



Flamecut Weldments: Original T-A®

The customer machines flamecut A36 mild steel plate weldments using a radial arm drill machine with flood coolant.

Because this drilling operation was ineffective, the customer requested a solution to improve performance.

The **Original T-A** significantly improved the customer's process, providing substantial cost savings from multiple areas of the operation.



Product: Original T-A® Objective: Improve performance Industry: Structural steel/fabricator Part: Flamecut weldments Material: A36 mild steel plate Hole Ø: 2.5" (63.5 mm) Hole Depth: 4.0" (101.6 mm)	Measure	Competitor Drill	Original T-A®
	RPM	60	115
	Feed Rate	0.003 IPR (0.076 mm/rev)	0.012 IPR (0.305 mm/rev)
	Penetration Rate	0.18 IPM (4.572 mm/min)	1.38 IPM (35.052 mm/min)
	Cycle Time	22 min 13 sec	2 min 54 sec
	Tool Life	75 holes	300 holes
	The T-A offered 86.25% cost per hole savings over the competitor tooling.		



► Original T-A
Holder: 22050S-005I
Insert: 135T-0216



300% tool life increase

The Original T-A provided:

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