



Gear Actuator Housing: Original T-A®

A customer manufactures ball screws, aerospace actuators, and landing gear actuators for the aerospace industry. In this application, they are using an Okuma VMC with 750 PSI (51.711 bar) through-tool coolant to machine a gear actuator housing made from cast stainless steel.

Unsatisfied with their current process, the customer needed to increase tool life and reduce the cost of production.

The **Original T-A** drill achieved the customer's goals by increasing tool life while lowering the overall cost of production.



Product: Original T-A® Objective: Increase tool life Industry: Aerospace Part: Gear actuator housing Material: Cast stainless steel Hole Ø: 0.25" (6.350 mm) Hole Depth: 0.7030" (17.856 mm)	Measure	Competitor	Original T-A®
	RPM	733	760
	Feed Rate	0.007 IPR (0.178 mm/rev)	0.008 IPR (0.203 mm/rev)
	Penetration Rate	5.13 IPM (130.302 mm/min)	6.08 IPM (154.432 mm/min)
	Cycle Time	15 sec	14.5 sec
	Tool Life	10 holes	40 holes



► Original T-A
Holder: **23010S-100L**
Insert: **1C51A-.703**



300% tool life increase

The Original T-A provided:

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