



## Landing Gear: BT-A

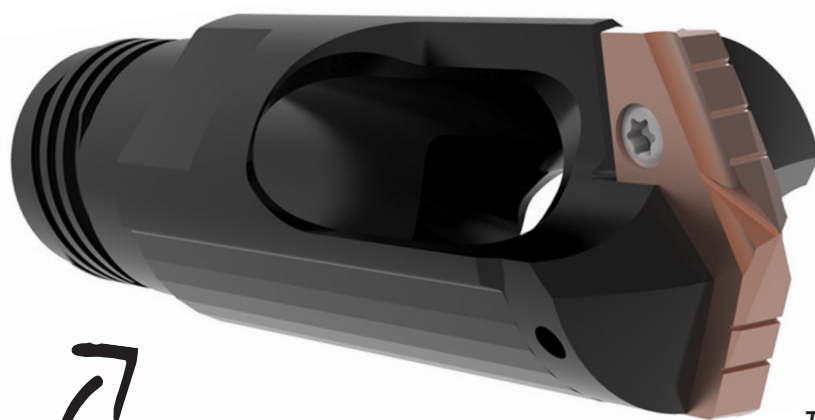
The customer is machining aerospace landing gear made from 4340 alloy steel using a LeBlond Heavy Duty Lathe with 60 GPM (227 LPM) of oil.

The customer needed to improve the process and reduce cost. They asked Allied for a durable solution at a lower price.

The **BT-A Drill** completed 43 pieces against Sandvik's disappointing 2 pieces. The BT-A Drill cost was justified after only 15 parts.



<b>Product:</b> BT-A <b>Objectives:</b> Improve process <b>Industry:</b> Aerospace <b>Part:</b> Landing gear <b>Material:</b> 4340 Alloy steel <b>Hole Ø:</b> 2.05" (52.07 mm) <b>Hole Depth:</b> 11.0" (279.4 mm)	Measure	Competitor Reamer	ALVAN® Reamer
	RPM	500	125
	Feed Rate	0.003 IPR (0.0762 mm/rev)	0.006 IPR (0.152 mm/rev)
	Penetration Rate	1.5 IPM (38.1 mm/min)	0.75 IPM (19.05 mm/min)
	Cycle Time	15 min	1 min 20 sec
	Tool Life	2 holes	43 holes
	BT-A offered <b>99%</b> cost per hole savings compared to competitor tooling.		



- ▶ BT-A Drill Head
- ▶ T-A® Insert  
#4 Series Special Super Cobalt

99% cost per hole savings

### The BT-A provided:

- ✓ Increased tool life
- ✓ Decreased cycle time
- ✓ Decreased cost per hole
- ✓ Eliminated set-up and deburr time

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