



Do you need consistency in your machining?

Catastrophic failures were causing our customer frustration as they were machining link arms for the agricultural industry. They previously used indexable drills to try and eliminate flex; however, there was still some flex, which resulted in OD insert chipping.

Looking for consistency and eliminating catastrophic failures, the customer tested Allied's **T-A Pro Drill**. Using the "K" geometry insert—designed to provide increased penetration rates and tool life in cast iron applications—they successfully eliminated tool failures.

The previous tooling was extremely inconsistent and provided anywhere from 25 parts to 125 parts with a 7 minute cycle time. Utilizing the T-A Pro "K" geometry, they achieved 250 parts with only a 6 minute cycle time. With the T-A Pro, our customer was also able to dramatically increase the penetration rate.

The consistency in tool life and elimination of tool failures made switching to the T-A Pro an easy decision for our customer.

Consistency saves you more than just some frustration.

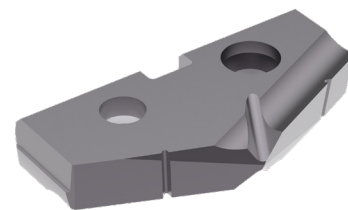
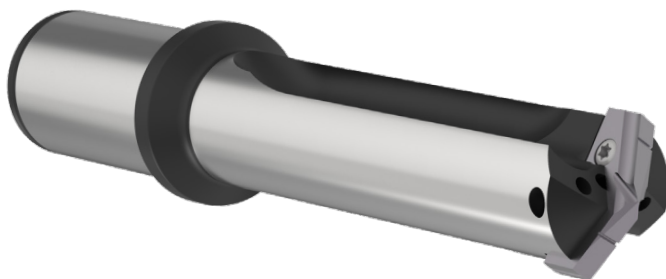


		Measure	Competitor IC Drill	T-A Pro Drill
Product:	T-A Pro Drill	RPM	1386	1386
Objective:	Decrease tool failure	Speed Rate	500 SFM (152.4 M/min)	500 SFM (152.4 M/min)
Industry:	Agricultural	Feed Rate	0.0045 IPR (0.114 mm/rev)	0.011 IPR (0.279 mm/rev)
Part:	Link arm	Penetration Rate	6.24 IPM (158.496 mm/min)	15.25 IPM (387.35 mm/min)
Material:	Ductile iron	Cycle Time	7 min	6 min
Hole Ø:	1.378" (35.001 mm)	Tool Life	25 - 125 parts	250 parts
Hole Depth:	2.362" (59.995 mm)	Tool Failure?	Yes	No

- ▶ T-A Pro Drill holder
3xD length
Item No. HTA2D03-150F

- ▶ T-A Pro Insert
K geometry (cast iron)
Item No. TAK2-35.00

14.29%
cycle time decrease



The cast iron specific, TiAlN coated T-A Pro insert provided:

- ✓ Increased tool life
- ✓ Decreased cycle time
- ✓ Eliminated tool failures