

Finishing News

NEWS BULLETIN ON MASS FINISHING TECHNOLOGY



April 2011 Volume 21

No.1 Mass Finishing Solutions Provider with over 4000 Installations

www.galagroup.com

*We wish you
a very happy
and Successful
FY 2011-12*

Other Automated Systems Installed



It is pleasure to come back to you with this half yearly finishing news from Gala Precision Engineering Pvt Ltd (Mass Finishing Solution Division)

As a part of our ongoing effort to spread awareness about mass finishing solution, we have organized number of Seminars ("VIBRO-BENZ Connect") at various cities . We also participated in Imtex2011 exhibition this year. Response to the same was very delightful.

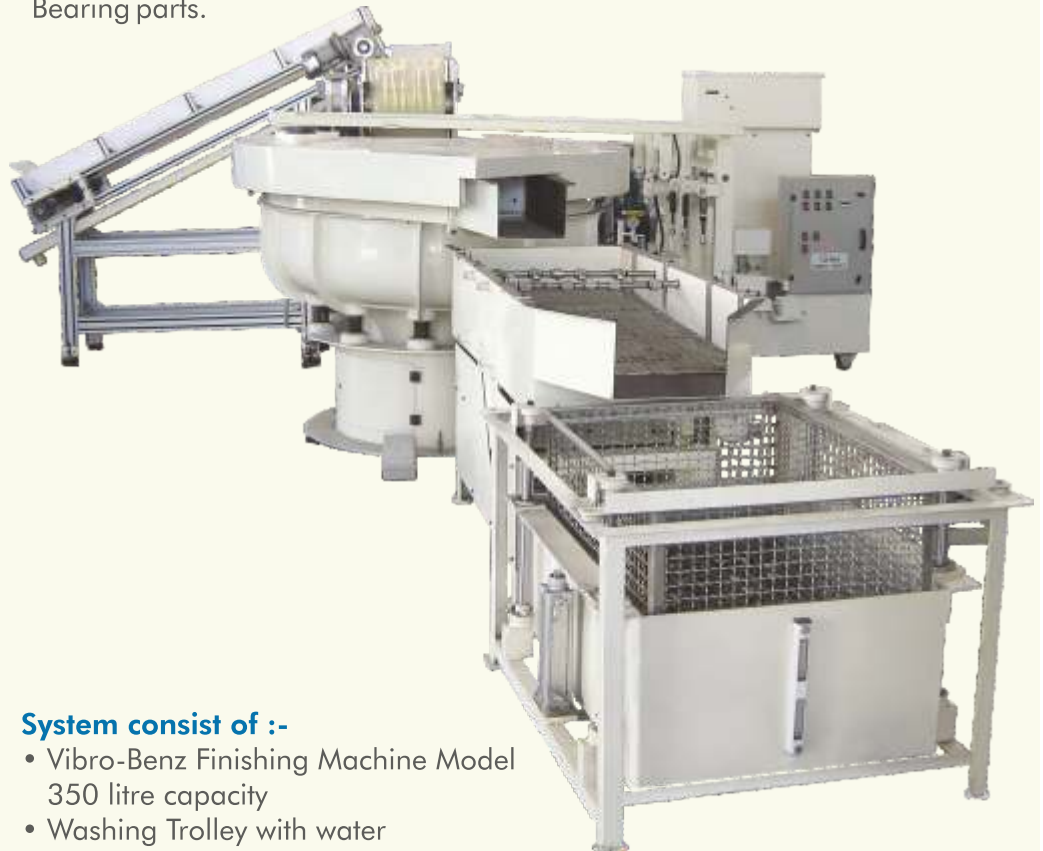
We are thankful to you for the valued response to our Finishing News.

AUTOMATED FINISHING SYSTEM

Month on month upward revision in demand by end customer, delay in delivery of raw material supplier on account of overall increase in demand in India , huge load on operation to squeeze manufacturing lead time are the current industrial scenario.

Gala's Customized Finishing Solutions will help to overcome such industrial scenario.

One of the latest system supplied by Gala to its customer for finishing of Bearing parts.



System consist of :-

- Vibro-Benz Finishing Machine Model 350 litre capacity
- Washing Trolley with water recirculation tank
- Filtration & Recirculation system
- Dipping Tank
- Horizontal Belt Conveyor
- Dosing System
- Inclined belt Conveyor
- PLC Based Control Panel

Benefits :-

- Reduction in process cycle
- Reduction in WIP
- Recirculation & filtration of waste water
- Easy material handling

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Gala's finishing solutions for Bearing Components

Case Study 1

Product - Inner Race & Outer Race

Requirement - Surface finish improvement

Present (Ra) Value - 0.6 μm

Expected (Ra) Value - 0.1 μm

Present Method - Barrel tumbling

Process Cycle Time - 4 to 6 hrs for one batch

Problems Faced - 1. Inconsistent finishing
2. Dimensional inaccuracy

Finishing Solution Provided By GALA :

Machine Used : Centrifugal Finishing Machine (CFM)

Surface Improved : From 0.6 Ra to 0.1 Ra

Process Cycle time : 2 hrs for deburring & finishing

Advantages - 1. Consistent surface finish
2. Dimensional accuracy
3. Lower process time



Case Study 2

Product - Bearing cages

Requirement - Deburring

Present Method - Manual buffing

Problems Faced - 1. Heavy man power involvement
2. Low productivity
3. High rejection rate due to manual operation

Finishing Solution Provided By GALA :

Machine Used : Automated Vibratory Finishing System

Surface Improved : Burr removed

Process Cycle time : 1 hr for deburring

Advantages - 1. Consistent deburring
2. Improved productivity due to auto separation & online washing
3. Low manual dependency
4. 80% reduction in man power



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Gala's finishing solution for Automobile Component

Case Study 3

Product - Carburetor Fuel Chamber

Requirement - deburring on external surface

Present Method - Manual deburring

Present Process Time - 3 to 4 hrs for 300 nos of components

Problems Faced -

1. Inconsistent deburring
2. Decreased productivity rate
3. High rejection rate due to manual operation
4. Improper material handling due to manual intervention

Finishing Solution Provided By GALA :

Machine Used : Auto Vibro Finishing Machine IN LINE with Drier

Process Cycle time : 1 hr for one complete cycle (Processing, Separation & Drying)

Per Batch Qty. Processed : 300 - 350 nos for 1 hr

Advantages -

1. Consistent deburring
2. Productivity increased due to reduced cycle time
3. Material handling reduced due to in line system

Before



After



Are you facing the separation problem of components from media?

GALA PROVIDES THE FOLLOWING SOLUTION

REVERSE SEPARATION (RD PU)

- 1) Motor rotates in reverse direction at the time of separation.
- 2) Oval shaped flapper for separation Arrangement.
- 3) No bump is provided. Flapper with rubber sheet provided.
- 4) Upto 90% separation is achieved.

ADVANCE SEPARATION (AS PU)

- 1) Motor rotates in ONE single direction.
- 2) Square shaped flapper for separation arrangement.
- 3) Bump is provided for efficient locking of flapper for effective separation.
- 4) Upto 100% separation is achieved.



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IMTEX 2011 EXHIBITION GLIMPSE



VIBROBENZ CONNECT, COIMBATORE



VIBROBENZ CONNECT, GURGAON



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