



CASE STUDY.

AccuThread 856[®] Structural Steel Job Shop

PROJECT PROFILE:

AN END-USER IS PRODUCING JOB SHOP BLUE PRINT WORK FOR THE AUTOMOTIVE, AGRICULTURE, AND PLASTIC INDUSTRIES. THEY ARE USING A MAZAK AJV 6080 VMC RUNNING WITH WATER SOLUBLE COOLANT TO MACHINE AN END CAP MADE OUT OF STRUCTURAL STEEL. THE END CAP REQUIRED 4 TAPPED HOLES PER PART.

+ CHALLENGE:

PREVIOUSLY THE CUSTOMER WAS USING AN DSG 1 X 11.5 NPT TAPER RUNNING AT THE FOLLOWING PARAMETERS: 10 RPM, 0.01 IPR, 0 SFM, AND 0.10 IPM. THE THREADED DIAMETER WAS 1.250" AND THE LENGTH OF THE HOLE WAS 3.925". THE TOOL HAD A CYCLE TIME OF 39 MINUTES 15 SECONDS AND A LIFE OF 1 HOLE. THE POOR TOOL LIFE WAS A RESULT OF THE THREAD TEARING USING A PIPE TAP. UNSATISFIED WITH THEIR CURRENT PROCESS, THE CUSTOMER WANTED TO REDUCE THEIR COST OF PRODUCTION AND INCREASE TOOL LIFE.

+ OUR SOLUTION:

AMEC SUGGESTED USING THE ACCUThread 856[®] THREADMILL ITEM #TMNK1000-NPT RUNNING AT: 2156 RPM, 0.002 IPR, 350 SFM, AND 2.17 IPM. THE TOOL WAS RUN USING A 2-PASS PROGRAM. THE RESULTS WERE OUTSTANDING. NOT ONLY DID THE ACCUThread 856[™] TOOL INCREASE TOOL LIFE TO 192 HOLES, IT ALSO REDUCED CYCLE TIME TO ONLY 3 MINUTES 36 SECONDS. ADDITIONALLY, THE CUSTOMER SIGNIFICANTLY LOWERED THEIR COST OF PRODUCTION. WITH THE AMEC COST PER HOLE BEING ONLY \$5.880 COMPARED TO THE COMPETITIVE COST PER HOLE OF \$173.958, THE CUSTOMER RECEIVED A TOTAL COST SAVINGS OF \$32,271.00 OR 96.6%.

+ PROJECT DATA:

NOT ONLY DID AMEC ENABLE THE CUSTOMER TO REDUCE CYCLE TIME AND INCREASE TOOL LIFE, BUT THE END-USER ALSO DECREASED THEIR COST OF PRODUCTION BY A STUNNING 96.6%.



*REDUCED
CYCLE TIME*

