

The logo for HAWKE, featuring a stylized 'L' shape to the left of the word 'HAWKE' in a bold, sans-serif font.

**L HAWKE**

**HAWKE CABLE GLANDS LIMITED**

**“Increasing the Lead”**

**Advantages of Brass Machining**

Presentation by Mr. Trevor Norris

- **Hawke Products**

**Cable Glands**



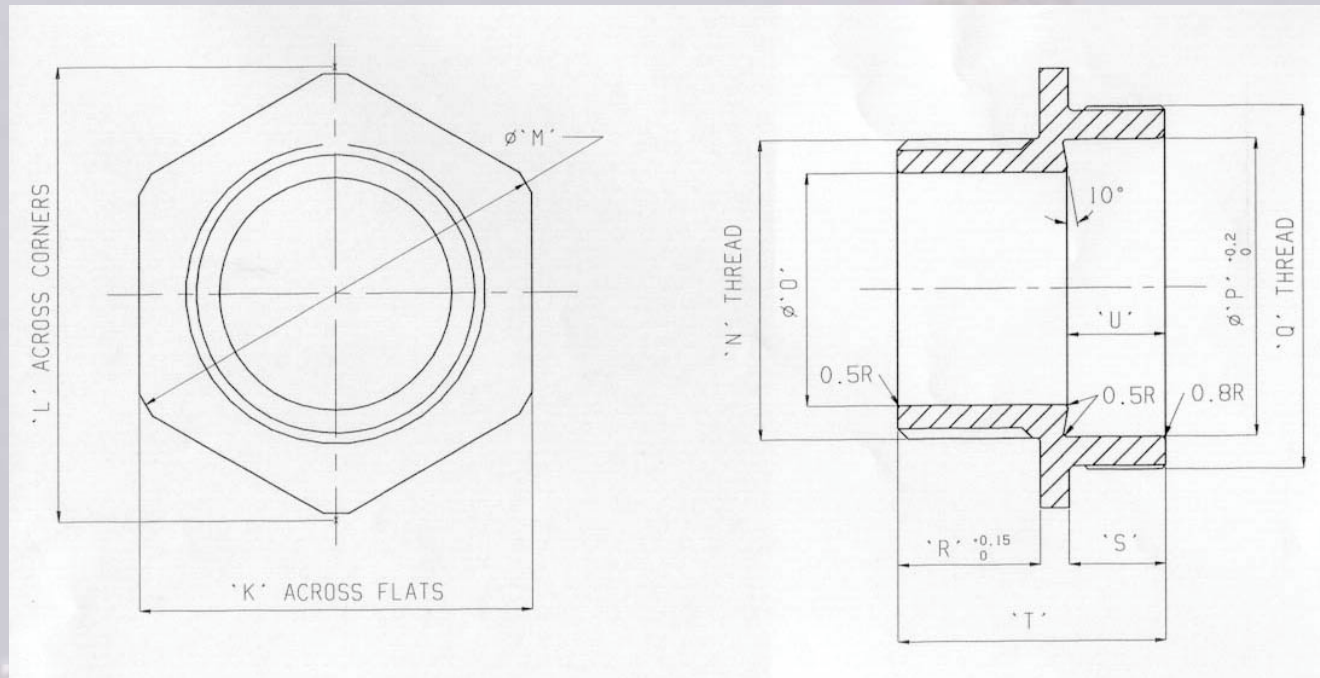
**Multi Spindle Wickmans**

**Connectors**



**CNC**

- **Cable Gland Entry**



## Method of Manufacture

- **Multi Spindle Wickman**
- **Machine Complete**

- **Tooling Comparisons**

	<b>Brass</b>	<b>Steel</b>
Tools	H.S.S.	Carbide
Average per Tool	£15	£60
Average Qty per Re-Grind	20K	2K
Average Tools per Set	10	10

- **Machining Benefits**

	<b>Brass</b>	<b>Steel</b>
Machine Cycle Time, Complete	7 seconds	21 seconds (not complete)
Machine Efficiency	89%	40%
Average comps/hour	410	68

## Brass



- Valuable
- Easy to Handle
- Compact

## Steel



- Value, negligible
- Clogs up machine
- Difficult to Handle
- Bulky

- **Other Benefits**

	<b>Brass</b>	<b>Steel</b>
Swarf	Re-sale Value	None
Cutting Fluid	Water Base Light Machine Oil	Special Water Base (HP) Special Oil with Additives
Labour Requirements	Low	High
Environmental Protection	None	Plating

- **Cost Comparisons**

	<b>Brass</b>	<b>Steel</b>
Net Material Cost	10.0	8.0
Machining Cost (£40/hour)	9.75	59.0
<b>Component Cost</b>	<b>19.75</b>	<b>67.0</b>

**Comment**

- Additional Threading Op. Required
- Plating

# Summary

## Brass vs. Steel

	For	Against
Material		*
Machining Cost	*	
Total Cost	*	
Tooling	*	
Ancillaries	*	
Environmental	*	