

Case Study

Ten Ham BV



Highlights

- ✓ Programming time dramatically reduced - in some cases from 3 hours to 5 minutes
- ✓ Number of NC code errors dramatically reduced
- ✓ Can now nest at multiple angles as opposed to a single fixed angle previously
- ✓ Manual changing of tooling now possible
- ✓ Automatic tooling accuracy vastly improved
- ✓ Can now produce more complex components that previously would have been impossible to program
- ✓ Machine cycle time improved overall by at least 10%
- ✓ Maintenance has delivered new functionality, making further savings
- ✓ Programmer and machine operator were trained in one day
- ✓ Machine now almost constantly in use due to overall improvements in programming time, cycle time and capabilities

Constructiebedrijf W. ten Ham BV, based in Ede have been using their Haco punch press to manufacture subcontracted components, together with their own range of stair components since its installation in 1996. The machine's controller had basic CAM functionality, taking in a DXF file and producing a nest, however this was extremely inflexible and prone to errors. After several years this began to limit the number and complexity of components they were able to manufacture, so they decided to research the market for a CAM system to compliment their existing AutoCAD installation. After evaluating the market they chose JETCAM, supplied by WIA Industriële Automatisering.

JETCAM Expert 1 was installed and two users were trained on the system. Bram ten Ham was one of the users trained;



"We learnt the system in only one day. I liked the interface - all of the relevant



options are available on each screen as you move through the software."

Once they put the system to work it immediately delivered several benefits that ultimately reduced the overall time it took to create parts. Previously the controller's CAM software would tool parts at only one angle automatically, and this procedure was also error-prone. In addition to this, manually reprogramming the tooling configuration was very difficult and left code open to even more errors. JETCAM could now tool components at different angles, tooling the job correctly each time. This in turn reduced the programming time from hours to minutes, the number of errors, machine cycle time and the



Software: JETCAM Expert 1

Machines: Haco Omes Omatic 320R
Punch Press

material used. In addition to undertaking subcontract work the company also has to fit in increasing demand for its own range of stair products (pictured right). As a result of the increased capacity they now no longer need to subcontract out additional work.

With any product that is relied upon in a business support can be a critical issue. *"We have had bad experiences of software and hardware support in the past, but JETCAM is the only product that has*



The company has expansion plans which includes larger premises and a laser machine. Ham comments that the punch press is busier than ever before, citing that an overall cycle time improvement of around 10% coupled with massively reduced NC code generation times allows them to get maximum efficiency. *"The more complex the job we take on, the greater the efficiency. We now have shorter lead times and can offer our customers a better service in terms of the complexity of the parts we can manufacture."*



lived up to expectations. WIA has also been very helpful - when I have a question I just email over a DXF file and I'll generally get an answer within a few hours, or even quicker." W. ten Ham BV has also received several software updates under their maintenance contract which have yielded additional benefits; *"With the most recent release, for example, it is now even easier to change tools manually."*