



## 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

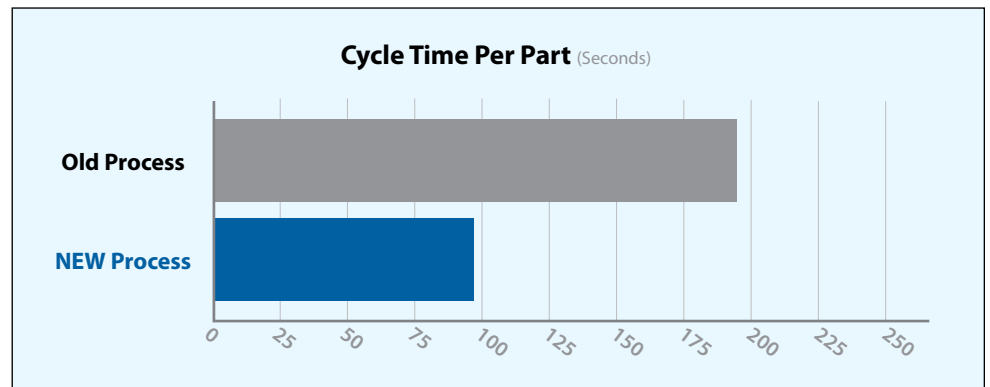
**A Brand AT-1 Thread Mill**  
3/4-10 | 5 Flute | EgiAs

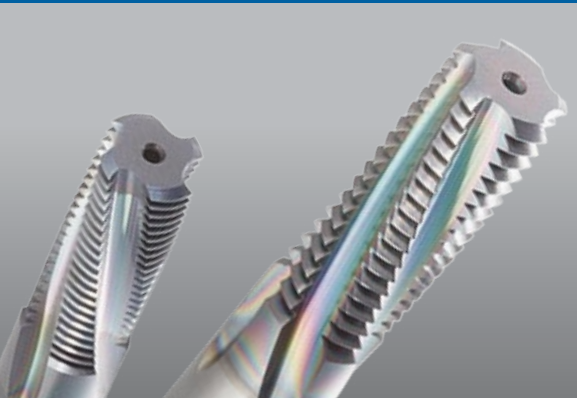
## OVER \$50,000 ANNUAL SAVINGS!

### 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	<b>225</b>
RPM	2,315	<b>1,864</b>
IPM	3.06	<b>1.77</b>
Number of Passes	3	<b>1</b>
Cycle Time (Seconds)	191	<b>97</b>





## 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 | TiAIN

#### NEW TOOLING

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

## THE RESULTS

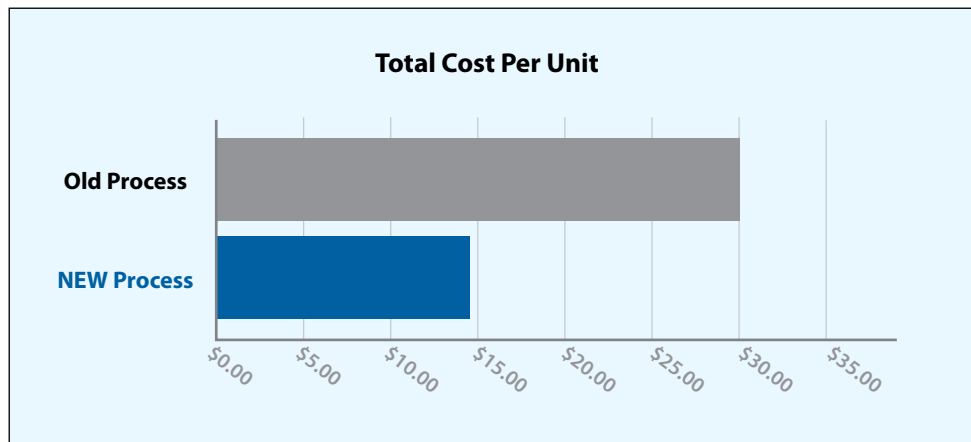
OSG was able to utilize 1 Pass thread milling with the A Brand AT-1 utilizing a thread mill feed rate compensation.

- 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)	<b>94</b>
Number of Parts Per Year	<b>3,600</b>
Cycle Time Saved Annually (hours)	<b>375.84</b>
Cost to Machine (Per Hour)	<b>120</b>
Annual Mill Cost Savings	<b>5,534</b>
<b>Total Machining Cost Saved Annually</b>	<b>\$50,635</b>

## 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](https://osgtool.com/at-1)

