



## 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.



		Measure	Competitor	Original T-A®
<b>Product:</b>	Original T-A®	RPM	350	320
<b>Objectives:</b>	(1) Increase productivity (2) Decrease cost	Speed	109 SFM (33.223 M/min)	99 SFM (30.175 M/min)
<b>Industry:</b>	Structural steel/fabricator	Feed Rate	0.003 IPR (0.076 mm/rev)	0.011 IPR (0.279 mm/rev)
<b>Part:</b>	I-beams and H-beams	Penetration Rate	1.05 IPM (26.670 mm/min)	3.52 IPM (89.408 mm/min)
<b>Material:</b>	Structural steel	Cycle Time	45.7 sec	13.6 sec
<b>Hole Ø:</b>	1.1875" (30.163 mm)	Tool Life	500 holes	500 holes
<b>Hole Depth:</b>	0.8" (20.320 mm)			



► 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

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