



## Battery Packs: Original T-A®

The customer manufactures battery packs made from hard plastic for the aerospace industry. They are using a Haas VMC CAT40 taper VF3 running without coolant.

The customer needed a more cost effective solution. They asked Allied Machine to decrease the cycle time and reduce the overall cost of production.

The **Original T-A** reduced the cycle time and provided substantial reduction in cost.



	Measure	Competitor 2 Tool Process		Original T-A®
		Twist Drill	Boring Process	
<b>Product:</b> Original T-A®	RPM	630	1168	1200
<b>Objective:</b> Decrease cycle time	Feed Rate	0.008 IPR	0.003 IPR	0.004 IPR
<b>Industry:</b> Aerospace	Cycle Time	3 min 22 sec		1 min 57 sec
<b>Part:</b> Battery packs	Cost Per Hole	\$13.41		\$2.87
<b>Material:</b> Hard plastic				
<b>Hole Ø:</b> 1.0625"				
<b>Hole Depth:</b> 7.0"				



78% cost savings

▶ Original T-A  
Holder: **24025H-125F**  
Insert: **1C22A-0102**



**The Original T-A provided:**

- ✓ Decreased cycle time
- ✓ Lowered the cost of production
- ✓ Elimination of boring operation

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