

ThriftChange® - Case Study

The following represents a case study of how Peterson's Thrift® line of products decreased set-up time, increased part through put and reduced scrap for a large automotive industry customer.

Facts/Former Process

- 32 parts running across 4 machines
- Machines - Acme 1 ¼" - 8 w/Acro Feed
- Attachment - Acme Form Holders & Slitters Shave Fixture
- Tooling - Solid High Speed Dovetail
- Part Type - Shafts
- Stock Size Range - ½" diameter thru ¾" diameter
- Material - 1215
- Machine Set-Ups - Averaged 1.6 changeovers each machine per week at 8
- Tooling Positions
 - 8th Position Feed out
 - 1st Position Knee Turn/ Form
 - 2nd Position Form
 - 3rd Position Shave
 - 4th Position Thread
 - 5th Position Shave
 - 6th Position Thread
 - 7th Position Cut-off

Manufacturing Issues

- Change-over Time 8 hours
- Real Machine Efficiency at 74.3%
- 96% of Scrapped Parts Due to Threading Issues
- Poor On-Time Delivery
- Product Containment

Revised Peterson Process

- Machines - Acme 1 ¼" - 8 w/Acro Feed
- Tooling - Peterson-Type Insert Tooling
- Attachment - Peterson ThriftForm® & ThriftShave® Attachment

Results

Set-up Time Reduction

ThriftChange® Tooling Package reduced change-over time from 8 hours to 2 hours. Change-over time reduction allowed production to drastically improve their on-time delivery for their customer.

Improved Machine Efficiency

The customer is currently running at a real time efficiency of 96.1%. This improvement has provided an increase of 25,328 pieces. The manufacturer can now better manage the production requirements against his customer's demands.

Tooling Cost

Peterson Insert Tooling provided an 8.4 % reduction in the straight tooling cost on the form tools and shave tools annualized over the 1st year (does not include re-sharpening cost).

The tool saving was an unplanned cost savings which provided additional departmental cost improvements.

ThriftShave® Attachment

The addition of the ThriftShave® resulted in a 95% reduction in scrap due to diameter and taper variation and an annualized cost reduction of 23% on the thread tooling. While the scrap reduction was factored into the cost savings, the 95% far exceed their planned savings. Their customer removed the containment requirement which provide a substantial savings. The thread tooling cost was another unplanned additional savings.

To find out more information and to explore how the Peterson Tool team can assist you with your manufacturing challenges call us at (615) 242-7341 or fill out the "Get a Quote" form at our web site (www.PetersonTool.com).