



Sub-Sea Petroleum Manifolds: Opening Drill®

The customer manufactures sub-sea petroleum manifolds using a Giddings & Lewis boring mill with 250 PSI (17.237 bar) water soluble coolant.

Since this operation consumed half the day, the customer asked Allied for a better solution.

The **Opening Drill®** drastically reduced the costly machine run time, which ultimately resulted in a decreased cost per hole.



		Measure	Competitor	Opening Drill®
Product:	Opening Drill®	RPM	125	150
Objective:	Decrease cycle time	Feed Rate	0.003 IPR (0.076 mm/rev)	0.004 IPR (0.102 mm/rev)
Industry:	Oil & gas/petrochemical	Penetration Rate	0.375 IPM (9.525 mm/min)	0.6 IPM (15.240 mm/min)
Part:	Sub-sea petroleum manifolds	Cycle Time	4 hours (20 passes)	15 min
Material:	625 Inconel	The Opening Drill offered 93.75% cost per hole savings over the competitor tooling.		
Hole Ø:	3.8" (96.52 mm)			
Hole Depth:	9.0" (228.6 mm)			



▶ Opening Drill®
Holder: **OP3-IL-CV50**
Inserts: **OP05T308-1H**

93% cost savings

The Opening Drill® provided:

- ✓ Decreased cycle time
- ✓ Decreased cost per hole

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