

Original T-A®

Case Study: 1018
Industry: Oil & Gas/Petrochemical
Part: Wire Line Component
Material: Monel Alloy
Diameter: 0.750"
Depth: 3.4"
Insert: 151A-0024
Holder: 23010S-100F



The Challenge

A contract machine shop maintains and repairs equipment for chemical plants and oil fields. The part being machined is a wire line component for offshore drilling made of Monel alloy. They are using an M5 Mazak CNC with semi-synthetic coolant to produce their products.

The customer needed to reduce the cycle time and increase their overall production.

The Advantages

The Original T-A successfully reduced cycle time and lowered the customer's cost-per-hole.

- Total cost savings = \$2,507 or 45.54%

Previous Tooling

Precision twist solid cobalt drill

- 250 RPM
- 0.004 IPR
- Tool life = 4 holes per regrind
- Cycle time = 3.9 minutes
- Cost per hole = \$22.02

Allied Machine Solution

Original T-A®

- 300 RPM
- 0.004 IPR
- Cycle time = 3.33 minutes
- Cost per hole = \$11.99

