

PRECI-FLEX® : THE FACTS SPEAK FOR THEMSELVES



PART:	Coupling
MATERIAL:	14CrNi14
BATCH SIZE:	400
MACHINE CONFIGUR.	Two Spindle Four Turret
MACHINE - COST PER MINUTE	\$2.20

PERFORMANCE DATA

STANDARD TOOLHOLDERSYSTEM	PRECI-FLEX® TOOLING SYSTEM
<p>SET UP TIME: 460 Min Installation of Toolholders, alignment to spindle, machining and measuring until first part correspond to drawing</p>	<p>SET UP TIME: 70 Min Installation of adapters externally presetted, machining and measuring of first part</p>
<p>MACHINING TIME: 3.27 Min per Part</p>	<p>MACHINING TIME: 2.98 Min per Part</p>
<p>LIFE TIME OF CUTTING TOOLS: 100 %</p>	<p>LIFE TIME OF CUTTING TOOLS: 155 %</p>
<p>COST OF CUTTING TOOLS: 476 \$</p>	<p>COST OF CUTTING TOOLS: 214 \$</p>
<p>PRODUCTION INTERRUPTIONS: 170 Min Exchange of worn out tools, correction of data, quality control</p>	<p>PRODUCTION INTERRUPTIONS: 35 Min Exchange of tools, correction of data, quality control</p>

COST-SAVING



* SET UP TIME	833 \$
* MACHINING TIME	247 \$
* CUTTING TOOL CONSUMPTION	263 \$
* PRODUCTION INTERRUPTION	288 \$

TOTAL COST-SAVING:

1631 \$ = 36 %

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PART:	Housing
MATERIAL:	16MnCr5
BATCH SIZE:	120
MACHINE CONFIGUR.	One Spindle One Turret
MACHINE - COST PER MINUTE	\$1.00

PERFORMANCE DATA

STANDARD TOOLHOLDERSYSTEM	PRECI-FLEX® TOOLING SYSTEM
<p>SET UP TIME: 270 Min Installation of Toolholders, alignment to spindle, machining and measuring until first part correspond to drawing</p>	<p>SET UP TIME: 80 Min Installation of adapters externally presetted, machining and measuring of first part</p>
<p>MACHINING TIME: 11.3 Min per Part</p>	<p>MACHINING TIME: 11.1 Min per Part</p>
<p>LIFE TIME OF CUTTING TOOLS: 100 %</p>	<p>LIFE TIME OF CUTTING TOOLS: 108 %</p>
<p>COST OF CUTTING TOOLS: 270 \$</p>	<p>COST OF CUTTING TOOLS: 251 \$</p>
<p>PRODUCTION INTERRUPTIONS: 185 Min Exchange of worn out tools, correction of data, quality control</p>	<p>PRODUCTION INTERRUPTIONS: 24 Min Exchange of tools, correction of data, quality control</p>

COST-SAVING



* SET UP TIME	183 \$
* MACHINING TIME	23 \$
* CUTTING TOOL CONSUMPTION	19 \$
* PRODUCTION INTERRUPTION	154 \$

TOTAL COST-SAVING:

380 \$ = 19 %

PRECI-FLEX® : THE FACTS SPEAK FOR THEMSELVES



PART:	Shaft
MATERIAL:	Densimet
BATCH SIZE:	40
MACHINE CONFIGUR.	Two Spindle Two Turret
MACHINE - COST PER MINUTE	\$1.53

PERFORMANCE DATA

STANDARD TOOLHOLDERSYSTEM	PRECI-FLEX® TOOLING SYSTEM
SET UP TIME: 220 Min Installation of Toolholders, alignment to spindle, machining and measuring until first part correspond to drawing	SET UP TIME: 35 Min Installation of adapters externally presetted, machining and measuring of first part
MACHINING TIME: 6.42 Min per Part	MACHINING TIME: 5.46 Min per Part
LIFE TIME OF CUTTING TOOLS: 100 %	LIFE TIME OF CUTTING TOOLS: 170 %
COST OF CUTTING TOOLS: 373 \$	COST OF CUTTING TOOLS: 112 \$
PRODUCTION INTERRUPTIONS: 140 Min Exchange of worn out tools, correction of data, quality control	PRODUCTION INTERRUPTIONS: 20 Min Exchange of tools, correction of data, quality control

COST-SAVING



* SET UP TIME	276 \$
* MACHINING TIME	57 \$
* CUTTING TOOL CONSUMPTION	261 \$
* PRODUCTION INTERRUPTION	139 \$

TOTAL COST-SAVING:

773 \$ = 59 %