

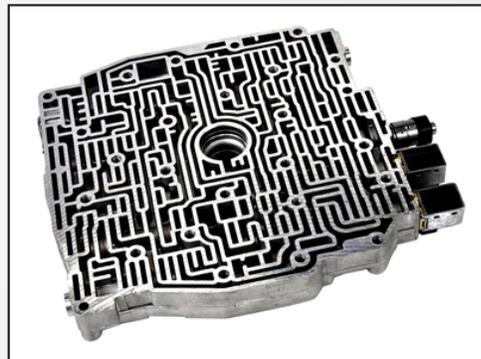


## Valve Body: Opening Drill®

The customer manufactures valves for the oil well industry. The customer is machining a valve body made from 4340 alloy steel using a Toshiba Shibaura 15 HP boring mill running with flood coolant.

Unsatisfied with this production process, the customer needed to reduce the cycle time.

The **Opening Drill®** successfully reduced cycle time and also lowered the cost of production.



Product: Opening Drill®	Objective: Decrease cycle time	Industry: Oil & gas/petrochemical	Part: Valve body	Material: 4340 alloy steel	Hole Ø: 7.9"	Hole Depth: 21"	Measure	Competitor Boring Bars	Opening Drill®
							RPM	125	125
Speed	259 SFM	259 SFM							
Feed Rate	0.006 IPR	0.0037 IPR							
Penetration Rate	0.75 IPM	0.46 IPM							
Cycle Time	7 hr 20 min	46 min							



▶ Opening Drill®  
Holder: **070821-12**  
Inserts: **OP-05T308-H**

89% cycle time decrease

The Opening Drill® provided:

- ✓ Decreased cycle time
- ✓ Decreased cost of production

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