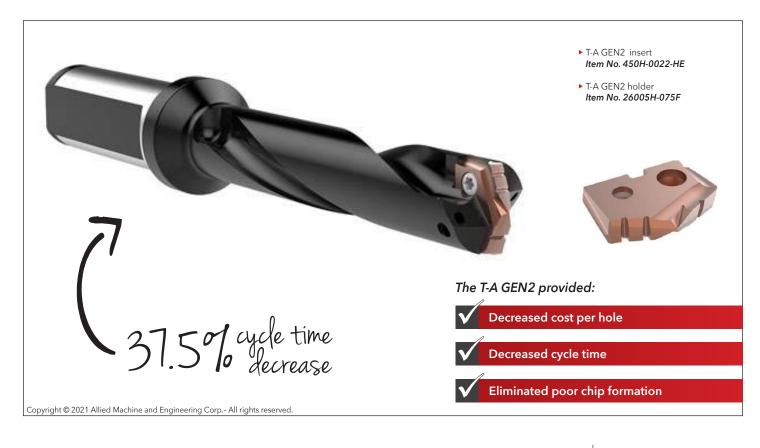
## 44W Structural Steel Plate: T-A GEN2

The customer is drilling solid steel plates made of 44W structural steel. They are using a Daewoo 4020 D 20HP Vertical Machining Center with 300 PSI (20.684 Bar) through tool coolant.

The customer requested a tool that could break the chip, as they were getting 'bird nests' around the spindle every time.

The **T-A GEN2** eliminated the poor chip formation while significantly reducing the cost per hole.

		Measure	Competitor	T-A GEN2
Product:	T-A GEN2	RPM	525	1230
Objective:	Better chip formation			
Industry:	Structural steel/ fabricator	Feed Rate	0.010 IPR (0.254 mm/rev)	0.007 IPR (0.178 mm/rev)
Part:	Plate	Penetration Rate	5.25 IPM (133.350 mm/min)	8.8 IPM (223.520 mm/min)
Material:	44W structural steel	Cuele Time	1	45
Hole Ø:	<b>0.813</b> " (206.502 mm)	Cycle Time	1 min 12 sec	45 sec
Hole Depth:	<b>4.000"</b> (101.600 mm)	Tool Life	1200 linear inches (30.48M)	1500 linear inches (38.1M)
		The T-A GEN2 offered 95% cost per hole savings over the competitor tooling.		





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