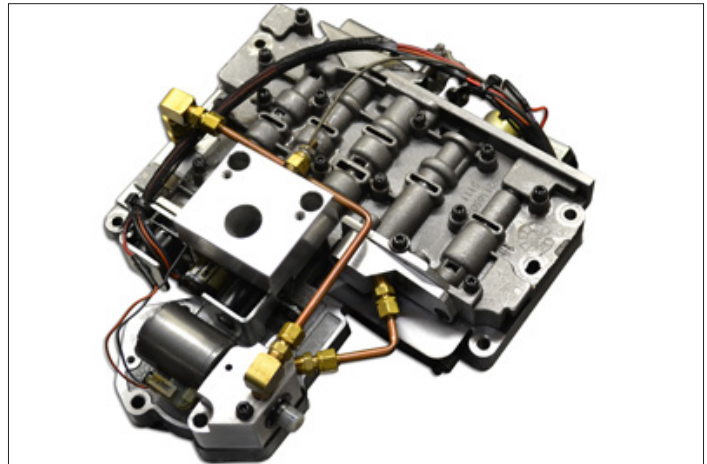


Original T-A®

Case Study: 1016
Industry: Oil & Gas/Petrochemical
Part: Valve Body
Material: WCC Cast Steel
Diameter: 1.2500"
Depth: 0.375"
Insert: 152T-0108-SP
Holder: 020128-8



The Challenge

The customer manufactures valves for the oil field industry using a custom-made spotting drill machine running with 60 PSI water soluble oil coolant. They are machining a valve body made from WCC cast steel.

In order to improve the production process, the customer needed to eliminate the costly tool regrinds and reduce the large amount of tool set-up time.

The Advantages

The Original T-A eliminated tool regrinds, reduced tool set-up time, and increased the tool life.

- Eliminated tool regrinds
- Decreased set-up time by 86%
- Total cost savings = \$6,778 or 46.6%

Previous Tooling

Guhring 90° spot drill

- 430 RPM
- 141 SFM
- 0.005 IPR
- 2.15 IPM
- Tool set up time = 29 minutes
- Cycle time = 10.5 seconds
- Tool life = 75 holes (required 8 regrinds)

Allied Machine Solution

Original T-A®

- 430 RPM
- 141 SFM
- 0.005 IPR
- 2.15 IPM
- Tool set up time = 4 minutes
- Cycle time = 10.5 seconds
- Tool life = 138 holes (eliminated regrinds)

