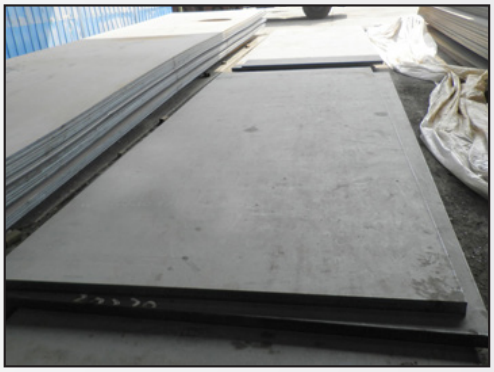
## Welded Stacked Plates: Original T-A®

The customer is drilling large welded stacked plates made of A516 material (GR70 approximately 20 Rc). The total thickness is 2.5" *(63.5 mm)* with gaps from 1/16" to 1/8" *(1.59mm to 3.18mm)*, which causes inconsistent face entry due to the wavy surface. They use a TOS horizontal boring machine with flood coolant.

All of these tools failed during testing, and the customer requested for Allied to provide a solution for this application.

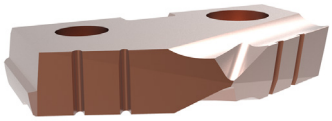
The **Original T-A** successfully completed the job despite the challenging application, which caused all previous tool testing to fail.



**Product:** Original T-A®
**Objective:** Successful run
**Industry:** General machining
**Part:** Welded stacked plates
**Material:** A516 material, GR70 approx 20 Rc
**Hole Ø:** 1.015" *(25.781 mm)*
**Hole Depth:** 7.0" *(177.8 mm)*

| Measure | Competitor | Original T-A® |
|---|---|---|
| RPM | The customer previously tested 3 other non-Allied tools, and all failed during testing. | 375 |
| Feed Rate | | 0.014 IPR *(0.356 mm/rev)* |
| Penetration Rate | | 5.2 IPM *(132.08 mm/min)* |
| Tool Life | | 200 holes |

- Original T-A
  Holder: ***22020S-004I***
  Insert: ***152H-1.015-IN***



***The Original T-A provided:***

✓ **Success in challenging application**