

Introduction

Efficiency equals profit.

In this competitive climate, identifying ways to be more efficient is the best way to decrease your bottom line. This application note will discuss the productivity benefits of 5-sided machining and 5-axis machining.

Details

Think first. Do second.

There are several steps to approach machining a part. This application note will compare examples to help you determine best practices. This application note will also explain control software features that increase productivity when machining complex parts.

PROBLEM: One often finds sales, reduced turnover and more.

SOLUTION 1: Evaluate the way you approach the part.

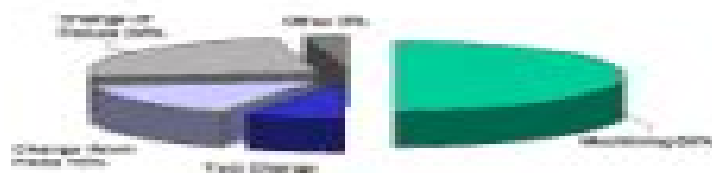
Example: One customer reduced their lead time by two weeks by machining the part from a billet instead of a casting. Machining a part from a billet eliminates the machine stock finished parts, eliminates delays due to lead times for castings, and eliminates the cost of finishing castings and the labor costs associated with handling them.

SOLUTION 2: Spend money to make money Upgrade your equipment.

Example: Investing in a machine with lower feed rates and more torque can significantly increase cycle time. Old machine: 9 hours. New machine: 1 hour (90 minutes).

SOLUTION 3: Machine design affects efficiency.

The discussed cycle time our customer experienced in Solution 2 was due in part to the horizontal orientation of the part because it allowed the chips to fall away from the part which made it possible to run a 3-inch diameter at 4500 spm to rough out the part.



Capacity Chart

Data from American Mold Builders Association

SOLUTION 4: Reduce the number of times you have to flip the part.

The Capacity Chart shows that 99% of a job's capacity is spent on fixturing. Although using an index table is preferred over using a row of vices that requires you to flip each part into the next vice, there are limitations to an index table solution (e.g., each time you handle the part to re-fixturing it, you spend time lowering all fixturing, unclamping the part, raising all the vices, and clamping the part into the next. Therefore, a pallet change system is often preferred because it keeps the spindle rotating.

Evaluate the job. Number of parts and number of tool changes. Even though the Capacity Chart shows tool change at only 1%, tool change optimization may provide sufficient time savings if you have multiple tool changes. Consider at what number of parts does it make sense to use time to set up another fixture on a pallet and locate that part versus flipping a part in a vice.

Microcut Mill Operation Manual

S Ben Porath



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Table of Contents Microcut Mill Operation Manual

1. Understanding the eBook Microcut Mill Operation Manual
 - The Rise of Digital Reading Microcut Mill Operation Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Microcut Mill Operation Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Microcut Mill Operation Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Microcut Mill Operation Manual
 - Personalized Recommendations
 - Microcut Mill Operation Manual User Reviews and Ratings
 - Microcut Mill Operation Manual and Bestseller Lists
5. Accessing Microcut Mill Operation Manual Free and Paid eBooks

- Microcut Mill Operation Manual Public Domain eBooks
- Microcut Mill Operation Manual eBook Subscription Services
- Microcut Mill Operation Manual Budget-Friendly Options
- 6. Navigating Microcut Mill Operation Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Microcut Mill Operation Manual Compatibility with Devices
 - Microcut Mill Operation Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Microcut Mill Operation Manual
 - Highlighting and Note-Taking Microcut Mill Operation Manual
 - Interactive Elements Microcut Mill Operation Manual
- 8. Staying Engaged with Microcut Mill Operation Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Microcut Mill Operation Manual
- 9. Balancing eBooks and Physical Books Microcut Mill Operation Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Microcut Mill Operation Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Microcut Mill Operation Manual
 - Setting Reading Goals Microcut Mill Operation Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Microcut Mill Operation Manual
 - Fact-Checking eBook Content of Microcut Mill Operation Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development

- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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