



## Axle Weldment: Opening Drill®

The customer is manufacturing automotive components for a specialty truck manufacturer. They are using a Giddings & Lewis 35 HP Boring Mill with minimal coolant pressure to machine an axle weldment made from 1018 low carbon steel.

Unsatisfied with this process, the customer needed to reduce the number of tools used to complete the operation and also lower their tooling costs.

The **Opening Drill®** easily achieved the customer's goals.



		Measure	Competitor	Opening Drill®
<b>Product:</b>	Opening Drill®	RPM	The customer previously used 3 different twin cutters with different diameters to open the hole to 2.48" (62.992 mm)	462
<b>Objective:</b>	Reduce steps in process	Speed		300 SFM (91.44 M/min)
<b>Industry:</b>	Automotive	Feed Rate		0.006 IPR (0.152 mm/rev)
<b>Part:</b>	Axle weldment	Penetration Rate		2.77 IPM (70.358 mm/min)
<b>Material:</b>	1018 low carbon steel	Cycle Time		3 min 25 sec
<b>Hole Ø:</b>	2.48" (62.992 mm)			
<b>Hole Depth:</b>	6.00" (152.4 mm)			



▶ Opening Drill®  
Holder: **OP1-1L-SS1.5**  
Inserts: **O-05T308-H**

### The Opening Drill® provided:

- ✓ Decreased cycle time
- ✓ Reduced required tooling
- ✓ Decreased costs

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