

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.

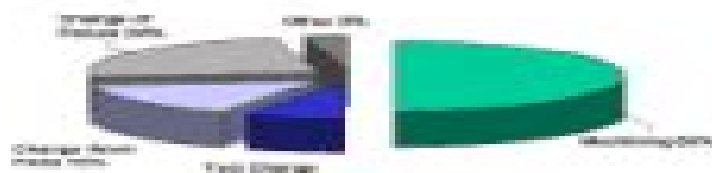
Example: One customer reduced their lead time by two weeks by machining the part from a billet instead of a casting. Machining a part from a billet eliminates the entire stock finished parts, eliminates delays due to lead times for castings, and eliminates the cost of finishing castings and the labor 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 endmill 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 finishing. 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-fixtue it, you spend time blowing off the chips, unclamping the part, wiping off the vice, 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

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Process Planning for Micro-milling in Microfluidic Device Fabrication Jeffrey R. Hartnett, 2007 **Computer Aided Manufacturing** C. Elanchezhian, G. Shanmuga Sundar, 2007 **Thomas Register of American Manufacturers**, 2002

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