

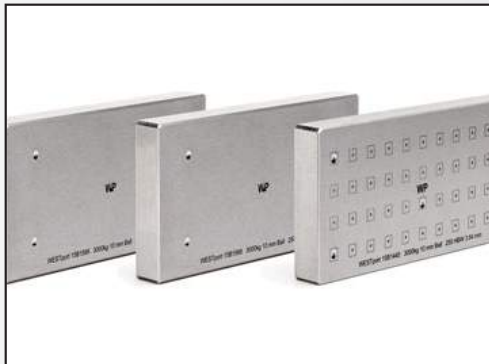


Test Block: BT-A

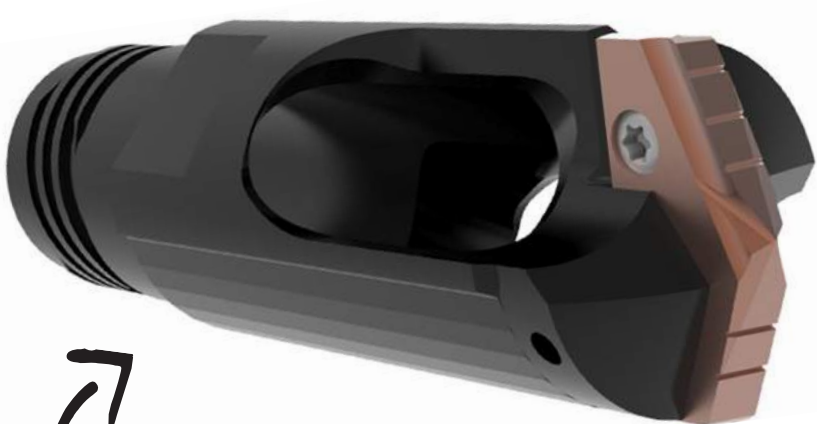
The customer is a mold maker for the plastics industry that contacted Allied to test BTA tooling. The workpiece is a 21" (533.4 mm) thick test block made of P20 material (28-32 Rc). They are using a Schienke Gundrill machine with Hulcut 745D semi-synthetic coolant (10% concentrate) at 1000 PSI (69 bar).

The customer needed to decrease total hole costs and improve the tool life.

The **BT-A Drill** successfully decreased total hole costs while improving the tool life.



		Measure	Competitor	BT-A
Product:	BT-A	RPM	1300	1575
Objectives:	Increase tool life	Feed Rate	0.0054 IPR (0.137 mm/rev)	0.0046 IPR (0.117 mm/rev)
Industry:	Tool, mold, & die	Penetration Rate	7.02 IPM (178.308 mm/min)	7.23 IPM (183.642 mm/min)
Part:	Test block	Cycle Time	3 min 10 sec	3 min 4 sec
Material:	P20	Tool Life	19 holes	39 holes
Hole Ø:	0.734" (18.644 mm)	BT-A offered 15% cost per hole savings compared to competitor tooling.		
Hole Depth:	21" (533.4 mm)			



- ▶ Special Holder
Item No. 081021-21
- ▶ Special Insert
Item No. 081021-22

105% tool life increase

The BT-A provided:

- ✓ Increased tool life
- ✓ Decreased cycle time
- ✓ Decreased cost per hole

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