



## Trying to keep up?

An increase in demand created a need for improved processes for our customer who machines fluid transfer couplings for the oil and gas industry. Their previous tooling was successful, but they were looking for a better cycle time.

Hoping to improve their performance and lower costs, the customer tested Allied's **T-A Pro Drill**. Using the "X" high-speed steel geometry insert—designed to provide increased penetration rates and tool life—they successfully decreased cycle time and increased tool life.

When running the T-A Pro, our customer was able to run at higher speeds and feeds leaving them with a 20% increase in penetration rate. The increase in penetration rate while also increasing tool life led to almost 50% cost per hole savings.

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

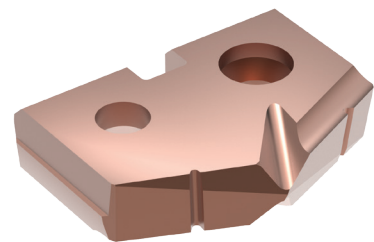
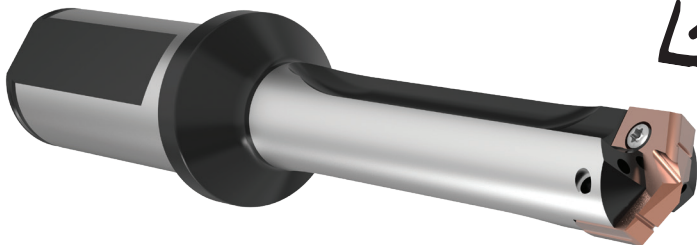
**Call us to help you find the right tool for the job.**



		Measure	Competitor Drill	T-A Pro Drill
<b>Product:</b>	T-A Pro Drill			
<b>Objective:</b>	Increase tool performance	<b>Speed Rate</b>	225 SFM (68.58 M/min)	250 SFM (76.2 M/min)
<b>Industry:</b>	Oil & gas/petrochemical	<b>Feed Rate</b>	0.009 IPR (0.229 mm/rev)	0.01 IPR (0.254 mm/rev)
<b>Part:</b>	Fluid transfer couplings	<b>Penetration Rate</b>	10.92 IPM (277.368 mm/min)	13.48 IPM (342.392 mm/min)
<b>Material:</b>	1045 steel	<b>Total Part Cycle Time</b>	10.989 sec	8.9 sec
<b>Hole Ø:</b>	0.7087" (18 mm)	<b>Tool Life</b>	1500" (38.1M)	2000" (50.8M)
<b>Hole Depth:</b>	2.0000" (50.8 mm)	T-A Pro offered <b>48.65%</b> cost per hole savings over the competitor tooling.		

- ▶ T-A Pro Holder  
Item No. HTA1A03-100F
- ▶ T-A Pro Insert  
X geometry (high-speed steel)  
Item No. TAX1-18.00

33%  
tool life increase



The AM200 coated T-A Pro insert provided:

- ✓ Increased tool life
- ✓ Decreased cycle time
- ✓ Decreased cost per hole