

Customer Profile:

Midwest Machining Solutions is a provider of the highest quality machining, manufacturing, production, repair, and assembly services. In addition, MMS also offers its own fabrication department to provide its customers with a one-stop solution for all machining and fabricating needs.

Steiner solutions delivers \$29,858.50 in annualized production cost savings.

Autofacer®

- Back spotfacing
- Hydraulic cylinder
- Lean process
- Cost reduction
- Quick delivery
- Engineered tooling
- Engineered solutions
- Improved cycle times



Midwest Case Study: Midwest Machining Solutions Saves 240 hrs With The Steiner Autofacer

The Challenge

Eliminate the unsafe and time-consuming secondary operation in a very difficult, heavily interrupted reverse counter bore application while lowering the cost per part.

Application Details

3,600 holes annually - Ø1.024 reverse counterbore, .689 hole diameter and heavily interrupted cut. Material was HRS Steel. Currently using two-piece style back boring tool.

The Solution

A fully automatic and mechanically activated Inertia Style Autofacer from Steiner Technologies utilizes the machine's spindle inertia to open and close the cutting blade. The CNC machine used was a Doosan 4020 vertical mill running at 250 SFPM with a feed rate of .0031 IPR.

The Results

By switching from the two-piece tool system to the Steiner Autofacer, cutting time per counter bore was reduced from 4.6 minutes to 30 seconds, and total operation time from 2.6 hours to 18 minutes (36 holes per part). Total cycle time reduction equaled 89%.

Additional Benefits

- Operator Safety: Operator no longer needs to climb in & out of the machine to attach cutter head.
- Scrap Rate reduction: No operator error of forgetting to remove the cutter head on two-piece style tool.
- Tool & Part Safety: Unique to the Steiner Autofacer, tool is equipped with perishable shear pin to provide protection from tool overload.

Randy Travers, Shop Foreman of Midwest Machining Solutions, stated, "The Steiner Autofacer delivered on what it promised and then some."

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