



AT-2 R-SPEC

新価格
体系
New Price
2022年8月

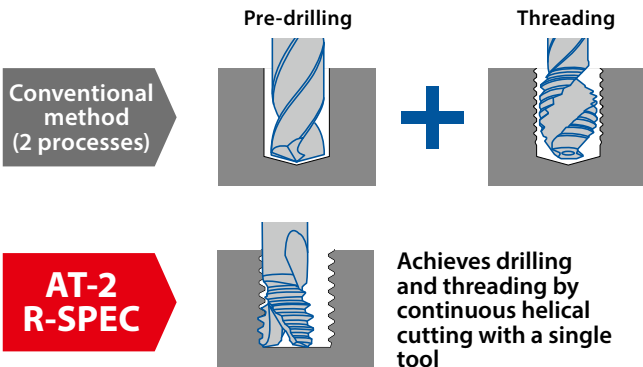


High-efficiency thread mill with end-cutting edge for non-ferrous metals

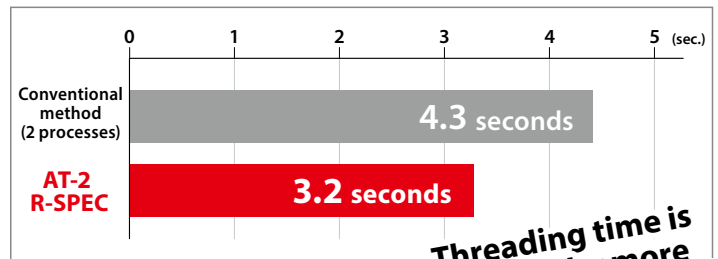
Super high-efficiency
threading

“ThreadRacer”

Threading time can be dramatically reduced!



Threading time comparison with conventional method (includes non-cutting time)



Threading time is reduced by more than **25%**!

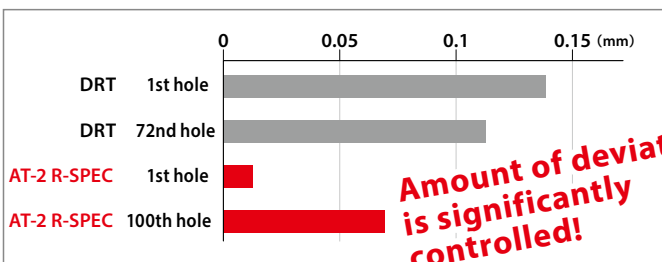
M6×1 Threading length 10mm ADC12 material
 Conventional drill : Vc=126m/min, f=0.6mm/rev
 Tap : Vc=94m/min (ATC: 1 time)
 AT-2 R-SPEC : Vc=220m/min, f=1.2mm/rev

Useful for preventing shifting of cutting position in cast hole!



Rough position settings and inclined nature of cast holes can cause position shifting in following processes...

Comparison of hole position accuracy with drill tap (DRT)



M8×1.25 Depth 18mm AC material
 Cutting test by shifting the axial center of $\phi 4.3$ pilot hole by 0.7 mm
 Drill tap : Vc=100m/min, f=1.25mm/rev
 AT-2 R-SPEC : Vc=220m/min, f=1.2mm/rev

Possible to thread with air-blow!

Q. Cutting oil sometimes cannot be used for machining aircraft and electrical parts...

A. Water-soluble coolant is generally recommended. However, air-blow can also be used when a pre-drilled hole is made to enhance chip separation and restrain welding of the DLC coating.

