

Spot Welding Electrodes: EcoCut

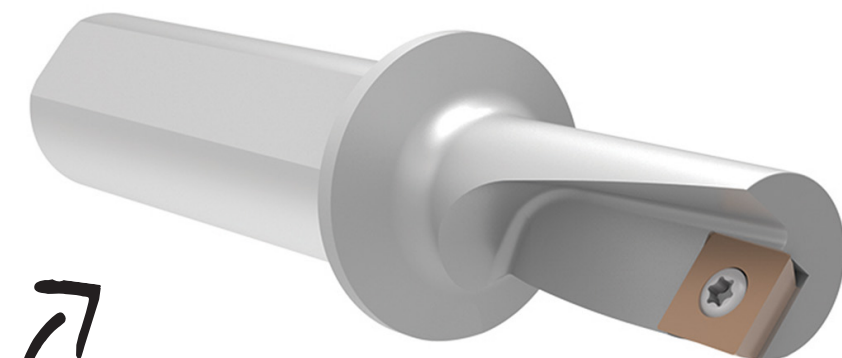
The customer manufactures automotive spot welding electrodes made from copper. They use a Daewoo Puma MS running with a ChipBlaster coolant pump to produce their products.

Looking for improvements, the customer needed to reduce cycle time, increase tool life, and lower the cost of production.

The **EcoCut** tooling reduced cycle time and increased tool life for the customer.



		Measure	Previous Tooling		EcoCut	
Product:	EcoCut		Solid carbide drill <ul style="list-style-type: none">• Hole Ø: 0.3750"• Depth: 0.710"• Cycle time: 3 sec• Tool life: 7500 parts Carbide bar <ul style="list-style-type: none">• Hole Ø: 0.4375"• Depth: 0.710"• Cycle time: 19 sec• Tool life: 9500 parts	turning/facing tool <ul style="list-style-type: none">• First Pass<ul style="list-style-type: none">• Hole Ø: 1.50"• Depth: 0.650"• Second pass<ul style="list-style-type: none">• Hole Ø: 0.625"• Depth: 0.025"• Cycle time: 1.2 sec• Tool life: 11,500 parts	First pass <ul style="list-style-type: none">• Hole Ø: 0.3150"• Depth: 0.710"• Cycle time: 4.5 sec Boring pass <ul style="list-style-type: none">• Hole Ø: 0.4375"• Depth: 0.710"• Cycle time: 6 sec	Turning operation <ul style="list-style-type: none">• Hole Ø: 1.50"• Depth: 0.650"• Cycle time: 7.8 sec First pass <ul style="list-style-type: none">• Hole Ø: 0.6250"• Depth: 0.025"• Cycle time: 0.2 sec
Objective:	Decrease cycle time	Tool Life	11,500 parts		50,000 parts	
Industry:	Automotive	Cycle	47.2 sec		18.5 sec	
Part:	Spot welding electrodes					
Material:	Copper					
Hole Ø:	0.025"					
Hole Depth:	0.625"					



► EcoCut
Insert: XCET 040102FR-27P H216T
Holder: EC 08R-2.25D 04-E



60% cycle time decrease

The EcoCut provided:

- ✓ Decreased cycle time
- ✓ Increased tool life