



A BRAND AT-2



SNAPSHOT

BACKGROUND

A die mold shop was struggling with long cycle times from EDM processing of threads in a 52HrC mold.

GOALS

The customer's primary request was cycle time reduction along with quality.

DETAILS

INDUSTRY

Die Mold

PART

Mold

MATERIAL

D2 (52 Hrc)

MACHINE

Makino

SPINDLE

CT40

ORIGINAL TOOLING

1/4-20 Electrode
0.25" | 0 Flute | -

NEW TOOLING

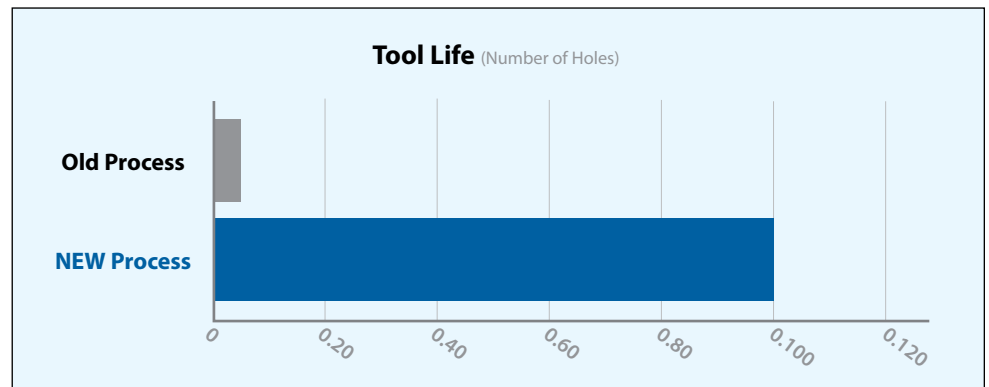
A Brand AT-1 Thread Mill
0.179" | 4 Flute | DUREY

OVER \$71,000 ANNUAL SAVINGS!

THE STRATEGY

OSG introduced the AT-2 thread mill to the customer. This tool is able to machine both the hole and thread simultaneously. Not only is this recommendation faster than EDM processing, but also faster than conventional drilling and tapping.

	Original Process	NEW Process
Tool Diameter (Inch)	0.25"	0.179"
Cutting Speed (RPM • SFM)	- • -	2,388 • 112
Feed (IPM)	-	4
Hole Depth (In)	0.5"	0.5"
Cycle Time (Minutes)	29.4	2.1
Tool Life (# of Holes)	5	100





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THE RESULTS

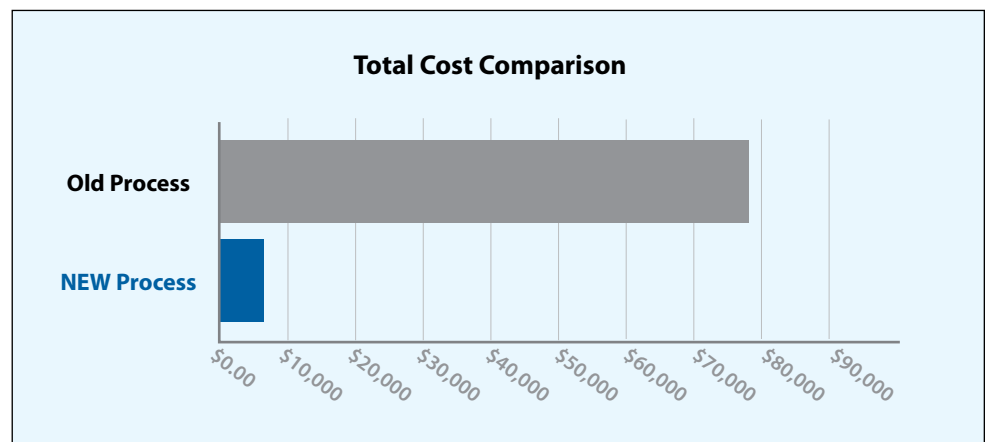
The following results were observed from testing the AT-2 thread mill. OSG was able to greatly reduce cycle time and increase tool life vs EDM processing.

- Cycle time was reduced from **29.4 min to 2.1 min per part!**
- Number of parts per tool was increased from 5 to 100.

Results Overview	
Cycle Time Saved Per Part (Minutes)	27.30
Number of Parts Per Year	2,000
Annual Cycle Time Saved (Minutes)	910
Annual Machine Cost Savings	\$68,250
Tool Life Productivity Improvement (%)	1900%
Annual Tool Change Cost Savings	\$2,375
Total Machining Cost Saved Annually	\$71,625

THE CONCLUSION

The customer was able to achieve their goal of improving cycle time. They were also able to benefit from a significant improvement of tool life. This combination of reduced cycle time and improved tool life led to **an overall cost savings of over \$71,000.**



OVER \$71,000 ANNUAL SAVINGS!



FIND OUT MORE

Click or scan for stock, features & benefits, videos and more! osgtool.com/at-2

