

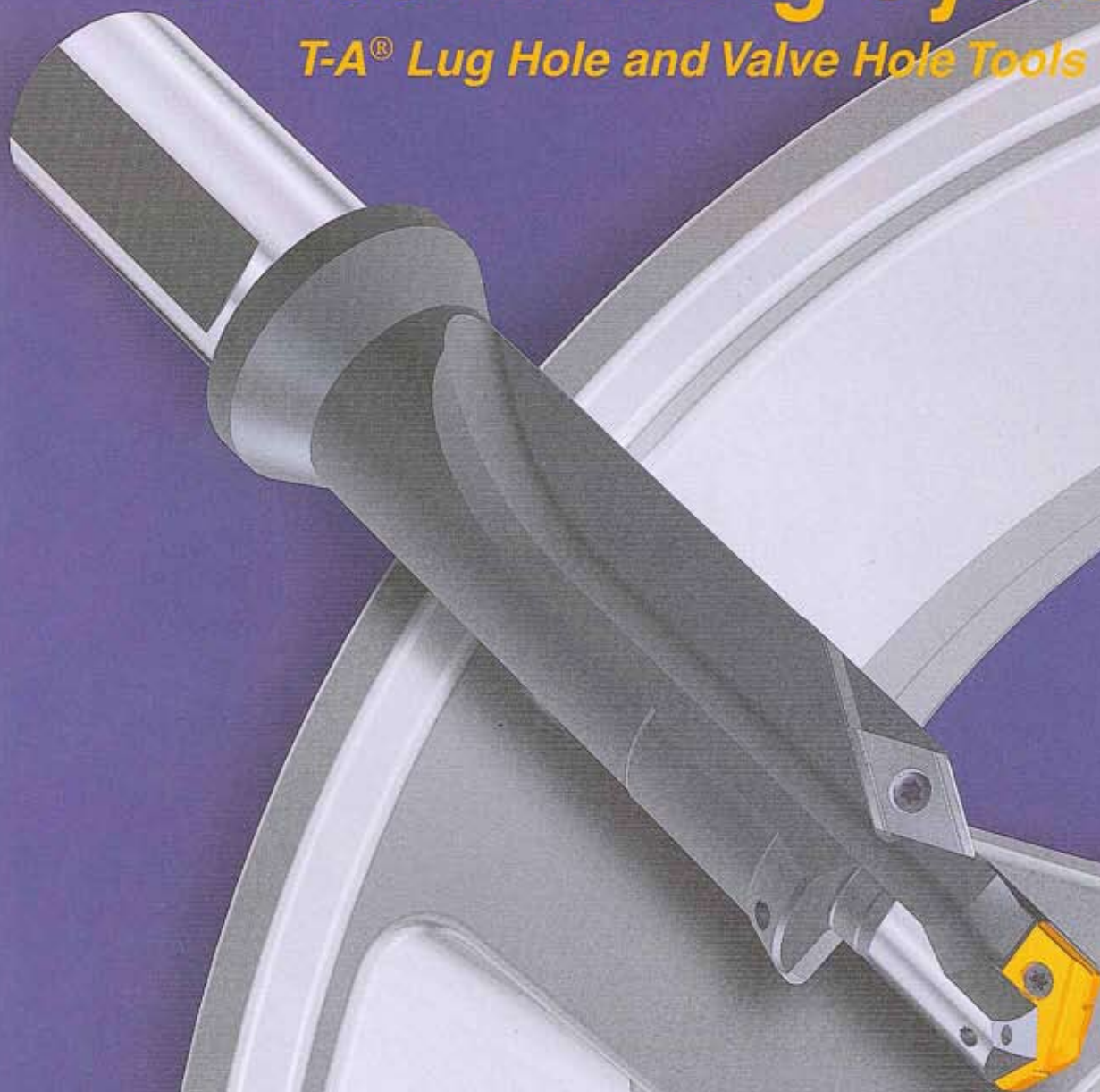


®

Allied Machine & Engineering Corp.

Wheel Drilling System

T-A[®] Lug Hole and Valve Hole Tools



Represented By:

T-A[®] Lug Hole Drills



Conical Seat, Counterbore Lug Hole Drill

Prototype Grade Lug Hole Drill

The prototype holder grade has been developed to meet the quick delivery demands normally associated with the prototype phase of wheel manufacturing. Due to short lead times, the prototype grade is recommended as a production grade replacement in an emergency. They are delivered in **5 working days**.

