



Large Molds: BT-A

The customer manufactures large automotive molds made from P20 (28-32 Rc) using a Schienke tri-spindle deep hole drilling machine with canola base soluble oil coolant at 280 PSI (19 bar).

The operation was not cost effective due to inconsistent tool life and very low penetration rates. The customer needed an improved solution.

The shop supervisor was so impressed, he stated, "At this point their performance (BT-A) outweighs the cost. Just get them here if you can." The **BT-A** made a huge difference for this customer.



		Measure	Competitor	BT-A
Product:	BT-A			
Objective:	Improve process	RPM	600	575
Industry:	Automotive			
Part:	Large automotive molds	Feed Rate	0.0012 IPR (0.0305 mm/rev)	0.009 IPR (0.2286 mm/rev)
Material:	P20			
Hole Ø:	1.156" (29.362 mm)	Penetration Rate	0.7 IPM (17.78 mm/min)	5.2 IPM (132.08 mm/min)
Hole Depth:	102" (2590.8 mm)	Cycle time	20 hours	7 hours



- ▶ BT-A Drill Head
BT-A2-805-1.1560
- ▶ T-A® GEN2 Insert
Item No. 4C12H-0105-HE

65% cycle time decrease

The BT-A provided:

- ✓ Decreased cycle time
- ✓ Decreased costs