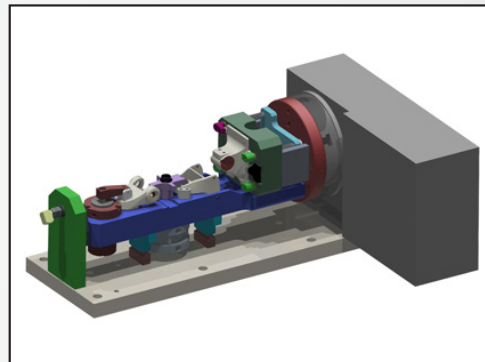


Hydraulic/ Pneumatic Clamping: EcoCut

A customer manufactures precision hydraulic and pneumatic clampings made from stainless steel. They use a Cincom swiss style lathe to manufacture their products. The customer uses a four-step process to complete the job.

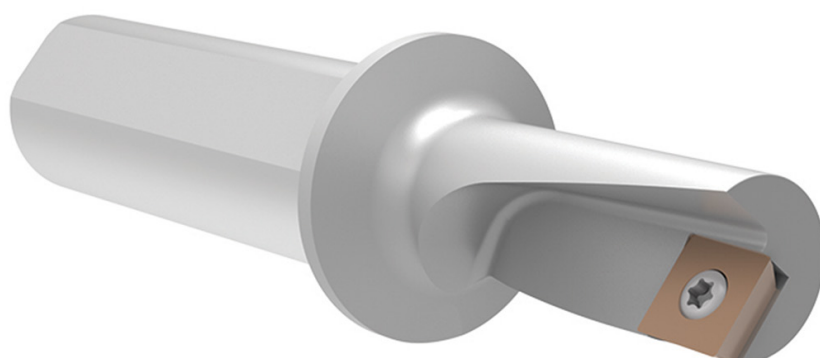
The customer asked Allied Machine for a solution to reduce the cycle time.

The **EcoCut** accomplished the process with a single tool, which decreased the customer's cycle time.



Product: EcoCut	Objective: Decrease cycle time	Industry: Hydraulics	Part: Precision hydraulic and pneumatic clamping	Material: Stainless steel	Hole Ø 0.3925" (9.970 mm) 0.4725" (12.002 mm)	Hole Depth 0.750" (19.050 mm)	Previous Tooling	EcoCut
							4 Tool Process <ul style="list-style-type: none"> • Cleveland twist drill • Rough boring tool • Finish boring tool • Chamfer Overall process: <ul style="list-style-type: none"> • Cycle time: 42 sec 	Pass 1 <ul style="list-style-type: none"> • 600 SFM (182.880 M/min) • 0.007 IPR (0.178 mm/rev) • 6120 RPM Pass 2 and 3 <ul style="list-style-type: none"> • 500 SFM (152.400 M/min) • 0.0028 IPR (0.071 mm/rev) • 4064 RPM Overall <ul style="list-style-type: none"> • 500 parts (per cutting edge)

► EcoCut
Item No. EC 08L-3.0D04 H-E



The EcoCut provided:

- ✓ Eliminated tools
- ✓ Decreased cycle time

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