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# PRESS RELEASE

**Go Faster with RbSA Industrial!!**

**Operator Training is the key to higher production rates.**

In tube bending, production rate is often the difference between losing, break even, and profitability. Most bending shops are pretty realistic when they bid jobs, taking in to account machine changeover time, downtime for maintenance, and run rate. However, we find that most are often “giving away” hours of labor: Once they have the job and product running on their bender, they do not take the time to optimize the production rate.

Training operators and set-up personnel to recognize potential time savers in the movement of axes between bends and how to implement them into the program can pay huge dividends.

Here are a few easy examples:

- Partial opening of the Pressure Die. Most part programs default to fully opening the pressure die after bending, before any other movements are made. If it takes the PD 1.5 seconds to close and 1.5 seconds to open, this is a total of 3 seconds per bend, per part. By using a timer or programmed open position (depending on the type of PD on the machine) to only crack open the PD enough to clear the tube, the total time may be able to be reduced to 1 second or less.

- Combine discontinuous carriage moves: Typically, the default move for the carriage after bending, is to move forward the length of the clamp die and stop for the bend arm to return. The carriage then resumes its move for the length to the next bend. These pauses in movement can add up to several seconds per part.
- Combine the movement of multiple axes: By combining the moves of multiple axes, the time to produce the part can be reduced significantly. Feed, rotation, and bend arm return can usually all be combined for all or a part of their move. Clamps can often be opened and closed simultaneously, and on machines with Servo Positioned clamps, they can often be partially closed during the movement of the other axes.
- Optimize Loading: By setting the load position of the part to the position of the first bend, a whole move may be able to be eliminated prior to making the first bend, or the load position may be changed to reduce the amount of time it takes an operator to get the part ready for bending.
- Optimize Unloading: on some parts the carriage and bend arm can be positioned during the unloading sequence to have the machine ready to receive the next part, or the machine can position the completed part to make it easier for an operator to unload, reducing the amount of material handling time.

As a distributor and installer of BendPro controls and YLM machines, RbSA Industrial has developed a unique training program, using classroom time running simulated machines with all the physical controls just like the real machine. By working in a classroom environment, the trainer and operators do not have to struggle to hear and understand each other over the noises of a typical manufacturing facility. This classroom time is combined with practical application bending actual parts. This approach may help your operators and set up personnel recognize and implement significant time savings in the production rate coming off your CNC Tubing Benders!

Written by

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Come visit us at FABTECH 2018 in Atlanta, GA. Booth C10224

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