



Sub-Sea Petroleum Manifolds: Opening Drill®

The customer manufactures sub-sea petroleum manifolds using a Giddings & Lewis boring mill with 250 PSI water soluble coolant.

Since this operation consumed half the day, the customer asked Allied for a better solution.

The **Opening Drill®** drastically reduced the costly machine run time, which ultimately resulted in a decreased cost per hole.



Product: Opening Drill® Objective: Decrease cycle time Industry: Oil & gas/petrochemical Part: Sub-sea petroleum manifolds Material: 625 Inconel Hole Ø: 3.8" Hole Depth: 9.0"	Measure	Competitor	Opening Drill®
	RPM	125	150
	Feed Rate	0.003 IPR	0.004 IPR
	Penetration Rate	0.375 IPM	0.6 IPM
	Cycle Time	4 hours (20 passes)	15 min
	Cost Per Hole	\$600.00	\$37.50



► Opening Drill®
Holder: **OP3-IL-CV50**
Inserts: **OP05T308-1H**

93% cost savings

The Opening Drill® provided:



Decreased cycle time



Decreased cost per hole