



Turbine Components: Opening Drill®

The customer manufactures turbine components made from chrome molly alloy steel using a Super 8 VMC with water soluble coolant.

The boring bar machining process moved too slow. The customer needed to reduce cycle time because the parts were scheduled for quick delivery.

Not only did the **Opening Drill®** decrease the cycle time to meet the delivery schedule, it also greatly reduced the cost per hole.



		Measure	Competitor Boring Bars	Opening Drill®
Product:	Opening Drill®	RPM	500	500
Objective:	Decrease cycle time	Feed Rate	0.005 IPR	0.005 IPR
Industry:	Renewable energy/energy	Penetration Rate	2.5 IPM	2.5 IPM
Part:	Turbine components	Cycle Time	2 hr 59 min	1 hr 29.6 min
Material:	Chrome molly alloy steel	Cost Per Hole	\$30.89	\$18.25
Hole Ø:	3.5"			
Hole Depth:	8.0"			



► Opening Drill®
Holder: **OP3-1L-BT50**
Inserts: **OP-05T308-H**

40% cost per hole decrease

The Opening Drill® provided:

- ✓ Decreased cycle time
- ✓ Decreased cost per hole

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