

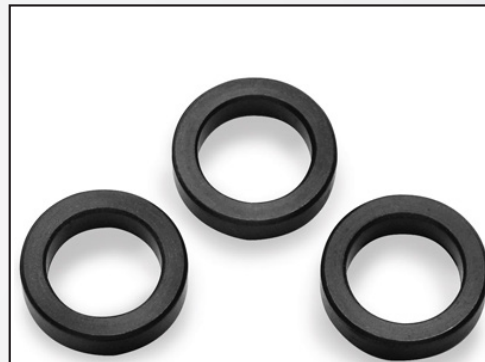


## Torque Converter Spacers: Revolution Drill®

The customer makes spacers for torque converters made from 1045 using a CNC lathe IKEGAI-Fx 25N with external coolant.

Because the Kennametal tool was expensive and had lengthy lead times, the customer asked Allied for a solution that would also improve cycle times and lower the cost per hole.

The **Revolution Drill®** met the customer's needs and provided twice as many drilled holes in half the time.



<b>Product:</b> Revolution Drill® <b>Objectives:</b> (1) Decrease cycle time (2) Decrease cost <b>Industry:</b> Automotive <b>Part:</b> Torque converter spacers <b>Material:</b> 1045 <b>Hole Ø:</b> 1.9" <b>Hole Depth:</b> 3"	Measure	Competitor Tooling	Revolution Drill®
	RPM	500	900
	Feed Rate	0.003 IPR	0.0035 IPR
	Penetration Rate	1.5 IPM	3.15 IPM
	Cycle Time	2 min	1 min
	Tool Life	300 holes	600 holes
	Cost per hole	\$2.14	\$0.98



► Revolution Drill  
Holder: **R34X22-150L**  
Inserts: **OP-05T308-H**

54% cost savings

### The Revolution Drill® provided:

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

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