



WNT proves less is more at Peerless Gas Controls

 When Flintshire-based Peerless Gas Controls, a manufacturer of gas solenoid valves and regulators, invested in a Haas Mini Mill with a fourth axis, the workholding solution required was going to be a simple replication of existing set-ups. That was until a timely visit by WNT (UK)'s technical sales engineer Matt Darbyshire.

The existing set-up consisted of four vices on a horizontal

tombstone, which was then rotated by the fourth axis. Peerless Gas Controls had been happy with this set-up as it gave the company 16 parts per cycle, and asked WNT to quote like-for-like. While happy to look at that option, Mr Darbyshire's experience told him that there was a better way, one that would reduce the number of vices, while increasing the number of parts per cycle and cutting the cycle time.

The vices used are from


WNT's DSG series, which are located on a triangular tower held horizontally in the fourth axis unit. Additionally, WNT has designed sub-plates, with precise location points that allow rapid changeover from one component type to another. The DSG series was selected for the set-up due to a number of features. These include a low profile with a height of just 60 mm from the vice base to the location surface. The vices can,

as in this case, be set up as a centric vice with a central third jaw, making load/unload easier.

"Using the old system we could finish 16 valve blocks in 65 minutes," says Tom Thomas, engineering manager at Peerless Gas Controls. "Now, by just having three vices, we can finish 18 parts in 45 minutes and we do not have to interrupt the cycle to turn parts over."

For further information www.wnt.com

Hainbuch chucks suit prosthetics parts

 Based in Weisendorf, Germany, Peter Brehm GmbH develops, manufactures and sells medical implants for primary and revision joint surgery. Here, a carbon fibre workholding solution from Hainbuch, which is available in the UK from Leader Chuck Systems, has addressed exacting production demands.

Six years ago the company decided to install a quartet of Hermle C30 five-axis milling machines featuring an integrated a pallet changer with more than 24 pallet positions, and that can handle pallet weights up to 60 kg. Round material is clamped with

nine manual Manok CFK stationary chucks from Hainbuch.

Chucks from a competitor, used prior to automating, did not have a construction height sufficient to move the loading station into the machine. The company was also dissatisfied with the shape of these clamping devices and the resulting swarf ingress. In the search for an alternative, these and other criteria were made priorities. For example, the new stationary clamping device should also be able to accommodate bars that are as long as possible. It should also have a low construction height



to avoid waste material, and be easily accessible.

"We decided on the carbon fibre Manok," says production

manager, Gerd Kirsch. "In addition to its minimal size, the CKF Manok offers a significant weight saving compared with the steel version."

The carbon version is as much as 70% lighter and at the same time is extremely rigid because it is equipped with hexagon Toplus clamping heads that offer a positive locking of the clamping head and clamping device. Unlike round clamping heads, the hexagon model prevents radial displacements to the taper of the clamping device. Therefore, the chips cannot penetrate into the chuck.

For further information www.leaderchuck.com