



## Quiet the Noise.

Sometimes you just need some peace and quiet. Our customer who machines plunger assemblies was previously running a competitor high penetration drill that was extremely loud, causing their machine operators to have to wear hearing protection while running the job, in addition to the Z-axis load on the machine always being over 100%.

Needing to eliminate the loud drill noise, the customer tested Allied's **T-A Pro drill**. Using the "P" ISO-specific steel insert geometry—designed to provide increased penetration rates and tool life—they were able to increase their speed and feed while decreasing the noise made.

On top of the success of reducing the drill noise, the T-A Pro had an increased tool life and decreased cycle time, which lowered the cost per hole by 55%. The sweet harmony of the T-A Pro in this application just shows why our customer was singing its praises.

If you are looking to quiet the noise, **we will help you find the right solution.**



		Measure	Competitor Drill	T-A Pro Drill
<b>Product:</b>	T-A Pro drill	<b>RPM</b>	882	1188
<b>Objective:</b>	Reduce drill noise	<b>Speed</b>	260 SFM (79.25 M/min)	350 SFM (106.68 M/min)
<b>Industry:</b>	Oil & gas/ Petrochemical	<b>Feed Rate</b>	0.0060 IPR (0.15 mm/rev)	0.0100 IPR (0.25 mm/rev)
<b>Part:</b>	Plunger assembly	<b>Penetration Rate</b>	5.30 IPM (134.6 mm/min)	11.88 IPM (301.8 mm/min)
<b>Material:</b>	4140 Steel	<b>Total Part Cycle Time</b>	65 sec	29 sec
<b>Hole Ø:</b>	1.125" (28.58 mm)	<b>Tool Life</b>	203 holes	455 holes
<b>Hole Depth:</b>	5.750" (146.05 mm)	T-A Pro offered <b>55%</b> cost per hole savings over the competitor tooling.		
<b>Tolerance:</b>	+/- 0.005" (0.13 mm)			

▶ T-A Pro holder  
Item No. HTA2C05-125F

▶ T-A Pro insert  
P geometry (steel)  
Item No. TAP2-28.58

124%  
tool life increase



The AM300 coated T-A Pro insert for use in steel provided:

- ✓ Reduced drill noise
- ✓ Decreased cycle time
- ✓ Decreased cost per hole
- ✓ Increased penetration rate

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