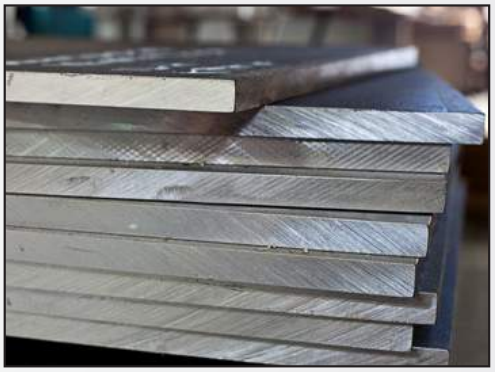
Structural Steel Plates: T-A GEN2

The customer is machining structural plates made from A36 structural steel. They are using a Peddinghaus machine with mist coolant.

Looking for performance improvements, the customer asked Allied to reduce cycle time and increse tool life.

The **T-A GEN2** drilling system made a significant difference for the customer. The customer was impressed that the less expensive Allied drill outperformed the much higher priced Kennametal tool.



Product: T-A GEN2
Objective: (1) Decrease cycle time
(2) Increase tool life
Industry: Structural steel/fabricator
Part: Structural steel plates
Material: A36 structural steel
Hole Ø: 0.875" *(22.225 mm)*
Hole Depth: 1.000" *(25.400 mm)*

Measure	Competitor	T-A GEN2
RPM	630	725
Feed Rate	0.0067 IPR *(0.170 mm/rev)*	0.0083 IPR *(0.211 mm/rev)*
Penetration Rate	4.2 IPM *(106.680 mm/min)*	6 IPM *(152.400 mm/min)*
Cycle Time	14.3 sec	10 sec
Tool Life	1000 holes	1150 holes

The T-A GEN2 offered *53.85%* cost per hole savings over the competitor tooling.

- T-A GEN2 insert
  Item No. 4C11H-0028
- T-A GEN2 holder
  Item No. 23015S-100F

30% cycle time decrease

The T-A GEN2 provided:

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