



A BRAND AT-1



SNAPSHOT

BACKGROUND

An oil industry product manufacturer is looking to thread mill a 4140 L80 link lube assembly.

GOALS

Reduce cycle time to increase productivity.

DETAILS

INDUSTRY

Oil and Gas

PART

Link Lube Assembly

MATERIAL

4130 L80

MACHINE

YCM TV188B | Water Soluble 10%

SPINDLE

50 Taper

ORIGINAL TOOLING

Competitor Thread Mill
3/4-10 | 4 Flute | TiAlN

NEW TOOLING

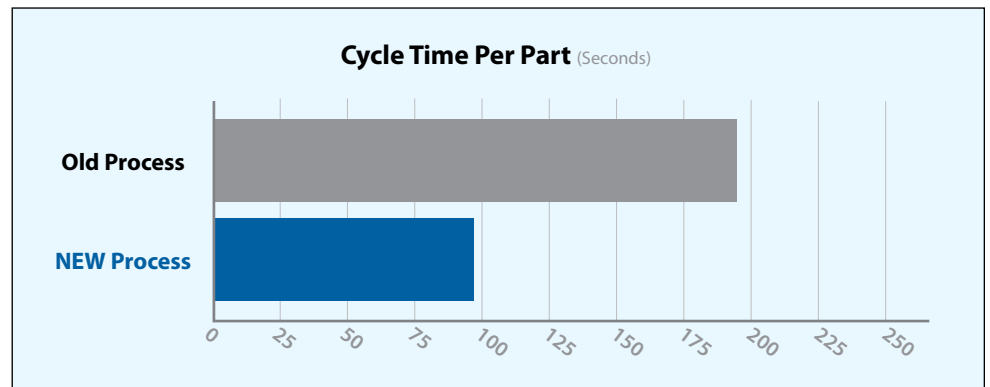
A Brand AT-1 Thread Mill
3/4-10 | 5 Flute | EgiAs

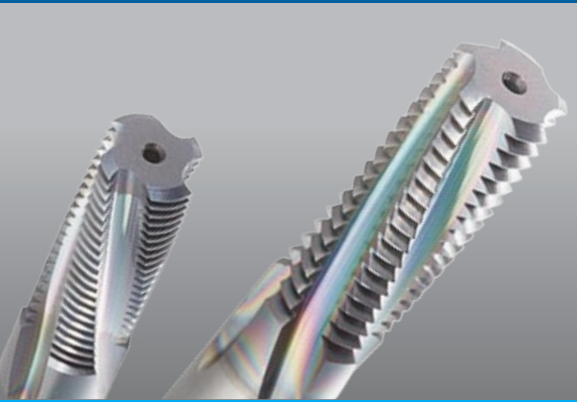
OVER \$50,000 ANNUAL SAVINGS!

THE STRATEGY

OSG was approached this opportunity by a customer who was using a conventional full length of cut thread mill. Due to the long thread the customer was experiencing longer than desired cycle times and deflection requiring multiple passes to achieve a quality thread. OSG proposed the A Brand AT-1 thread mill to take on the opportunity. The AT-1 is designed for single pass thread milling up to 45HRC with its patented left hand helix geometry.

	Original Process	NEW Process
Tool Diameter	3/4-10	
SFM	300	225
RPM	2,315	1,864
IPM	3.06	1.77
Number of Passes	3	1
Cycle Time (Seconds)	191	97





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THE RESULTS

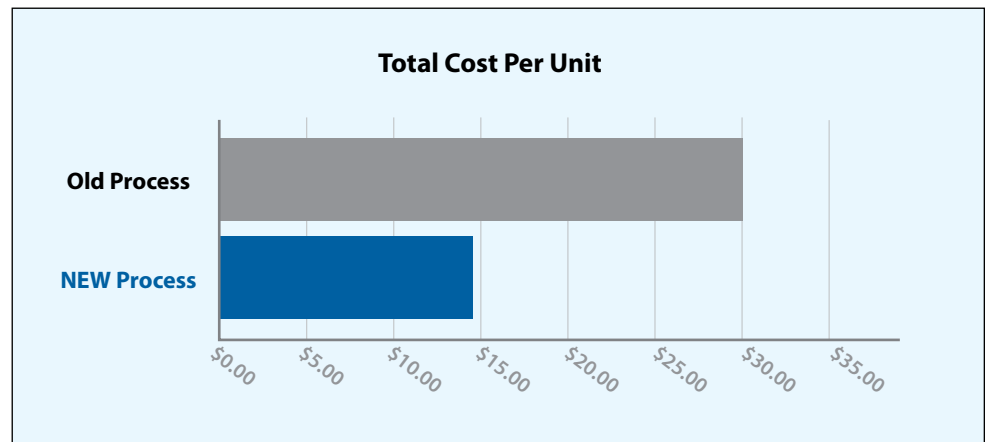
OSG was able to utilize 1 Pass thread milling with the A Brand AT-1 utilizing a thread mill feed rate compensation.

- Number of passes was reduced from **3 to 1**
- Part Production went from **80 to 200 per tool**.
- **Cycle time was reduced by 94 seconds per part!** (191sec to 97sec)
- **A total savings of \$50,635**

Results Overview	
Cycle Time Saved per Part (Seconds)	94
Number of Parts Per Year	3,600
Cycle Time Saved Annually (hours)	375.84
Cost to Machine (Per Hour)	120
Annual Mill Cost Savings	5,534
Total Machining Cost Saved Annually	\$50,635

THE CONCLUSION

Annual thread mill usage went from 45 to 18 with the OSG AT-1! This alone saves \$5,534.28 for a **total savings of \$50,635!**



OVER \$50,000 ANNUAL SAVINGS!



FIND OUT MORE

Click or scan for stock, features & benefits, videos and more! osgtool.com/at-1

