



I-Beams: Original T-A®

The customer needs to drill holes in I-beams made from A36 structural steel. They just purchased a new Peddinghaus PCD 1100 Beam Drill Line.

The customer needed to reduce costs by decreasing the tool failure. Also, the machine operator was unhappy with the long stringy chips produced by the Nachi drills.

The **Original T-A** structural steel drill provided excellent chip formation (tightly curled 6's and 9's). More importantly, the drill eliminated the tool breakage issue.



Product: Original T-A® Objectives: (1) Decrease tool failure (2) Improve chip formation Industry: Structural steel/fabricator Part: I-beams Material: Structural steel Hole Depth: 0.75" (19.05 mm)	Measure	Competitor	Original T-A®
	RPM	700	516
	Feed Rate	0.007 IPR (0.178 mm/rev)	0.009 IPR (0.229 mm/rev)
	Penetration Rate	4.9 IPM (124.46 mm/min)	4.65 IPM (118.11 mm/min)
	Tool failure?	Yes	No



*eliminated
tool failure*

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



The Original T-A provided:



Improved chip formation



Eliminated tool breakage