

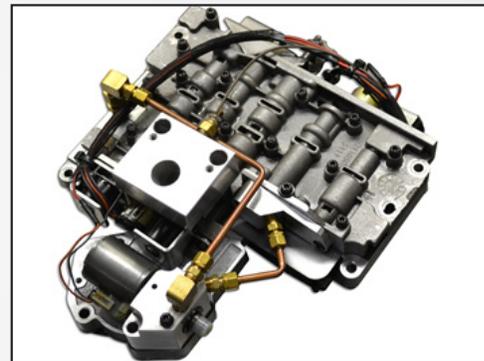


Valve Body: Original T-A®

The customer manufactures valves for the oil field industry using a custom-made spotting drill machine running with 60 PSI (4.137 bar) water soluble oil coolant. They are machining a valve body made from WCC cast steel.

In order to improve the production process, the customer needed to eliminate the costly tool regrinds and reduce the large amount of tool set-up time.

The **Original T-A** eliminated tool regrinds, reduced tool set up time, and increased the tool life.



Product:	Original T-A®	Measure	Competitor	Original T-A®
Objectives:	(1) Eliminate tool regrinds	RPM	430	430
	(2) Increase tool life	Speed	141 SFM (42.977 mm)	141 SFM (42.977 mm)
	(3) Reduce set-up time	Feed Rate	0.005 IPR (0.127 mm)	0.005 IPR (0.127 mm)
Industry:	Oil & gas/petrochemical	Penetration Rate	2.15 IPM (54.61 mm)	2.15 IPM (54.61 mm)
Part:	Valve body	Tool Set Up Time	29 min	4 min
Material:	WCC cast steel	Cycle Time	10.5 sec	10.5 sec
Hole Ø:	1.25" (31.75 mm)	Tool Life	75 holes	138 holes
Hole Depth:	0.375" (9.525 mm)			



▶ Original T-A
Holder: 020128-8
Insert: 152T-0108-SP

84% tool life increase

The Original T-A provided:

- ✓ Decreased set up time
- ✓ Increased tool life
- ✓ Eliminated regrind

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