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Solving Metal Die- Casting
Water Problems



Methods' JobShop Cell
Resolves Production
Hiccups for Third
Generation Machinist

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PG 4	Methods' JobShop Cell Resolves Production Hiccups for Third Generation Machinist
PG 12	A "Cool" Story About Solving Metal Die-Casting Water Problems
PG 20	Ad Index



Pg 4

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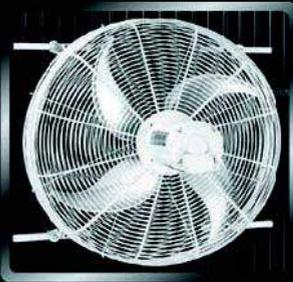
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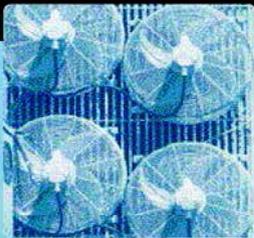
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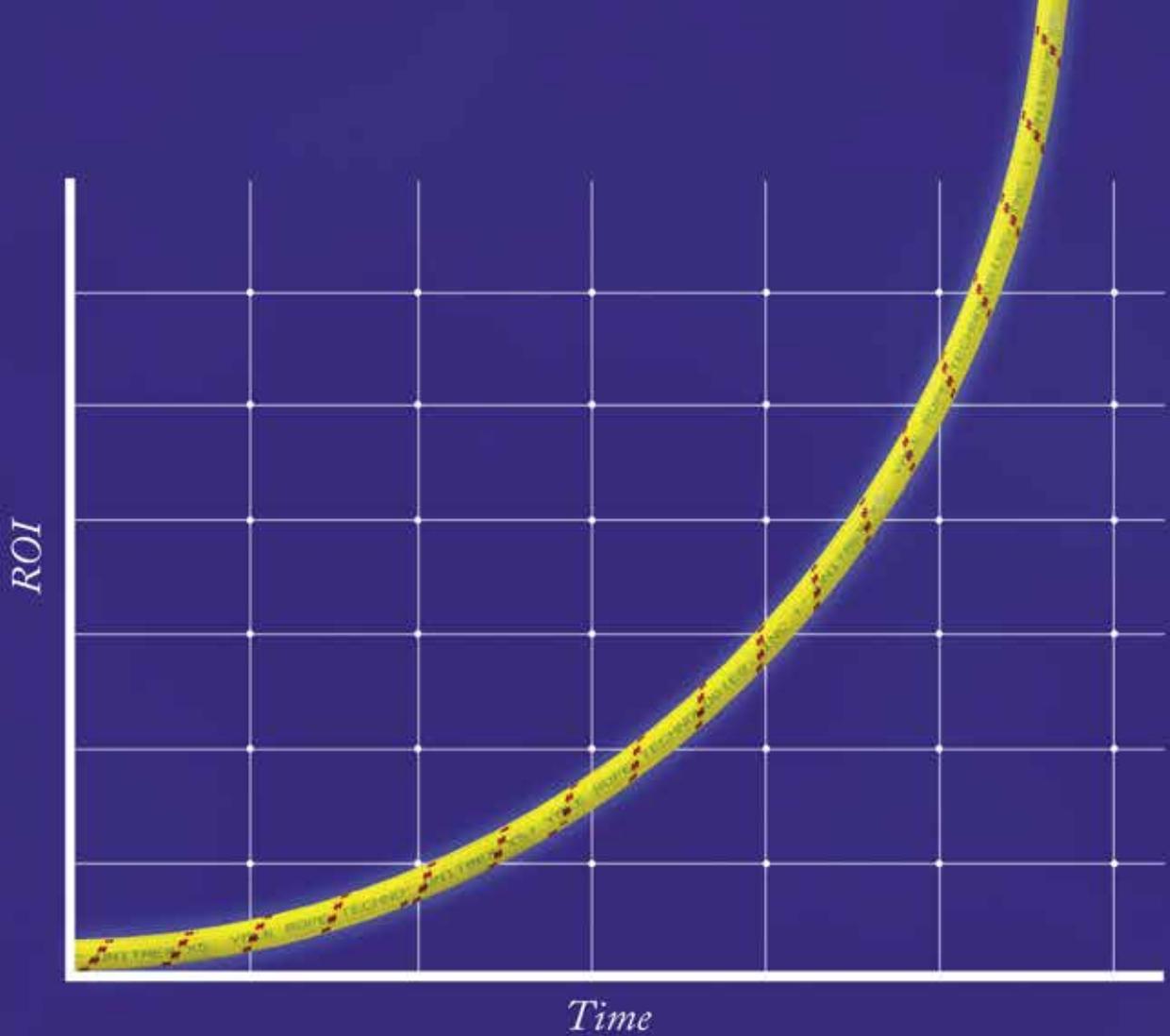


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Methods' JobShop Cell Resolves Production Hiccups for Third Generation Machinist



Evan Jones has a passion for machining. So much so, he practically has coolant coursing through his veins. His grandfather started Humboldt Instrument with a partner in San Leandro, Calif., and Jones spent his teenage years at his father's "mom and pop" machine shop, Humboldt Northwest, in Oregon. By his early 20s, Jones realized machining was more than just a job or career path. "Machining became a lifetime endeavor," he said.

