



Where **high performance**
is the **standard**[®]

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Company Overview

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Customer Service

and Tech Support :

email: sales@maford.com
Ph: 800-553-8024/
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For 100 years, M.A. Ford[®] has been at the cutting edge of tooling design and manufacturing and has developed an enviable global reputation for performance and precision in advanced solid carbide tooling, serving over 60 countries world wide. Our innovative cutting geometries, materials and coating technologies are providing effective manufacturing solutions to an expanding and increasingly diverse range of industries.

Target Industries:

Aerospace
Medical
Firearms
Automotive
Heavy Machinery
Energy
Electronics
Agriculture

Competitors

Kyocera SGS
Seco
Imco
Fullerton
Mitsubishi
Sumitomo
Harvey Tool
Widia

Key Product Lines

- High Performance Solid Carbide End Mills
- High Performance Solid Carbide Drills
- Solid Carbide Reamers
- Solid Carbide Diamond Grind Routers
- Solid Carbide Custom Tools
- Solid Carbide and HSS Countersinks
- Solid Carbide General Purpose End Mills
- Solid Carbide General Purpose Drills
- Solid Carbide Burs
- Solid Carbide Micro Tools
- Re-Conditioning and Re-Coating

M.A. Ford Rapid Turnaround Program*

Coating

ALtima[®] 3 days No maximum quantity
Blaze, TiN, TiCN 3 days No maximum quantity

Range Reamers

270 Series 3 days 25 piece maximum

Shank Flats

End mills 3 days 50 piece maximum

Corner Radius

End mills – 6mm & above 3 days 12 piece maximum

Depth Setting Rings 3 days No maximum quantity

Coolant Slots 3 days 10 piece maximum

Micro-Stop Integral Pilot 3 days 10 piece maximum

*When base tool in stock

Custom Tool Division

M.A. Ford's Custom Tool Division offers application development, design and manufacturing expertise in the following product classifications in either solid or coolant thru configurations:

- High Performance Drills and Step Drills
- Rockbit Drills (Flat Bottom - 150°)
- G-Drills and Step G-Drills
- Step Reamers
- Reamers
- Coolant Thru Specials
- Firearms Reamers (Chamber-Barrel-Muzzle-Throat)
- Custom End Mills
- Custom Form Tools
- Re-conditioning and Re-Coating



**ISO 9001:2015
Certified**

Returns: No returns will be accepted without a prior written Return Materials Authorization (RMA) from M. A. Ford. Please contact our Customer Service department for an authorization number and shipping instructions. Merchandise that has been approved for return must be returned on a pre-paid basis in original packaging.

Miscellaneous Return Restocking Charges:

Miscellaneous returns are subject to the following restocking fees:

- Purchased within 30 days, 5%
- 31-180 days, 10%
- 6 months – 1 year, 15%
- No miscellaneous returns for materials purchased beyond 1 year (Contact Customer Service for Stock Rotation Option), except series 239. For series 239, no returns are accepted for materials purchased beyond 90 days.

All Returns Are Subject To The Following Conditions:

- Returned items must be current M.A. Ford products per the current price schedule.
- Standard products that are scheduled to be removed from the catalog and/or slow moving items are subject to review and may not be eligible for return.
- Damaged product packaging, marked/defaced labels and/or packages are not eligible for return.
- Products that have been altered or coated by a third-party are not eligible for return.
- Returned products must be properly packaged for shipment with the RMA number indicated on the shipment and noted on the return goods documentation. Any carrier damage is the responsibility of the Distributor.

To Request A Sample Tool

The Test Tool Request Form is available at maford.com/page/forms. Follow the instructions on the bottom of the form to fax or email to M.A. Ford Customer Service. Once approved, the tool will ship same day if in stock.

