

PRIORITY SUPPLY Inc.
Providing Intelligent Solutions to the Metal Turning Industry

HAINBUCH PUSHER SYSTEMS

Stop Gumming of Material Due to Pushers

This, and future stories, are provided to allow our customers to learn and benefit from the experiences and the mishaps of others. They are all true, and out of respect for all our customers the names of companies and individuals will be withheld.

A manufacturer we've been working with for a time, recently experienced a quality containment issue that ended up costing them in several ways. Seems that material was gumming up around their pushers during the production run on a large job.

They were using a standard two-split pusher collet at the time. The tension was so tight it scraped the material right off the bar stock and built up around the assembly. The buildup was so bad they had to shut down the machine for more than four hours a week while valuable time was lost cleaning up the work area.

At a their production rate for these parts per hour they were losing thousands of parts production per week and were forced to go into over-time to make up. This led to thousands of dollars per week in revenue loss plus a burden rate for the over-time.

Luckily they were using the Hainbuch pusher system in another department and contacted Priority Supply to see if this pusher system would apply to this problem.

With Hainbuch pushers, different purposes are often served by the same part. James worked with his contacts and got several alternatives.

James was able to confirm that there was a solution that did indeed apply to this particular application. The customer then purchased a set of six Hainbuch RS Pusher Assemblies and installed them into the machine. This completely eliminated the weekly hours of down-time caused by the material build-up and has not caused them any down-time since.

The Hainbuch Pusher is specifically engineered to deal with problems of the kind described above. It's a two-piece assembly that is tension adjustable. It consists of an outer collet and an inner collet and the two components are spring loaded in relation to each other.

- Tension Adjustable
- Easy to Assemble into Machine

For any questions or concerns that may be generated please contact us by email at jamesb@prioritysupply.com or phone (888) 287-6973. We hope you will prosper from at least one of these episodes along the way in this and others in the email series.

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RS-Adjustable Feed Fingers

Huge savings potential for multi-spindles

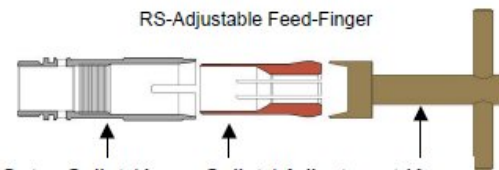
Principle:

The inner collet is screwed into the outer collet using a special key. A marking ring on the inner collet in conjunction with a scale on the outer collet is a guide to set the approximate feed force.

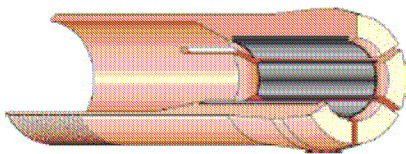
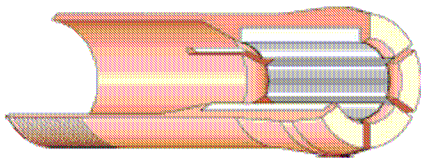
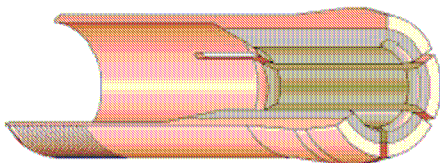
- The feed force is set to required value; wear is therefore minimized
- Feed marks are mostly eliminated
- The contact is all around the bar due to the multiple slotted inner collets
- The bar pointing process can be obsolete
- Reduced inventory: The same inner collet fits into different brands of multi-spindles machines



Conventional Feed-Finger



Outer Collet / Inner Collet / Adjustment Key



KSB-Plastic Coating is recommend whenever feed lines or scratches on the material surface must be prevented

OXK-Ceramic Coating. This extremely hard surface prevents the seizing of material to the clamping bore and minimizes scratches on the material surface. The long tool life justifies their use in high volume mass production environments. Available for round bores only.

HM-Carbide Coating recommended for similar applications as feed fingers with OXK coating. Available for profiled clampings.