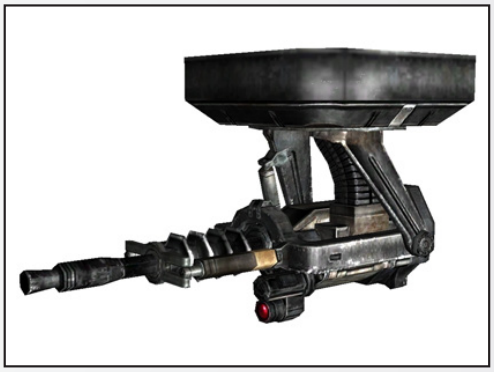
Turrets: Revolution Drill®

The customer manufactures turrets made from A36 structural steel using a Giddings & Lewis horizontal machining center MC60 with high pressure flood coolant.

To improve production, the customer needed to reduce the cost of this drilling operation.

The **Revolution Drill®** accomplished the cusomer's needs by reducing cycle time and increasing tool life.



Product: Revolution Drill®
Objective: Decrease cost per part
Industry: Heavy equipment
Part: Turrets
Material: A36 structural steel
Hole Ø: 2.1″
Hole Depth: 2.5″

Measure	Competitor Tooling	Revolution Drill®
RPM	100	825
Feed Rate	0.010 IPR	0.003 IPR
Penetration Rate	1.0 IPM	2.475 IPM
Cycle Time	5 min	1 min
Tool Life	15 holes	22 holes
Cost per part	$10.71	$4.54

- Revolution Drill Holder: ***R36X22-150L***
  Inserts: ***OP-05T308-H***

80% cycle time decrease

The Revolution Drill® provided:

- ✓ Decreased cost per part
- ✓ Decreased cycle time
- ✓ Increased tool life