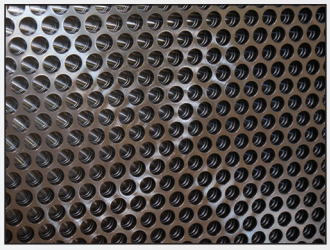
T-A PRO® DRILL

Say Goodbye to Instability.



A predictable process is what you need. Our customer who drills tube sheets was previously having to run a peck cycle every 0.039" *(1.00 mm)*.

Needing better chip formation and process stability, the customer tested Allied's ***T-A Pro drill***. Using the "M" ISO-specific stainless steel insert geometry–developed for improved chip formation in difficult to machine stainless steels and heat resistant alloys–they were able to achieve the needed chip formation and eliminate peck cycles all together.

On top of the improved process stability, the T-A Pro had a decreased cycle time and increased tool life lowering the cost per hole by 33%. With the T-A Pro, your application is sure to be solid.

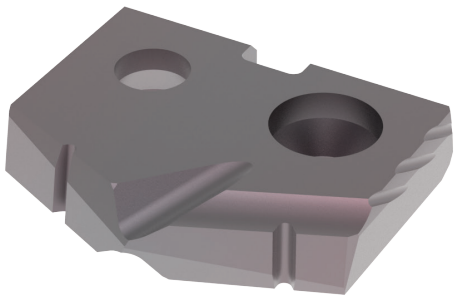
Dependable, consistent, stable--that's Allied. ***We'll find the right solution for your toughest applications.***

Product:	T-A Pro drill
Objective:	Process stability
Industry:	Heat exchangers/ Tube sheets
Part:	Tube sheets
Material:	316 SS and A36
Hole Ø:	0.6331" *(16.08 mm)*
Hole Depth:	9.2520" *(235.00 mm)*
Tolerance:	+/- 0.002" *(0.05 mm)*
Required Surface Finish:	125 Ra µin *(3.2 µm)*

Measure	Competitor Drill	T-A Pro Drill
RPM	1584	2178
Speed	262 SFM *(80.00 M/min)*	360 SFM *(110.00 M/min)*
Feed Rate	0.0079 IPR *(0.20 mm/rev)*	0.0060 IPR *(0.15 mm/rev)*
Penetration Rate	12.48 IPM *(316.9 mm/min)*	12.87 IPM *(326.9 mm/min)*
Total Part Cycle Time	1 min 40 sec	44 sec
Tool Life	50 holes	140 holes
T-A Pro offered ***33%*** cost per hole savings over the competitor tooling.		

- T-A Pro holder
  Item No. HTA0C15-20FM
- T-A Pro insert
  M geometry (stainless steel)
  Item No. TAM0-16.08

180% tool life increase



The AM460 coated T-A Pro insert for stainless steel and HRSA materials provided:

- ✓ Improved process stability
- ✓ Decreased cycle time
- ✓ Decreased cost per hole
- ✓ Increased penetration rate