



## Good, Better, Best.

You can have a process that gets the job done, but is it the best or just simply good? Our customer who machines iron utility poles was previously using tooling that left them wishing for more consistency in their process.

Needing an increased tool life and better performance, the customer tested Allied's **T-A Pro drill**. Running the drill dry and using the "K" ISO-specific cast iron insert geometry—developed for maximum tool life, reduced exit burr, and improved hole finish—they were able to significantly increase their tool life and penetration rate.

On top of the increased tool life, the T-A Pro had a decreased cycle time reducing cost per hole nearly 80%. As Lincoln Chafee once said, "Trust is built with consistency," and consistency and dependability are exactly what the T-A Pro was able to bring our customer.

The success of the T-A Pro in this application is just another example of why the T-A Pro is more than just a good drill.

If you are looking for more than just getting the job done, **give us a call, and we will help you find the right solution.**



		Measure	Competitor Drill	T-A Pro Drill
<b>Product:</b>	T-A Pro drill	<b>RPM</b>	1950	2220
<b>Objective:</b>	Increase tool life	<b>Speed Rate</b>	303 SFM (92.35 M/min)	345 SFM (105.16 M/min)
<b>Industry:</b>	General machining	<b>Feed Rate</b>	0.010 IPR (0.25 mm/rev)	0.011 IPR (0.28 mm/rev)
<b>Part:</b>	Utility poles	<b>Penetration Rate</b>	19.50 IPM (495.3 mm/min)	24.42 IPM (619.8 mm/min)
<b>Material:</b>	Ductile cast iron	<b>Total Part Cycle Time</b>	2.148 sec	1.721 sec
<b>Hole Ø:</b>	0.5938" (15.08 mm)	<b>Tool Life</b>	225 holes	650 holes
<b>Hole Depth:</b>	0.7000" (17.78 mm)	T-A Pro offered <b>77.95%</b> cost per hole savings over the competitor tooling.		

▶ T-A Pro holder  
Item No. HTA0B03-075F

▶ T-A Pro insert  
K geometry (cast iron)  
Item No. TAK0-15.08

188.89%  
tool life increase



The ISO-specific TiAlN coated T-A Pro insert provided:

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

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