Production Grade Lug Hole Drill

Production grade holders are designed, with additional features, to assure maximum performance and life. Customers with long wheel production runs will find that the production grade offers the lowest cost per hole. They are delivered in **5 weeks**.



Quotation & Ordering Information

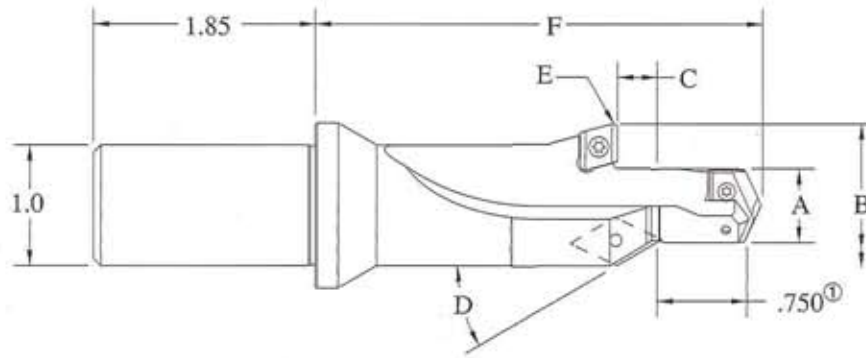
Put this unique drilling system to work for your automotive wheel application. Simply select a tool from the following pages. Fill in the data in the appropriate tables from pages 2 and 3 of this brochure and check any options you wish to include. Fax or mail a copy to your authorized AMEC distributor along with drawings of the hole configuration if available. AMEC's engineering staff will evaluate your application and respond with a quotation through your distributor.

Upon receipt of your purchase order a drawing will be sent for your approval, and future reference. Please note that all tool drawings are the property of AMEC. We hold all customer information in strict confidence, and ask that you maintain the same confidentiality with our design investment.



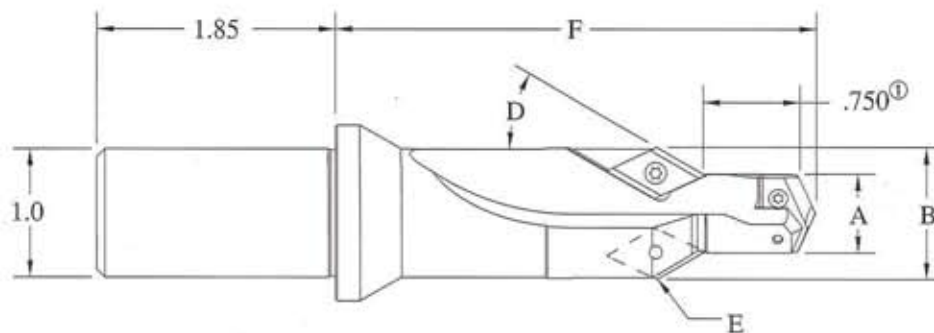
Conical Seat Lug Hole Drill

T-A[®] Conical Seat, Counterbore Lug Hole Drill



Mark Item No.	A Drill Diameter ^②	B C'Bore Diameter	C Conical Seat Length	D Cone Angle	E Corner Radius	F Tool Reference Length
						<input type="checkbox"/> 3.73 ^③ <input type="checkbox"/> 4.73
Options:	<input type="checkbox"/> 1/16" Flat on Shank <input type="checkbox"/> Through Tool Coolant <input type="checkbox"/> Shank Dia. Modification			Grade:	<input type="checkbox"/> Prototype <input type="checkbox"/> Production	

T-A[®] Conical Seat Lug Hole Drill



Mark Item No.	A Drill Diameter ^②	B C'Sink Diameter	D Cone Angle	E Corner Radius	F Tool Reference Length	
					<input type="checkbox"/> 3.73 ^③ <input type="checkbox"/> 4.73	
Options:	<input type="checkbox"/> 1/16" Flat on Shank <input type="checkbox"/> Through Tool Coolant <input type="checkbox"/> Shank Dia. Modification			Grade:	<input type="checkbox"/> Prototype <input type="checkbox"/> Production	

① Measured from the intersection of the chamfer insert and drill diameter, to the O.D. corner of the T-A[®] blade.

