SFM (35.662 M/min) |
| Industry: | Military/ defense | Feed Rate | 0.007 IPR (0.178 mm/rev) | 0.008 IPR (0.203 mm/rev) |
| Part: | Humvee bracket | Penetration Rate | 5.36 IPM (136.144 mm/min) | 7.96 IPM (202.184 mm/min) |
| Material: | High strength alloy steel | Cycle Time | 8.5 sec | 5.6 sec |
| Hole Ø: | 0.4490" (11.405 mm) | Tool Life | 2,500 holes | 2,500 parts |
| Hole Depth: | 0.75" (19.05 mm) | | | |

▶ ASC 320®
335M11400A21M



The ASC 320® provided:

- ✓ Maintained tool life
- ✓ Decreased cycle time
- ✓ Decreased costs

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