

Economical production data by Cascade deburring machine

1. Company Name : Seongshin Precision Co.,Ltd

2. Products : Power steering pump for commercial automobile

3. Comparative table

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Parts	Monthly Production Q'tities	Coventional Manual Deburring Process			Cascade Deburring Machine			Remark
		Cycle Time (Deburr/Wash/Move)	Working Time		Cycle Time (Deburr/Wash/L,Unloading)	Working Time		
			Min per part	Total(Min)		Min per part	Total(Min)	
S-701	100	2.0' / 0.8' / 0.5'	3.3	330	1.4' / 0.8' / 2.0'	0.7	70	Loading q'tities per cycle : 6ea
RF-8	300	2.0' / 0.8' / 0.5'	3.3	990	1.4' / 0.8' / 2.0'	0.7	210	
IPS-L	500	1.5' / 0.3' / 0.5'	2.3	1,150	1.0' / 0.3' / 2.0'	0.55	275	
IPS-M	1,000	1.5' / 0.3' / 0.5'	2.3	2,300	1.0' / 0.3' / 2.0'	0.55	550	
IPS-S	1,500	1.5' / 0.3' / 0.5'	2.3	3,450	1.0' / 0.3' / 2.0'	0.55	825	
S-103 REAR	2,500	2.0' / 0.8' / 0.5'	3.3	8,250	1.0' / 0.8' / 2.0'	0.63	1,575	
S-104 REAR	1,500	2.0' / 0.8' / 0.5'	3.3	4,950	1.0' / 0.8' / 2.0'	0.63	945	
KMT	1,000	2.0' / 0.8' / 0.5'	3.3	3,300	1.0' / 0.8' / 2.0'	0.63	630	
S-103 FRONT	2,500	1.4' / 0.8' / 0.5'	2.7	6,750	1.0' / 0.8' / 2.0'	0.63	1,575	
S-104 FRONT	1,500	1.4' / 0.8' / 0.5'	2.7	4,050	1.0' / 0.8' / 2.0'	0.63	945	
Total	12,400			35,520			7,600	

4. Comparison of working condition

Rejected rate	0.40%	0.10%
Deburring quality	Inspection and 2nd deburring process requir	Good
Numer of workers	4 persons	1 person
Daily working time	8 Hour	8 Hour
Effective rate	70%	70%
Monthly working days	25 days	25 days

5. Results

1) Cost saving

2) Achived reject rate almost 0%

3) Improvement of product quality due to integrated deburring quality

4) Reduction of cycle time

