



APPLICATION CASE STUDY

COMPANY DETAILS –



Industries Inc.
ISO/TS 16949 Registered

Ralco Industries is a tier 2 stamping facility and tooling manufacturer in Auburn Hills, MI. Their target customers are in the automotive industry.

METAL MATES PRODUCTS IN USE

VS Lubricant Light Duty Stamping Lubricant
HDP-HSS Heavy Duty Stamping Lubricant for High Strength Steel
SS15 Coolant Semi-synthetic, biostable, general purpose metalworking coolant containing approximately 20% mineral oil.

CUSTOMER NEEDS IDENTIFIED

Metal Mates VS Lubricant is Ralco's house lubricant used on cold rolled, galvanized and hot rolled steel ranging from 0.032 to 0.140 material thicknesses. Metal Mates VS is an easy cleaned water based lubricant for stamping, drawing, piercing and flanging. It contains additives for corrosion protection and bacterial prevention as well as extreme pressure and anti-wear agents for light to medium-duty stamping. The company does welding assemblies and found VS to work better than the previous soluble oil they used and were able to eliminate washing their parts.

Recently, several extruded cold rolled steel parts with a material thickness of 0.035 were introduced. HDP Lubricant was successful initially but the coating life was short lived. The operators found that the titanium coating would wear off after 5000 hits. HDP-HSS (HDP High Strength Steel) was introduced in August 2006 and it has successfully help extend tool life.

ACCEPTED BENEFITS

- ❖ coating life was increased from 5000 hits to 35,000 hits before the coating showed signs of wear.
- ❖ Part washing process is eliminated.
- ❖ Increased productivity and reduced down time.

VALUE TO CUSTOMER

The cost savings per 35,000 part run is estimated to be \$840.00. This cost saving is a due to the extended punch life.

Area: MICHIGAN

Date: ONGOING

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