

Connector: Original T-A®

The customer manufactures components for the aerospace industry using a Mori Seiki lathe with a bar feeder running with 300 PSI (20.684 bar) oil coolant. They are machining aerospace connectors made from 6061-T6 aluminum.

Unsatisfied with this procedure, the customer needed to increase tool life and complete the entire drilling process in one operation.

The **Original T-A®** completed the process in one operation and provided significant cost-saving advantages for the customer.



		Measure	Competitor	Original T-A®
Product:	Original T-A®	RPM	3000	3000
Objective:	Increase tool life	Speed	1129 SFM (344.119 M/min)	1129 SFM (344.119 M/min)
Industry:	Aerospace	Feed Rate	0.012 IPR (0.305 mm/rev)	0.022 IPR (0.559 mm/rev)
Part:	Connector	Penetration Rate	36 IPM (914.4 mm/min)	66 IPM (1676.4 mm/min)
Material:	6061-T6 aluminum	Cycle Time	45 sec	10.5 sec
Hole Ø:	1.4375" (36.513 mm)	Tool Life	1250 holes	10,500 holes
Hole Depth:	6.0" (152.4 mm)			



► Original T-A
Holder: 23030S-150L
Insert: 1C23A-0114



23% cycle time decrease

The Original T-A provided:

- ✓ Decreased cycle time
- ✓ Lowered the cost of production
- ✓ Increased tool life