Flamecut Weldments: Original T-A®

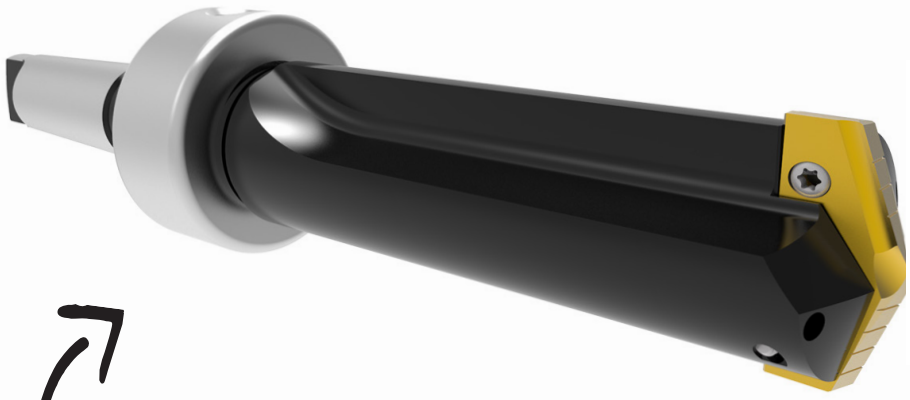
The customer machines flamecut A36 mild steel plate weldments using a radial arm drill machine with flood coolant.

Because this drilling operation was ineffective, the customer requested a solution to improve performance.

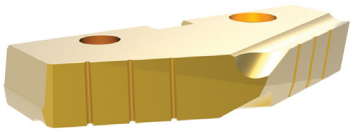
The **Original T-A** significantly improved the customer's process, providing substantial cost savings from multiple areas of the operation.

Product: Original T-A®
Objective: Improve performance
Industry: Structural steel/fabricator
Part: Flamecut weldments
Material: A36 mild steel plate
Hole Ø: 2.5" *(63.5 mm)*
Hole Depth: 4.0" *(101.6 mm)*

Measure	Competitor Drill	Original T-A®
RPM	60	115
Feed Rate	0.003 IPR *(0.076 mm/rev)*	0.012 IPR *(0.305 mm/rev)*
Penetration Rate	0.18 IPM *(4.572 mm/min)*	1.38 IPM *(35.052 mm/min)*
Cycle Time	22 min 13 sec	2 min 54 sec
Tool Life	75 holes	300 holes
The T-A offered *86.25%* cost per hole savings over the competitor tooling.		



▸ Original T-A
Holder: ***22050S-005I***
Insert: ***135T-0216***



300% tool life increase

The Original T-A provided:

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