M.A. Ford® Direct Field Sales Staff

Title	Name	City/State	Cell	E-mail
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Order Entry and Shipping Cutoff Times
 Orders received by 5:00pm CST in stock **shipped via UPS** same day
 For Fed Ex shipments:

- Cutoff time is 4:30pm CST for priority shipments
- Cutoff time 3:30pm CST for ground shipments

Test Tool Results Example

This test of the M.A. Ford series 277 was a big improvement for Company A as the current indexable tool would only produce 200 parts before chipping out. The M.A. Ford Tool ran 3,000 pcs between tool changes. The insert usage cost of \$23,400.00 must be added for the special Competitor A tool body usage of 52 pcs. annually. **Total savings \$137,591.00.**

Select Machining Type		Solid Milling		Color On	Color Off	Test Date	03/24/17
Select Data Entry Units		Inch		Metric	Output Units	Inch Metric	
Company		Contact		Test Objective		Tool Life	
Salesman		Distributor		Material		1/4" Ratchet lever bore	
Evaluater		Machine		Hardness (HRC)		<250 BHN	
Machine #		Machine		Surface Condition		Milled	
Rated Power (HP)		Machine #		Solid Mill Material Factor		1.28	
Tool Number		Existing		Mill type: climb		Interpolation	
Tool Brand Name		Competitor A		Test 1		Test 2	
Endmill Description		AOMT040204-900DT		MA Ford 27737512B			
		IC 908		3/8" X 7/8" X 2.5" .015			
# EffectiveTeeth		2		4			
Tool Diameter (in)		0.375		0.375			
RPM (at max RPM)		5240		5240			
Speed (sfm)		514		514			
Feed (ipr)		0.0005		0.0030			
Feed (mm/min)		5.03		62.58			
Width of Cut (in.)		0.020		0.020			
Depth of Cut (in.)		0.3		0.3			
Length of Cut (in.)		0.95		0.95			
# of Passes		Per Part		1			
Type of Chip Produced ?		Segmented		Tubular			
Coolant		SYNTHETIC		SYNTHETIC		SYNTHETIC	
Power @ Spindle (KW)		0.02		0.22			
# of Parts		Per Mill Chg.		66		3000	
# of Parts		Per Regrind		0		0	
Mill Chg. Time (Seconds)		1800		120			
Linear Distance /Mill Chg (mm.)		2,100		7,647			
Reason for Indexing		CHIPPING		NORMAL WEAR			
Tool Life Increase		4445%					
Annual Part Production		150,000					
Cycle Time		per part (sec)		21.00		0.90	
Cut Time		per part (sec)		287.81		23.02	
Removal Rate (mm3 /min)		494.60		6182.51			
Productivity Increase		1150%					
Annual Machine Time Savings (hours)		11032.7					
Burden Rate (hour)		\$45.00		Not Required		Not Required	
Cutter Cost		\$12.00		\$31.16			
RegrindCost (For Grindable)		\$0.00		\$0.00			
Number of Regrinds Per Tool		0		0			
Tool Chg. Cost Per Tool Chg.		\$22.50		\$1.50			
Tooling Cost Per Mill Change							
Est. Annual Mill Usage		2250		50			
Estimated Annual Mill Cost		\$27,000.00		\$1,558.00			
See Line Headers		\$ Per Part		\$ Per Part		Savings (Yr)	
Tooling Cost --		\$0.180		\$0.010		\$25,442	
Tool Change Cost		\$0.341		\$0.001		\$51,061	
Cutting Time Cost		\$3.598		\$0.288		\$496,472	
Other Cycle Time Costs		-\$3.335		-\$0.277		(\$458,785)	
Costing Summary		\$0.78		\$0.02		\$114,191	
Assessments		Objective Attained?		Yes No		Retest? No Yes	

This test was a big improvement for end user as the current Indexable tool would only produce @ 200 parts before chipping out. The MA Ford Tool will run 3000 pcs between tool changes. The numbers on this Report are more accurate in calculating the overall savings with the actual annual production adjusted to the correct production of 1/4" Lever ratchets produced. The other reports were skewed on Part production as the number of inserts used annually with a 200 pc. production rate per tool change had to be considered. Due to the chipping and Failure of the Competitor A tool this is a more accurate report with the burden rate as the actual insert usage is 66 per tool change for this production. 23,400.00 must be added for the special Competitor A tool body usage of 52 pcs. annually. Total savings 137,591.00

M.A. Ford Test Winners To Try:

239 Series Diamond Grd/Diamond Coated Router for Composites

278 Series 5 FL HP End Mill for Titanium, Inconel and similar materials

180 Series 7 FL HP End Mill for Titanium, Inconel, Nickel Alloys and similar materials

CDA Series HP Drill for Aluminum and similar materials

CXD Series HP Drill for Titanium and similar materials