

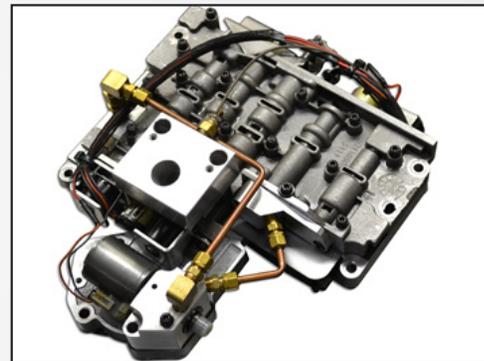


## Valve Body: Original T-A®

The customer manufactures valves for the oil field industry using a custom-made spotting drill machine running with 60 PSI 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.



		Measure	Competitor	Original T-A®
<b>Product:</b>	Original T-A®	RPM	430	430
<b>Objectives:</b>	(1) Eliminate tool regrinds (2) Increase tool life (3) Reduce set-up time	Speed	141 SFM	341 SFM
<b>Industry:</b>	Oil & gas/petrochemical	Feed Rate	0.005 IPR	0.005 IPR
<b>Part:</b>	Valve body	Penetration Rate	2.15 IPM	2.15 IPM
<b>Material:</b>	WCC cast steel	Tool Set Up Time	29 min	4 min
<b>Hole Ø:</b>	1.25"	Cycle Time	10.5 sec	10.5 sec
<b>Hole Depth:</b>	0.375"	Tool Life	75 holes	138 holes



▶ 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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