CASE STUDY.

ASC 320®

PROJECT PROFILE: Free Machining Steel

A commercial lawn mower manufacturer is producing 3 major brands of lawn mowers for both homeowner and commercial use. They are using a Haas Lathe running with Blaser 2000x coolant. The part being machined is a deck bushing made out of free machining steel. The customer's annual production includes machining 160,000 parts per year for the homeowner mower line and over 100,000 parts per year for the commercial mower line.

INCREASED PRODUCTIVITY

+ CHALLENGE:

Previously the customer was using a 0.3906" diameter x 2.0" deep Mitsubishi VT 15PF drill running at a speed of 3002 RPM and 0.007 IPR. The machine's cycle time was 5.71 seconds and the tool had a life of 3500 pieces prior to regrind. Looking for improvements, the customer wanted to increase productivity and decrease the cost of production.

+ OUR SOLUTION:

AMEC suggested using an ASC 320® 0.3906" diameter x 2.0" deep drill, item #335E03906A21M. It was advised that the tool be run at a speed of 3912 RPM and 0.010 IPR. The tool had a cycle time of 3.07 seconds and a tool life of 3500 pieces prior to regrind. The results were excellent. By decreasing cycle time the customer was able to increase productivity. Additionally, the customer lowered their cost of production and saved a total of $169.99 or 27.56%.

+ PROJECT DATA:

Due to the successful performance of the AMEC tooling, the customer reduced cycle time and therefore increased productivity. The customer also lowered their cost of production.