BT-A Drill

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.

Product: BT-A
Objectives: Improve process
Industry: Aerospace
Part: Landing gear
Material: 4340 Alloy steel
Hole Ø: 2.05" *(52.07 mm)*
Hole Depth: 11.0" *(279.4 mm)*

Measure	Competitor	BT-A
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 99% cost per hole savings compared to competitor tooling.		

99% cost per hole savings

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

The BT-A provided:

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