

# QUICKSUPPORT

## TUBE SHEET & BAFFLE STACK PROCESSING / SUPPORT KIT

The complete processing / support kit for large and small tube sheets and baffle plates

### Benefits:

- Offers complete support throughout the entire work piece. This minimizes vibration during the drilling operation which in turn leads to increased feed rates, better hole quality and a dramatic increase in tool and insert life.



Pictured: Complete QuickSupport kit

### Features:

- Most cost effective way to support work piece
- Maximum support and rigidity
- Quick set-up
- Easy handling
- Works with both tube sheets and baffles
- Easy clean up

### Kit Includes:

- 2000 aluminum precision support tubes
- 200 aluminum support tube alignment washers
- 8, 1"x2"x2" clamp-over support blocks
- Chip removal brush
- Cordless 3/8" impact wrench kit
- 6, Adjustable support jacks
- Special set screw adapter driver

Call us for more information: 1-800-295-0509

Phone: 1-705-745-2961 ~ Fax: 1-705-745-8130

www.quickmill.com ~ E-mail: info@quickmill.com

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**QUICKMILL**<sup>®</sup>

*Much more than a machine.*

# QUICKSUPPORT CASE STUDIES

## Before:

Quickmill carried out testing at one of our heat exchanger clients to show the difference with proper support. On this particular day a tube sheet 3-3/4" thick by 84" diameter was being drilled.

The tube sheet was supported by a series of blocks around the outside diameter of the work piece as well as a number of clamps. The set-up looked appealing and rigid but when drilled using carbide it was found that it was not as solid of a set-up as first perceived.

During drilling a high pitched squealing was frequent and tool life was unpredictable and unreliable resulting in an average of about 254 drilled holes (952.5 linear inches) per insert due to poor set-up. Each drilled hole was produced in an average of about 25 seconds.

## After:

After seeing this part run, aluminum support tubes and washers were put in place for the next production part. The support tubes and washers were installed in a particular pattern, about 17 tubes and washers were used to support the tube sheet. There were also a number of 1" x 2" x 2" solid clamp-over blocks placed around the outer diameter of the work piece for placing the strap clamps over so that the aluminum blocks are not crushed when clamping.

During the drilling process it ran quiet with no squeal, the time per hole was reduced from 25 seconds to 19 seconds by increasing the feed rates. Tool life went up from the average 254 holes per insert to a now predictable and reliable 500 holes per insert, this equals about 1875 total linear inches.



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