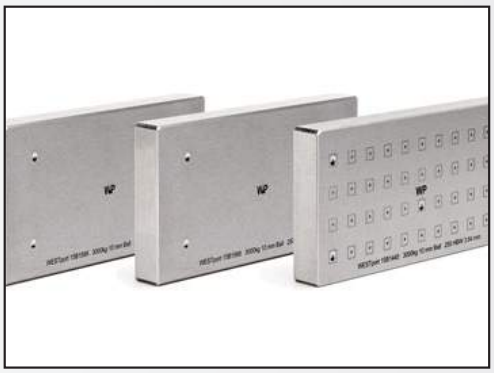
BT-A Drill

Test Block: BT-A

The customer is a mold maker for the plastics industry that contacted Allied to test BTA tooling. The workpiece is a 21" *(533.4 mm)* thick test block made of P20 material *(28-32 Rc)*. They are using a Schienke Gundrill machine with Hulcut 745D semi-synthetic coolant *(10% concentrate)* at 1000 PSI *(69 bar)*.

The customer needed to decrease total hole costs and improve the tool life.

The **BT-A Drill** successfully decreased total hole costs while improving the tool life.



Product: BT-A
Objectives: Increase tool life
Industry: Tool, mold, & die
Part: Test block
Material: P20
Hole Ø: 0.734" *(18.644 mm)*
Hole Depth: 21" *(533.4 mm)*

Measure	Competitor	BT-A
RPM	1300	1575
Feed Rate	0.0054 IPR *(0.137 mm/rev)*	0.0046 IPR *(0.117 mm/rev)*
Penetration Rate	7.02 IPM *(178.308 mm/min)*	7.23 IPM *(183.642 mm/min)*
Cycle Time	3 min 10 sec	3 min 4 sec
Tool Life	19 holes	39 holes
BT-A offered *15%* cost per hole savings compared to competitor tooling.		

105% tool life increase

- Special Holder
  Item No. 081021-21
- Special Insert
  Item No. 081021-22

The BT-A provided:

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