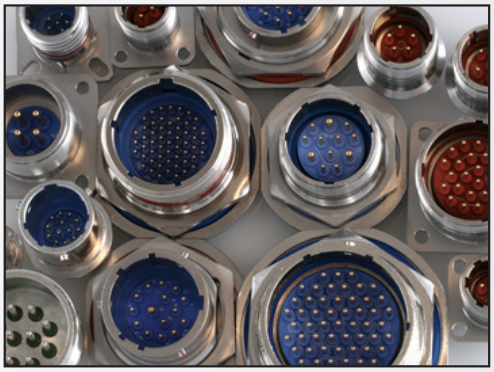
## Connector: Original T-A®

The customer manufactures components for the aerospace industry using a Mori Seiki lathe with a bar feeder running with 300 PSI oil coolant. They are machining aerospace connectors made from 6061-T6 aluminum.

Unsatisfied with this procedure, the customer needed to increase tool life and complete the entire drilling process in one operation.

The **Original T-A®** completed the process in one operation and provided significant cost-saving advantages for the customer.

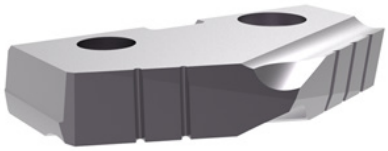


**Product:** Original T-A®
**Objective:** Increase tool life
**Industry:** Aerospace
**Part:** Connector
**Material:** 6061-T6 aluminum
**Hole Ø:** 1.4375″
**Hole Depth:** 6.0″

| Measure | Competitor | Original T-A® |
|---|---|---|
| RPM | 3000 | 3000 |
| Speed | 1129 SFM | 1129 SFM |
| Feed Rate | 0.012 IPR | 0.022 IPR |
| Penetration Rate | 36 IPM | 66 IPM |
| Cycle Time | 45 sec | 10.5 sec |
| Tool Life | 1250 holes | 10,500 holes |

23% cycle time decrease

▸ Original T-A
Holder: ***23030S-150L***
Insert: ***1C23A-0114***



*The Original T-A provided:*

- ✓ Decreased cycle time
- ✓ Lowered the cost of production
- ✓ Increased tool life