

Real-Life Stories

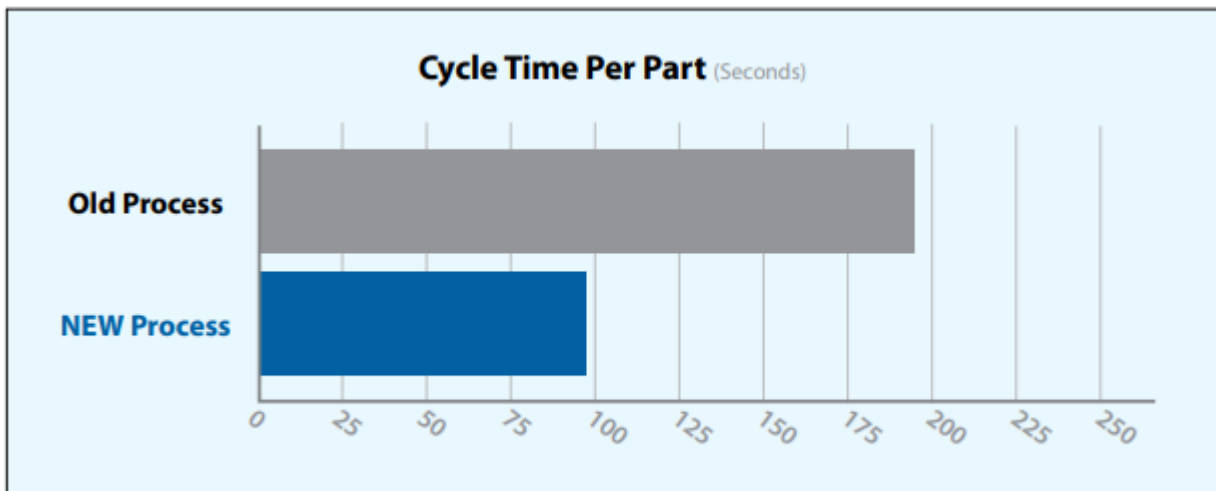
## Case Study: Bring Your A-Game with the OSG A Brand AT-1 Thread Mill

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### THE STRATEGY

OSG was approached for 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



## THE RESULTS

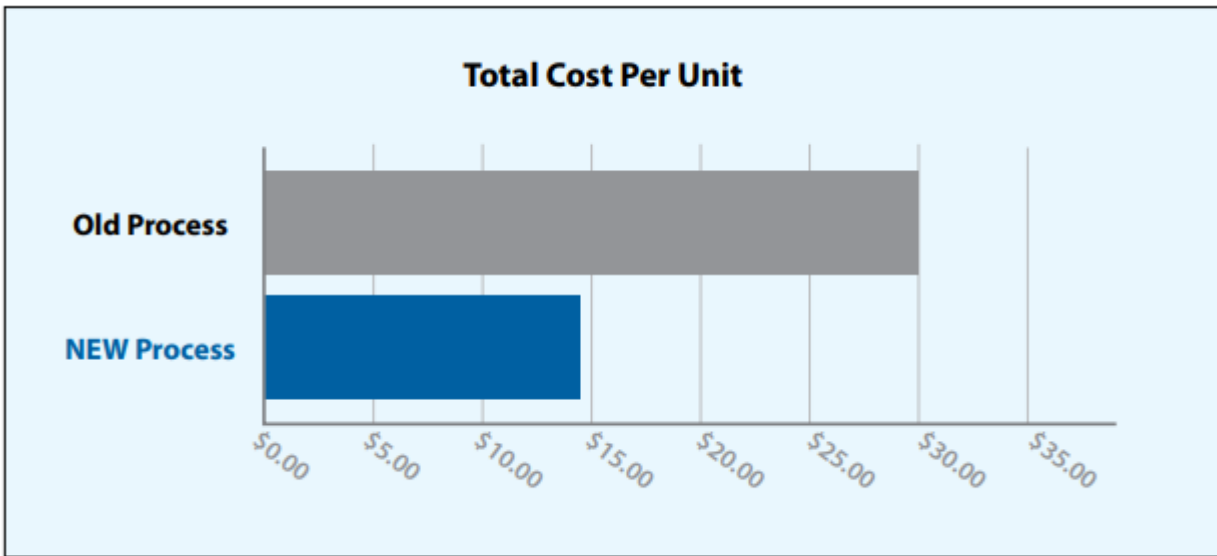
OSG was able to utilize one-pass thread milling with the A Brand AT-1 utilizing a thread mill feed rate compensation.

- 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
<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!**



*Previously Featured on OSG Tools' website.  
Download a PDF of the Case Study here.  
Browse MSCDirect.com to see the A Brand AT-1 thread mill.*

[www.mscdirect.com/betterMRO](http://www.mscdirect.com/betterMRO)

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