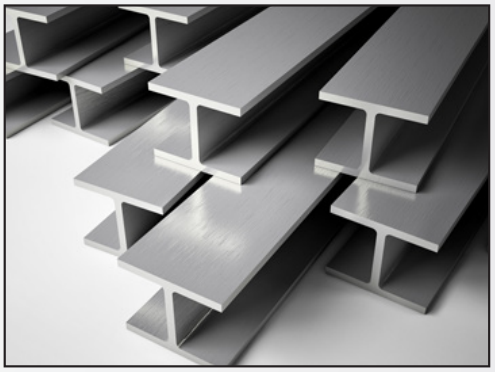
I-Beams and H-Beams: Original T-A®

A customer is a large structural steel and ductwork specialty contractor in the construction industry. They manufacture I-Beams and H-Beams made from structural steel using a Peddinghaus with soluble oil mist coolant. The customer's annual production is over 100,000 tons *(90,718.5 metric tons)* of steel beams, bars, and ductwork.

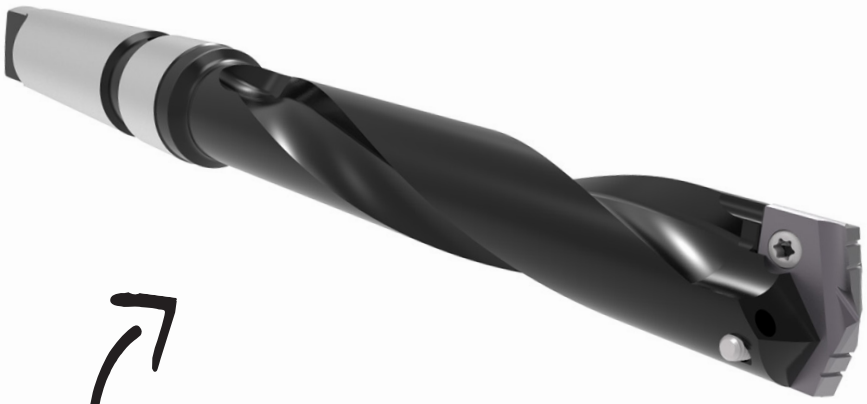
The customer wanted to increase productivity while decreasing the overall cost of production.

The **Original T-A** structural steel solution reduced the machine's cycle time and also lowered the cost of production while increasing the overall productivity.



Product: Original T-A®
Objectives: (1) Increase productivity (2) Decrease cost
Industry: Structural steel/fabricator
Part: I-beams and H-beams
Material: Structural steel
Hole Ø: 1.1875" *(30.163 mm)*
Hole Depth: 0.8" *(20.320 mm)*

Measure	Competitor	Original T-A®
RPM	350	320
Speed	109 SFM *(33.223 M/min)*	99 SFM *(30.175 M/min)*
Feed Rate	0.003 IPR *(0.076 mm/rev)*	0.011 IPR *(0.279 mm/rev)*
Penetration Rate	1.05 IPM *(26.670 mm/min)*	3.52 IPM *(89.408 mm/min)*
Cycle Time	45.7 sec	13.6 sec
Tool Life	500 holes	500 holes



- Original T-A
  Holder: ***24020H-004IS100***
  Insert: ***152A-0106-SS***

70% cycle time decrease

The Original T-A provided:

- ✓ Decreased cycle time
- ✓ Decreased cost
- ✓ Increased productivity