Jones built up an immense knowledge base, racking of hours upon hours of spindle time. He learned the best machining practices, managed customer relationships, and gained tremendous insight into running a successful CNC shop.

By the time he opened up his shop, 3rd Gen Machine of Logan, Utah, he was spending every waking minute mulling over cutting theories, tools, and the most efficient way to tackle a job.

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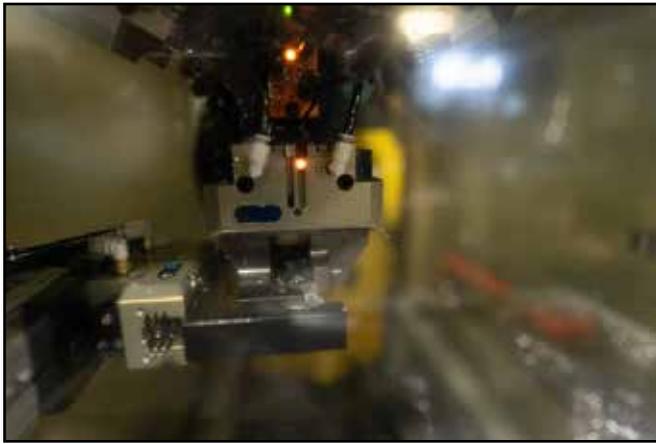
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One of the critical ingredients in that recipe is high-quality CNC machines.

“Being a machine shop owner, my passion is equipment,” he said. “So that’s what gets us excited, looking into possibilities with how you can serve customers better, it’s all about quality, runtime, and productivity.”

Jones is a forward-thinking machine shop owner. So when 3rd Gen Machine was running into production issues, he took action. Chip imprint scratches were causing his scrap rate to rise. His throughput wasn’t where he wanted it to be. The constant loading and unloading of raw materials and finished goods were taking a toll.

The final straw came in the form of a spindle crash.

“That day, we sent a purchase order to Methods for the automation system,” Jones said, cracking a smile.

Jones worked with Methods on a turnkey automa-

tion cell utilizing the JobShop Cell, which comprises two FANUC RoboDrills and an articulating FANUC LR Mate 200iD robot.

Jones first encountered RoboDrills in 2020. A colleague recommended the vertical machining center for its reliability and repeatability. Soon enough, Jones reached out to Methods’ Sales Engineer David Snow. The two set up a tour of another CNC machine shop outfitted wall-to-wall with RoboDrills.

After seeing the RoboDrills in action, Jones worked with Methods to develop a time study on the JobShop Cell.

“I’ve had interest in automation for more than a decade,” he said. “The approach was a little bit different than what I imagined, but it was the right approach, really.”

Before implementing the automation system, 3rd Gen Machine would try to make multiple parts simultaneously. While that process made good use of fast tool-to-tool change times, the shop’s throughput plateaued; it could only produce components as fast as people could manually load and unload parts. That cumbersome process is partly what led to the spindle crash.

Methods’ applications engineering team designed the cell for single-piece runs. That method retained the RoboDrill’s lightning-like 1.3-second chip-to-chip change time and removed the possi-

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bility of errors in the loading/unloading process. Moreover, the shop was free to run unattended.

The results were better than anyone predicted. “You’re working with the limits of a robot, which are nearly limitless,” Jones said. “After we got in there and optimized the programs to the equipment, we were able to surpass the cycle time on the time study. That definitely showed us that the RoboDrill cell was the way to go.”

The JobShop Cell improved nearly every workflow on the shop floor; it unshackled skilled laborers so they can tend to other equipment rather than loading/unloading machines. And, the cell came online just in time for a high-production project

for the outdoor goods industry.

“We had a big ask for Methods, we wanted to make nine different parts from the twin cell,” Jones said. “Customer demands increased at the same time we brought that in, it would have been challenging to get their products on more and more equipment.”

Not only did Methods deliver on that big ask, Jones said, but experts also helped him work out some kinks. At first, chips were getting near the cell’s proximity sensor and piling up in the wrong area.

