



CASE STUDY.

PROJECT PROFILE:

GEN3SYS®

Medium Carbon Steel Automotive 4

The end-user is manufacturing Tubesheets. The customer is machining these parts made out of mild steel forging using an Eagle drill table-gantry, with semi-synthetic coolant.

+ CHALLENGE:

Previously the customer was using a High Impact AM200® Super Cobalt Spade drill running at the following parameters: 611 RPM, 161 SFM, .009 IPR, and 5.5 IPM. The tool drilled a 1.008" diameter hole to a 4.125" depth. The tool had a cycle time of 45 seconds and a life of 194 holes. Looking for improvements, the customer wanted to reduce his cycle time.

+ OUR SOLUTION:

AMEC recommended GEN3SYS® using insert item #5C124H-1.008 and holder #60524S-100F. The tooling ran at a speed of 1086 RPM, 286 SFM, .0143 IPR, and 15.5 IPM. The results were excellent and met the customer's goals of reducing cycle time. The GEN3SYS® High Penetration drill increased tool life to 436 holes and delivered a cycle time of just 16 seconds. The customer succeeded in reducing their cycle times and costs. What was \$1.22 per hole fell to \$.81, a savings of \$.41 per hole.

+ PROJECT DATA:

GEN3SYS® High Penetration Drilling System improved the customer's production by reducing cycle time and generating a cost savings of over 34%.



REDUCED CYCLE TIMES