



A BRAND ADO



SNAPSHOT

BACKGROUND

A large aerospace manufacturer is having production pauses while drilling 40-45HRC Inconel 718 in a two-step process.

GOALS

Reduce cycle time, spindle load, and increase tool life utilizing 1 tool rather than 2.

DETAILS

INDUSTRY

Aerospace

PART

Pin

MATERIAL

Inconel 718 40-45HRC

MACHINE

Okuma | Water Soluble 10%

SPINDLE

CAT40 Mill Turn

ORIGINAL TOOLING

Competitor Replaceable Tip Drill 8D
0.625 | 2 Flute | TiAlCrSi Multi Layer

NEW TOOLING

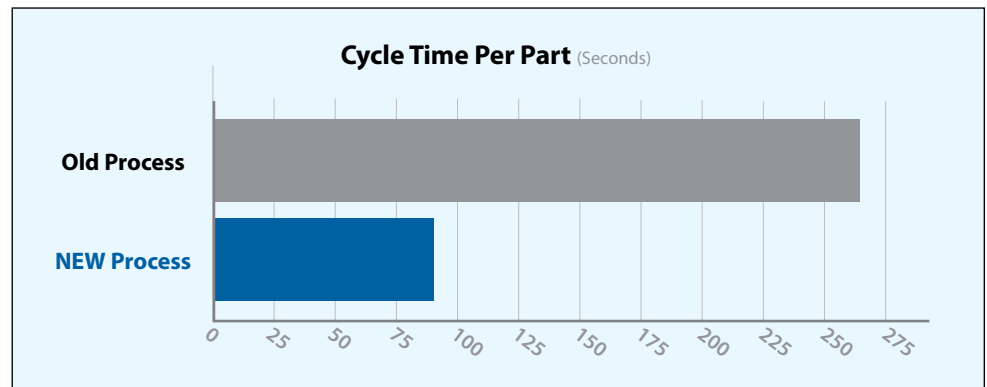
A Brand ADO 5D
0.625 | 2 Flute | EgiAs

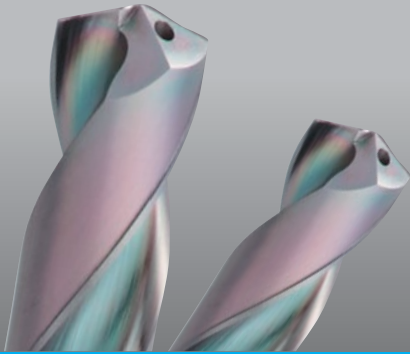
OVER \$27,000 ANNUAL SAVINGS!

THE STRATEGY

OSG brought in an A Brand ADO 5D drill to take on the opportunity. The self-centering technology of the OSG ADO allowed us to eliminate the spot drill reducing the number of tools for this application from 2 to 1. The ADO also features an R-Gash on its cutting edge. The R-Gash granted an acceptable spindle load for continuous machining with the ability to increase feed by a considerable margin.

| | Original Process | NEW Process |
|----------------------|------------------|-------------|
| Tool Diameter | 0.625 5D Drill | |
| SFM | 75 | |
| RPM | 458 | |
| IPM | 0.92 | 2.75 |
| Hole Depth | 4 | |
| Cycle Time (Seconds) | 263 | 89 |





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THE RESULTS

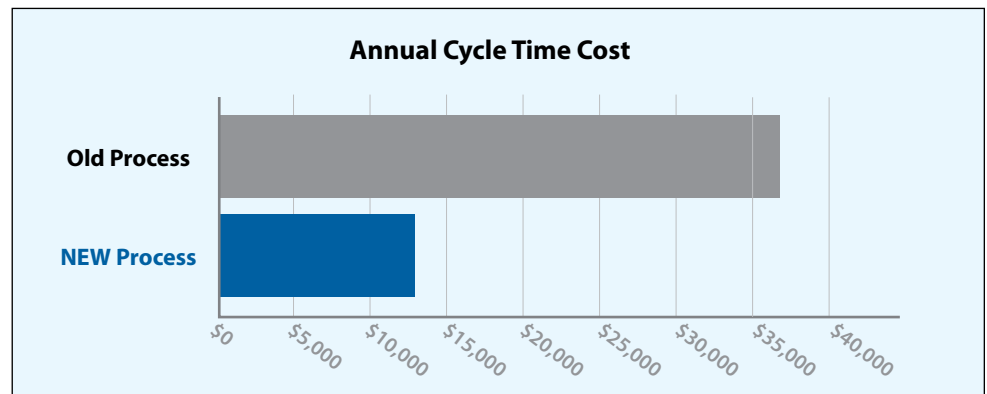
OSG was successful in increasing tool life and being more productive than the old process by reducing the tools required from 2 to 1 with the OSG A Brand ADO!

- Parts per drill increased from **5 to 16**.
- Cycle time was **reduced by 174 seconds per part!** (263sec to 89sec)
- Tools required **reduced from 2 to 1**.
- **A total savings of \$27,728**

| Results Overview | |
|--|-----------------|
| Cycle Time Saved per Part (Seconds) | 174 |
| Number of Parts Per Year | 4,000 |
| Cycle Time Saved Annually (hours) | 193.91 |
| Cost to Machine (Per Hour) | 125 |
| Annual Mill Cost Savings | 7,969 |
| Total Machining Cost Saved Annually | \$27,728 |

THE CONCLUSION

OSG was able to reduce drill usage from 800 to 250 utilizing the A Brand ADO! This alone **saves \$7,629 a year!**



OVER \$27,000 ANNUAL SAVINGS!



FIND OUT MORE

Click or scan for stock, features & benefits, videos and more! osgtool.com/a-brand-ado