“I requested additional air ports for the robots to

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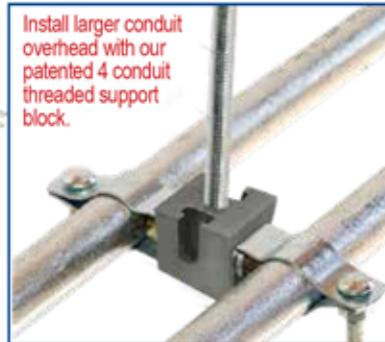
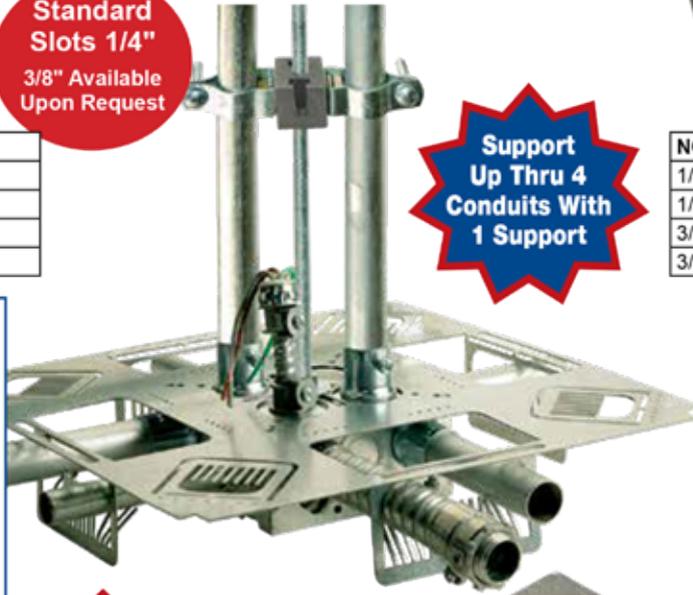
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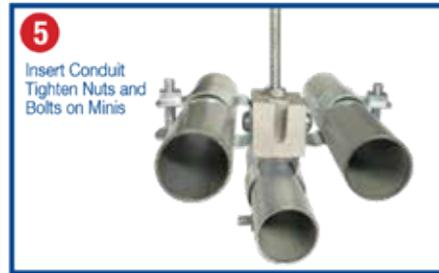
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help me manage chips, and Methods came in and solved that for me," Jones explained.

The cell ended up working so well, 3rd Gen Machine installed a second unit and has a third JobShop Cell on order. The JobShop Cell puts out twice the output compared to other solutions while only taking up half the floor space; Jones said, a valuable commodity. The shop's throughput increased to the extent employees had to stage finished goods in rented shipping containers.

However, those are temporary solutions. The JobShop Cell has helped 3rd Gen Machine's growth, and in turn, Jones is utilizing that capacity to expand his business with a new building.

But 3rd Gen Machine is doing much more than expanding its capacity and adding new machines. They're further developing departments and capabilities, planning for long-term, consistent growth, and cementing their position as a full-service machine shop.

Jones said he'll always keep Methods in mind when he needs more machines.

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A “Cool” Story About Solving Metal Die-Casting Water Problems

Zinc die-cast manufacturer finds cooling towers composed of advanced engineered plastic provide an optimal long-term solution for cooling process water.

When it comes to die casting, controlling the process temperature is crucial. If the temperature of the dies is too hot it can damage the mold; too cold and the temperature could drop too quickly and cause serious defects - including greater porosity or misruns on the casting surface.

Used to draw heat from the die cavities, water is an integral part of the die-casting cycle. This is where cooling towers come into play, ensuring that optimal water temperatures can enable the production of the highest-quality parts. However, the reliance on old, outdated cooling technologies can put die-casting companies at risk of costly downtime, or even flawed parts that may cause irreparable damage to a company’s reputation.

For years, the Ridco Casting Company in Pawtucket, RI, struggled with its three metal-clad cooling towers which had to be operational 24 hours a day, 7 days a week. The fourth-generation family-owned and operated zinc die



