



Case Study

Midwest Machining Solutions Saves 240 hrs With The Obtuz Autofacer

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 customer with a one-stop solution for all machining and fabricating needs.

Application Details:

3,600 holes annually— $\varnothing 1.024$ reverse counterbore, .68g hole diameter and heavily interrupted cut. Material was HRS steel. Currently using a two-piece style back boring tool.

The Obtuz Solutions:

A fully automatic and mechanically activated Inertia style Autofacer from Obtuz 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 .0034 IPR.

The Results:

By switching from the two-piece tool system to the Obtuz Autofacer, cutting time per counter bore was reduced from 4.6 minutes to 30 seconds, and total operation time from 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 and 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 Obtuz Autofacer, tool is equipped with perishable shear pin to provide protection from tool overload.

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

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