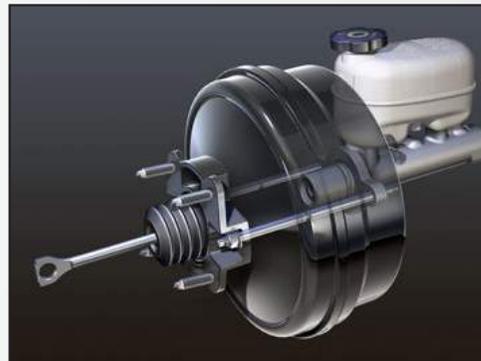


Master Brake Cylinder: T-A GEN2

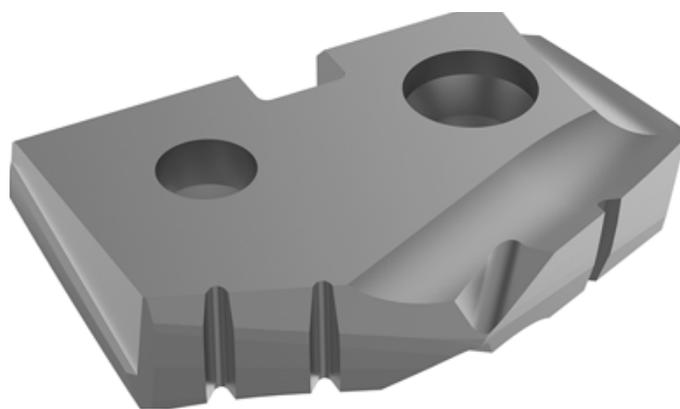
The customer is manufacturing master brake cylinders out of aluminum die cast for the automotive industry. They are using an HMC Twin Spindle with a 1000 PSI (69 Bar) blaster oil soluble coolant.

The customer needed to reduce the cost per part while maintaining the quality of the through hole size and straightness.

The **T-A GEN2** product not only maintained the quality of the hole size and straightness, but it also achieved optimal chip control at a high feed rate.



		Measure	Competitor	T-A GEN2
Product:	T-A GEN2			
Objective:	Decrease cost per part	RPM	4463	4463
Industry:	Automotive			
Part:	Master brake cylinder	Feed Rate	0.010 IPR (0.254 mm/rev)	0.015 IPR (0.381 mm/rev)
Material:	Aluminum die cast			
Hole Ø:	0.856" (21.742 mm)	Cycle Time	5.29 sec	3.53 sec
Hole Depth:	3.937" (100 mm)	Tool Life	10,000 holes	12,000 holes



- ▶ T-A GEN2 insert
Item No. 4C21N-8559
- ▶ Laser Clad Holder

33% cycle time decrease

The T-A GEN2 provided:

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