



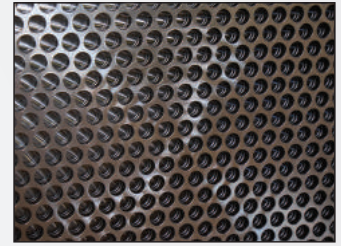
## Say Goodbye to Instability.

A predictable process is what you need. Our customer who drills tube sheets was previously having to run a peck cycle every 0.039" (1.00 mm).

Needing better chip formation and process stability, the customer tested Allied's **T-A Pro drill**. Using the "M" ISO-specific stainless steel insert geometry—developed for improved chip formation in difficult to machine stainless steels and heat resistant alloys—they were able to achieve the needed chip formation and eliminate peck cycles all together.

On top of the improved process stability, the T-A Pro had a decreased cycle time and increased tool life lowering the cost per hole by 33%. With the T-A Pro, your application is sure to be solid.

Dependable, consistent, stable--that's Allied. **We'll find the right solution for your toughest applications.**

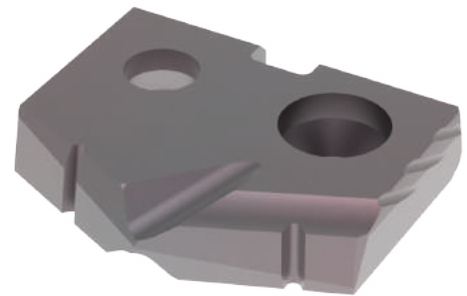


		Measure	Competitor Drill	T-A Pro Drill
<b>Product:</b>	T-A Pro drill			
<b>Objective:</b>	Process stability	<b>RPM</b>	1584	2178
<b>Industry:</b>	Heat exchangers/ Tube sheets	<b>Speed</b>	262 SFM (80.00 M/min)	360 SFM (110.00 M/min)
<b>Part:</b>	Tube sheets	<b>Feed Rate</b>	0.0079 IPR (0.20 mm/rev)	0.0060 IPR (0.15 mm/rev)
<b>Material:</b>	316 SS and A36	<b>Penetration Rate</b>	12.48 IPM (316.9 mm/min)	12.87 IPM (326.9 mm/min)
<b>Hole Ø:</b>	0.6331" (16.08 mm)	<b>Total Part Cycle Time</b>	46 sec	44 sec
<b>Hole Depth:</b>	9.2520" (235.00 mm)	<b>Tool Life</b>	50 holes	140 holes
<b>Tolerance:</b>	+/- 0.002" (0.05 mm)	T-A Pro offered <b>33%</b> cost per hole savings over the competitor tooling.		
<b>Required Surface Finish:</b>	125 Ra µin (3.2 µm)			

▶ T-A Pro holder  
Item No. HTA0C15-20FM

▶ T-A Pro insert  
M geometry (stainless steel)  
Item No. TAM0-16.08

180%  
tool life increase



The AM460 coated T-A Pro insert for stainless steel and HRSA materials provided:

- ✓ Improved process stability
- ✓ Decreased cycle time
- ✓ Decreased cost per hole
- ✓ Increased penetration rate

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