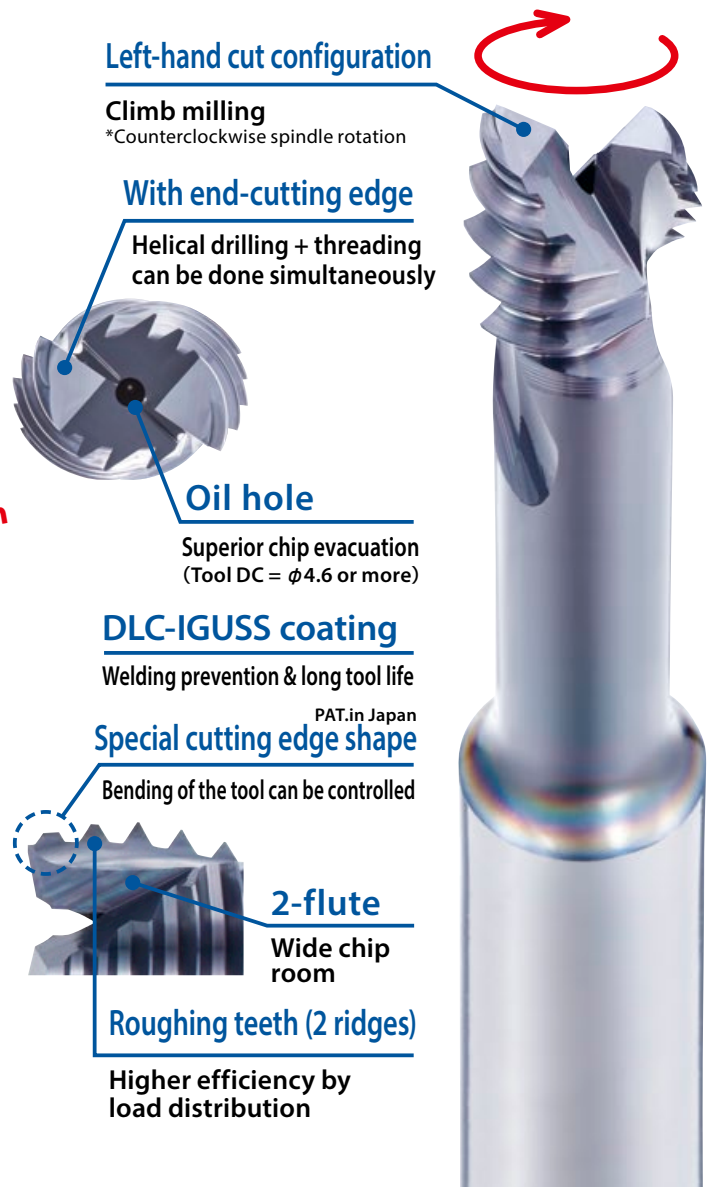
Left-hand cut configuration

Climb milling

*Counterclockwise spindle rotation

With end-cutting edge

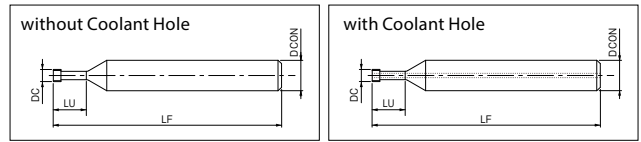
Helical drilling + threading can be done simultaneously



PAT.in Japan

Dimension

Cutting Thread Type	Material	Surface Treatment	Shank
Internal Thread	CARBIDE	DLC-IGUSS	SHANK h6



Effective thread 2 x D type

Unit:mm

EDP No.	Thread Size	DC	LF	Maximum threading length	LU	DCON	Flutes	Oil Hole	Stock	Price (Yen)
8331220	M 3 × 0.5	2.4	50	6	7.75	6	2	—	D	10,400
8331221	M 4 × 0.7	3.1	50	8	10.45	6	2	—		10,600
8331222	M 5 × 0.8	4	50	10	12.8	6	2	—		11,100
8331223	M 6 × 1	4.6	50	12	15.5	6	2	Yes		11,300
8331224	M 8 × 1.25	6.2	70	16	20.38	8	2	Yes		17,500
8331225	M 10 × 1.5	7.5	80	20	25.25	10	2	Yes		18,200
8331226	M 12 × 1.75	9	80	24	30.13	10	2	Yes		19,500

Effective thread 2.5 x D type

Unit:mm

EDP No.	Thread Size	DC	LF	Maximum threading length	LU	DCON	Flutes	Oil Hole	Stock	Price (Yen)
8331227	M 3 × 0.5	2.4	50	7.5	9.25	6	2	—	D	10,400
8331228	M 4 × 0.7	3.1	50	10	12.45	6	2	—		10,600
8331229	M 5 × 0.8	4	50	12.5	15.3	6	2	—		11,100
8331230	M 6 × 1	4.6	50	15	18.5	6	2	Yes		11,300
8331231	M 8 × 1.25	6.2	70	20	24.38	8	2	Yes		17,500
8331232	M 10 × 1.5	7.5	80	25	30.25	10	2	Yes		18,200
8331233	M 12 × 1.75	9	80	30	36.13	10	2	Yes		19,500

○=Limited standard stock item

Recommended cutting conditions



Use OSG's helpful NC code generator software "ThreadPro!"

