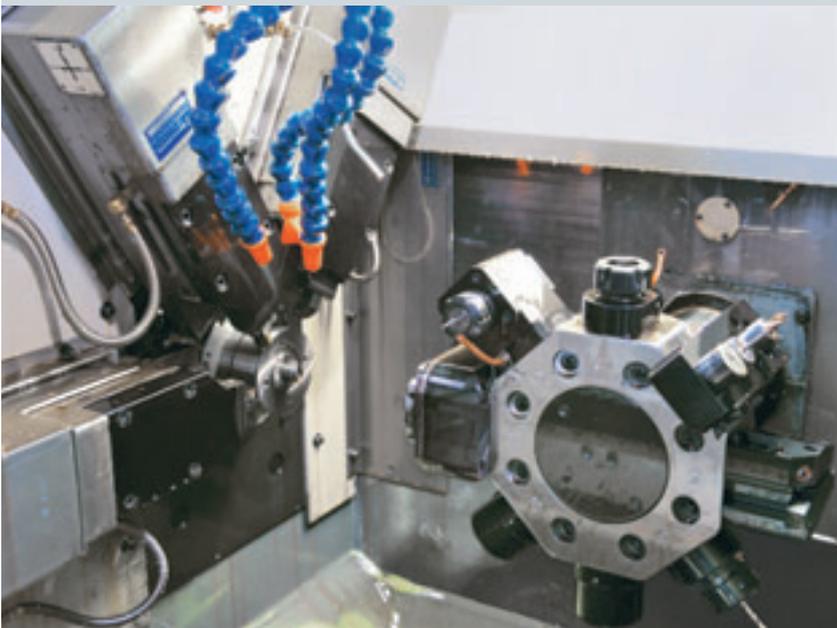


■ Alan Manufacturing Inc., Odessa, Florida

# Time For Turning

Florida shop achieves near 100 percent turning center utilization through smart use of Sinumerik 840D control software.



Siemens Energy & Automation, Inc.

The Lico turning center has three independent slides, separate from the turret, with a back spindle and can run up to four live tools

Sophisticated machine tools are not only the workhorse, but the stallion of modern component manufacturing. However, these expensive machines must be kept fully utilized for a production shop to operate profitably. Much of this comes from good organization, scheduling the work flow and availability of materials. But the machines themselves can have a big influence on efficiency. A machine tool with the ability to perform varied tasks and with quick setup time is going to make a big contribution to overall efficiency and hence profit. Alan Manufacturing Inc. in Odessa, Florida is one company that has taken a structured approach to efficiency in its choice of machine tools and the software driving them.

Alan Manufacturing is a production CNC turning shop making components for high-accuracy flow instruments, high-pressure hydraulic gear, surgical equipment, marine engines and military ordnance among others. The shop uses a number of machine tools to perform turning, threading, boring, drilling,

cross-drilling, milling and hard machining to 0.000050" roundness.

Two turning centers are currently in use at Alan Manufacturing: an Emco Maier 332MC, and the newest acquisition, a Lico LNT 36 with three independent slides and able to utilize up to four live tools simultaneously. Both the Emco Maier and Lico machines have Sinumerik 840D CNCs onboard, a key factor for the shop's efficiency.

## Same software drives different machines

The Sinumerik motion control system includes many modules for specific functions, but the basic concept of the system is standardization, with the same basic control modules being used across many machine technologies. This enables Alan Manufacturing to duplicate their programs between the Emco Maier and Lico machines allowing up to 75 percent of jobs to be run on either machine. The multi-channel controls are the same for both machines, as are the motors and drive packages.

Simple programming of the machines is another major factor in minimizing setup time. The operators at Alan Manufacturing are able to program directly at the machine, using customer-supplied print or DXF files. The control software has straightforward routines and self-help graphics for threading, turning, boring and grooving. Almost every aspect of the cycle can be programmed on the machine control while the previous job is still running.

With the capabilities of the turning centers and control software, aside from cycle, workpiece and insert changes, Alan Manufacturing is consistently achieving nearly 100 percent machine utilization, a major contributor to its profitable outlook. ■

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