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.

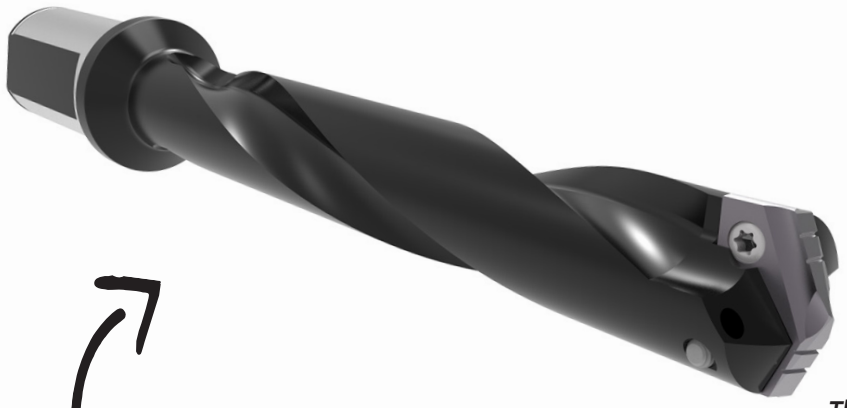
The customer needed a more cost effective solution. They asked Allied Machine to decrease the cycle time and reduce the overall cost of production.

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

Product: Original T-A®
Objective: Decrease cycle time
Industry: Aerospace
Part: Battery packs
Material: Hard plastic
Hole Ø: 1.0625" *(26.998 mm)*
Hole Depth: 7.0" *(177.8 mm)*

Measure	Competitor 2 Tool Process		Original T-A®
	Twist Drill	Boring Process	
RPM	630	1168	1200
Feed Rate	0.008 IPR *(0.203 mm/rev)*	0.003 IPR *(0.076 mm/rev)*	0.004 IPR *(0.102 mm/rev)*
Cycle Time	3 min 22 sec		1 min 57 sec

The T-A offered *78.60%* cost per hole savings over the competitor tooling.



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