



## Looking to lower your cost?

Tooling cost was hindering our customer who machines brake brackets for the automotive industry. They previously used a competitor replaceable tip drill in ductile iron, but the performance wasn't meeting their expectations.

Looking to improve their performance and lower costs, the customer tested Allied's **T-A Pro Drill**. Using the "K" geometry insert—designed to provide increased penetration rates and tool life in cast iron applications—they successfully decreased their cost per hole.

While maintaining the same speeds and feeds, the T-A Pro was largely successful in increasing tool life from 16,000 holes to 20,000—a twenty-five percent increase. The customer also saw a decrease in their cycle time due to Allied's ability to compact the tool design, which paired with the increased tool life significantly lowered the customer's annual tooling cost.

The success of T-A Pro in this application is just another example of why the T-A Pro is more than your typical spade drill.

**Sometimes going back to the basics saves you more.**

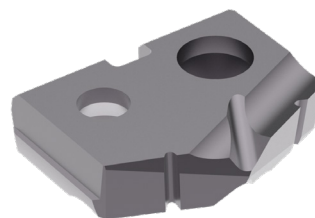


		Measure	Competitor Drill	T-A Pro Drill
<b>Product:</b>	T-A Pro Drill	RPM	2500	2500
<b>Objective:</b>	Decrease costs	Speed Rate	360 SFM (109.7 M/min)	360 SFM (109.7 M/min)
<b>Industry:</b>	Automotive	Feed Rate	0.009 IPR (0.229 mm/rev)	0.009 IPR (0.229 mm/rev)
<b>Part:</b>	Brake bracket	Penetration Rate	22.5 IPM (571.5 mm/min)	22.5 IPM (571.5 mm/min)
<b>Material:</b>	Ductile iron	Total Part Cycle Time	3 min 19 sec	3 min 14 sec
<b>Hole Ø:</b>	0.551" (13.995 mm)	Tool Life	16,000 holes	20,000 holes
<b>Hole Depth:</b>	1.181" (29.997 mm)	T-A Pro offered <b>39.96%</b> annual savings over the competitor tooling.		

▶ Special T-A Holder  
Item No. 201020-25

▶ T-A Pro Insert  
K geometry (cast iron)  
Item No. TAK0-14.00

25%  
tool life increase



The cast iron specific, TiAlN coated T-A Pro insert provided:

- ✓ Increased tool life
- ✓ Decreased cycle time
- ✓ Decreased annual tooling cost

