



CASE STUDY.

PROJECT PROFILE: **41L40 Aerospace Contract Shop**

GEN3SYS[®]

The end-user is machining a 41L40 sleeve bearing on a Daewoo Lynx 200L lathe with 100 PSI through-tool coolant.

+ CHALLENGE:

Previously the customer was using a Guhring RT 800 WP high penetration drill running at the following parameters: 550 RPM, 0.005 IPR (0.13 mm/min), resulting in 2.75 IPM (69.85 mm). They were drilling a 1.201" (30.50 mm) diameter hole to a depth of 3.82" (97.03 mm). Total drilling time to complete 100 holes was 139 minutes, with a tool life of 382 total inches.

Before committing to repurchasing the competitive carbide drill inserts, the customer asked what Allied could bring to the table.

+ OUR SOLUTION:

Allied recommended the GEN3SYS[®] High Penetration Drilling System, using insert item 5C129H-30.5 and holder 60329S-125F. GEN3SYS[®] was run at the following parameters: 715 RPM, 0.012 IPR (0.30 mm/rev) resulting in 8.58 IPM (217.9 mm/min). GEN3SYS[®] delivered a performance that exceeded the expectations of the customer by drilling 632 total inches in just 74 minutes.

+ PROJECT DATA:

GEN3SYS[®] exceeded the customer's expectations by proving to be the clear choice over the competitive tool. Allied's solution allowed for a 70% reduction in cycle time while obtaining 66% additional tool life. The Cost Per Hole fell from \$2.98 to \$1.08, which resulted in a cost savings of 63.7%!



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