Scan to access ▶



Work Material		Aluminum Alloy Casting			Wrought Aluminum Alloy · Magnesium Alloy			Copper Alloy											
Recommended Coolant		Water-Soluble			Water-Soluble			Water-Soluble											
Cutting Speed (m/min)		100 ~ 300			100 ~ 300			100 ~ 300											
Thread Size	DC	2 x D Type			2.5 x D Type			2 x D Type			2.5 x D Type								
		Speed (min ⁻¹)	Feed (mm/min)	Feed per Tooth (mm/t)	Speed (min ⁻¹)	Feed (mm/min)	Feed per Tooth (mm/t)	Speed (min ⁻¹)	Feed (mm/min)	Feed per Tooth (mm/t)	Speed (min ⁻¹)	Feed (mm/min)	Feed per Tooth (mm/t)						
M 3 × 0.5	2.4	13,263	1,592	0.3	13,263	1,592	0.3	13,263	159	0.03	13,263	159	0.03	13,263	159	0.03	13,263	159	0.03
M 4 × 0.7	3.1	14,375	1,941	0.3	14,375	1,941	0.3	14,375	194	0.03	14,375	194	0.03	14,375	194	0.03	14,375	194	0.03
M 5 × 0.8	4	15,915	1,910	0.3	12,732	1,528	0.3	15,915	255	0.04	12,732	204	0.04	15,915	255	0.04	12,732	204	0.04
M 6 × 1	4.6	15,224	2,842	0.4	11,072	2,067	0.4	15,224	284	0.04	11,072	207	0.04	15,224	284	0.04	11,072	207	0.04
M 8 × 1.25	6.2	12,322	2,218	0.4	8,214	1,479	0.4	12,322	277	0.05	8,214	185	0.05	12,322	277	0.05	8,214	185	0.05
M10 × 1.5	7.5	10,186	2,037	0.4	6,791	1,358	0.4	10,186	255	0.05	6,791	170	0.05	10,186	255	0.05	6,791	170	0.05
M12 × 1.75	9	8,488	1,698	0.4	5,659	1,132	0.4	8,488	212	0.05	5,659	141	0.05	8,488	212	0.05	5,659	141	0.05

- AT-2 R-SPEC is only for milling internal threads.
- Please select "continuous" for the path type in ThreadPro.
- The cutting conditions initially displayed in ThreadPro are reference values. Before use, please adjust the cutting conditions according to the recommended cutting condition table as well as the actual machining environment, such as the rigidity of machine, tool holder and workpiece clamping.
- Tool vibrations should be kept at a minimum level for maximum accuracy.
- When machining magnesium alloy materials, please use the coolant oil recommended by the coolant oil manufacturer. Please also properly dispose the cutting chips to prevent fire hazards.
- Spindle rotation must be counterclockwise due to the left-hand cut configuration.

Note

Bottom shape of finished hole is as depicted in the right picture. Please make sure that it is acceptable based on the cutting instruction in advance.



OSG Corporation

Headquarters
3-22 Honnogahara, Toyokawa-City, Aichi 442-8543, Japan
TEL : +81-533-82-1118 FAX : +81-533-82-1136
E-mail : cs-info@osg.co.jp Web : https://www.osg.co.jp/

Central Japan Sales Division
1-9 Kifune, Meito-ku, Nagoya-City, Aichi 465-0058, Japan
TEL : +81-52-703-6131 FAX : +81-52-703-7775

Eastern Japan Sales Division
Shinagawa Seaside Canal Tower 19F, 4-12-6 Higashi
Shinagawa, Shinagawa-ku, Tokyo 140-0002, Japan
TEL : +81-3-5715-2966 FAX : +81-3-5460-2966

Western Japan Sales Division
NaniwasuziSIA Bldg. #405, 2-4-2, Shin-machi, Nishi-ku,
Osaka-City, Osaka 550-0013, Japan
TEL : +81-6-6538-3880 FAX : +81-6-6538-3879