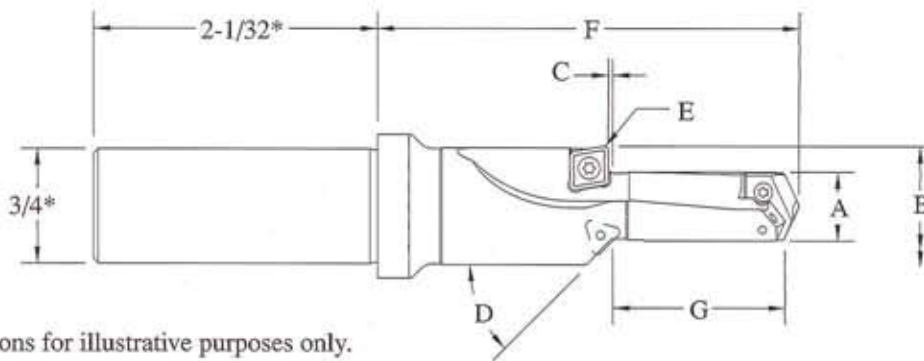
② On pilot diameters larger than .618 on "0" series Lug Hole Drills, we suggest chrome plating the pilot of prototypes for added stability.

③ #1 series available in this length only.

T-A[®] Valve Hole Drill

Valve Hole Drill

Valve Hole Drills are engineered and manufactured to meet the demanding valve stem hole drilling requirements. They are delivered in **5 weeks** and are only available in the production grade.



* Dimensions for illustrative purposes only.

Mark Item No.	A Drill Diameter	B C'Bore Diameter	C Chamfer Length	D Chamfer Angle	E Corner Radius	F Tool Reference Length	G Pilot Length ^①

Options: 1/16" Flat on Shank Shank Dia. Modification

① Measured from the intersection of the chamfer insert and drill diameter, to the O.D. corner of the T-A[®] blade.



AMEC Wheel Drilling System

The tools shown in this literature represent only a few of the many designs being built for the aluminum wheel industry today. We will design to fit your requirements.

All tools are engineered, manufactured, and **QC certified** prior to shipment to assure they meet the high quality demands of the automotive wheel industry.

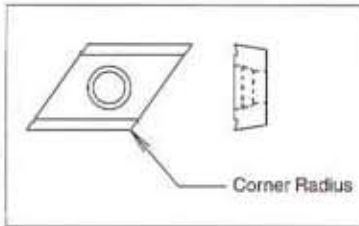
- ◆ The AMEC Wheel Drilling System is easily maintained by indexing inserts or replacing the T-A[®] blade.
- ◆ Hole configurations remain consistent without troublesome regrinding and resetting of the machine.
- ◆ High penetration rates.
- ◆ Lower cost per hole.

Valve Hole Drill Illustrated.

Accessories

1

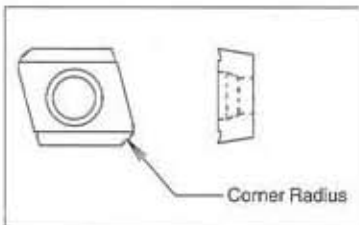
55° Diamond Inserts



Allied Item Number	Corner Radius
5191 - 0200	Sharp
5191 - 0202	0.016"
5191 - 0203	0.031"

2

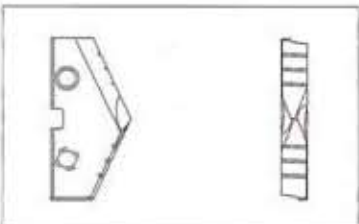
75° Diamond Inserts



Allied Item Number	Corner Radius
5051 - 0302	0.016"
5051 - 0303	0.031"
5051 - 0304	1 mm
5051 - 0305	1.5 mm
5051 - 0307	0.024"
5051 - 0308	2 mm
5051 - 0309	3 mm

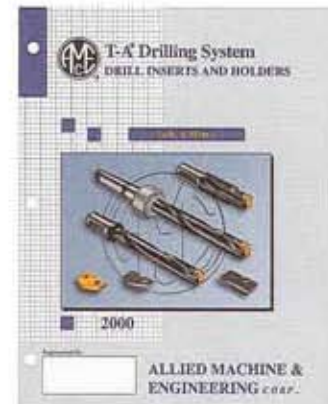
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T-A® Drill Inserts



TiN Coated Micro Grain Carbide
C-2 Grade (USA) and K-20 Grade (ISO)

For detailed T-A® Drill Insert information
check the T-A® Drilling System or
T-A® Metric Drilling System Catalogs.



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