Aircraft Spacers: EcoCut

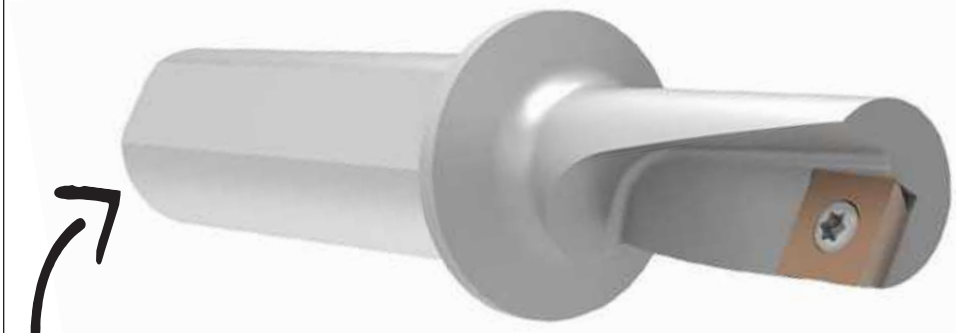
The customer machines aircraft spacers made from 6061 Aluminum using a Haas SL20 lathe with through tool coolant.

Because this was a large volume job, the customer needed a solution to reduce the cycle time.

The **EcoCut** made a significant difference for the customer and successfully reduced cycle time.

Product:	EcoCut	**Part:**	Aircraft spacers
Objectives:	Decrease cycle time	**Material:**	6061 Aluminum
Industry:	Aerospace	**Hole Ø:**	0.5" *(12.7 mm)*

Measure	Competitor			Allied EcoCut Solution		
	Solid Carbide	End Mill	Seco Tool	Drilling	Boring	Turning
RPM	1900	1700	3600	4856	4356	3667
Feed Rate	0.010 IPR *(0.254 mm/rev)*	0.0025 IPR *(0.064 mm/rev)*	0.004 IPR *(0.102 mm/rev)*	0.003 IPR *(0.076 mm/rev)*	0.003 IPR *(0.076 mm/rev)*	0.003 IPR *(0.076 mm/rev)*
Penetration Rate	19 IPM *(482.6 mm/min)*	4.25 IPM *(107.95 mm/min)*	14.4 IPM *(365.76 mm/min)*	14.57 IPM *(370.078 mm/min)*	13.10 IPM *(332.74 mm/min)*	11 IPM *(279.4 mm/min)*
Cycle Time	30.34 sec			20.97 sec		



30% cycle time decrease

▸ EcoCut
Item No. 2.25xD

The EcoCut provided:

- ✓ Decreased cycle time
- ✓ Decreased cost per hole