

Original T-A®

Case Study: 1012
Industry: Oil&Gas/Petrochemical
Part: Wrench
Material: Alloy Steel
Diameter: 0.937"
Depth: 4.0"
Item: 151A-0030-NP
Holder: 27010S-100L



The Challenge

A contract machine shop that repairs and maintains equipment for the oilfield industry is machining the base of a wench for an offshore oil rig made from alloy steel. They use a Lucas HBM NMTB taper with through coolant using RCA to produce their products.

The customer needed a solution to reduce the cycle time of the process.

The Advantages

The Original T-A reduced the machine's cycle time while providing increased penetration rates.

- Total cost savings = \$81.05 or 14.15%

Previous Tooling

Original T-A insert (item 180N-13) with modified

- 500 RPM
- 0.006 IPR
- Cycle time = 1.83 minutes

Allied Machine Solution

Original T-A®

- 620 RPM
- 0.005 IPR
- Cycle time = 1.79 minutes