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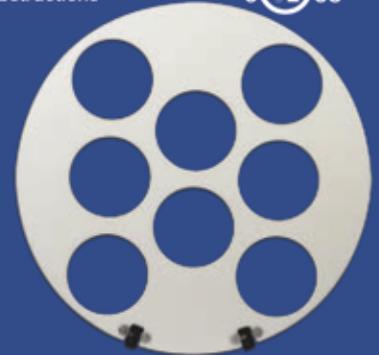
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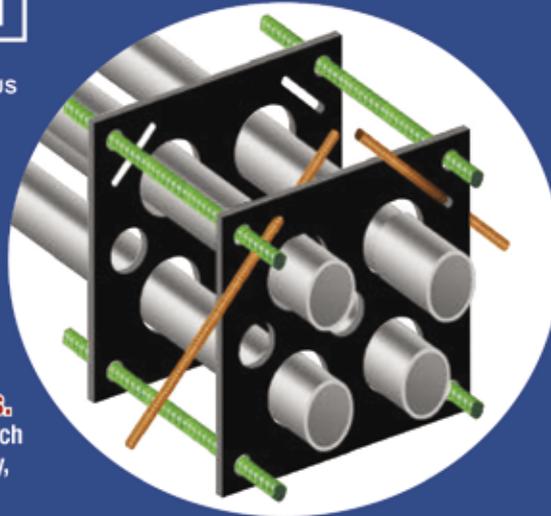
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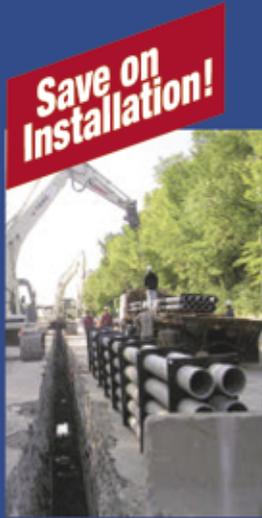
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casting manufacturer is known for producing some of the highest quality components in the industry.

“Metal cooling towers are maintenance intensive,” says Jeffrey Cohen, President of Ridco Casting. “We spent a lot of time over the years repairing and replacing our old galvanized steel towers.”

A cooling alternative

The performance of cooling towers constructed with metal-clad sheeting can be compromised by a significant number of factors. Among these are environmental circumstances, such as salt-air, or the presence of ambient caustic gases from industry. Other corrosive damage can result from the harsh chemicals used to treat the water that passes through the cooling tower.

“We finally decided to end the cycle of replacing our metal towers with another metal tower,” explains Cohen. “This time we decided to go with an HDPE cooling tower, and we’re happy we did.”

High-density polyethylene (HDPE) cooling towers are composed of engineered plastic that is impervious to the natural and chemical causes of rust and corrosion. Developed by Delta Cooling Towers (www.deltacooling.com), such cooling towers are available today in a variety of designs and capacities from 10 to 2,500 cooling tons, with newer modular designs that can be connected for even greater capacities.

The HDPE cooling tower model Ridco Casting selected was a Paragon 200-ton model with enough cooling capacity to eliminate all three of the metal towers the company was utilizing. This model includes one-piece casing, so there are no troublesome joints or seams – areas that are often the source of leaks that require significant ongoing maintenance. Its HDPE construction ensures that the tower design can handle the toughest water-cooling jobs in any climate.

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benefits as well. For example, Ridco experienced a substantial savings when its new unit was installed. A typical cooling tower installation project can take several weeks or more. However, the engineered plastic designs are factory assembled, enabling an installation process that can often be completed in a single day with a smaller crew.

The savings did not end there for Ridco. Cohen estimates that his new cooling tower has greatly reduced expenses on costly water treatment chemicals as well as requiring far less maintenance and having essentially eliminated downtime related to its cooling water.

Cohen is also impressed with the savings he is seeing on his cooling tower's fan drive system. His old metal towers came with a belt-drive fan system that required periodic belt replacement in order to prevent further downtime. The Delta direct drive fan further eliminates the need for this maintenance, while the variable-frequency drive (VFD) motor enables users to enjoy substantial savings on electric power consumption.

"We are estimating a savings of at least \$5,000 a year on our electric bills," concludes Cohen. "And now we have a lower average water temperature reading than with the three old units. So, it has worked well for us." •



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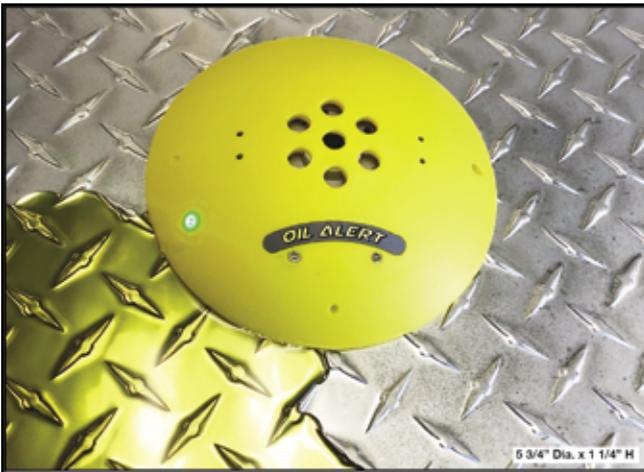
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