



# D.L. Ricci Corp. Case Study #332

## "Machining at Home"

- Set-Up:** - Usually our case studies pay tribute to our field crews out on-site, but this story is an example of the kind of work we often do at our own facility. An upper Midwest fabricator needed some machining work done on giant sprayer pivot arm assemblies for a water treatment plant. The fabricators had worked with D.L. Ricci before and decided the economical choice was to bring the assemblies to Red Wing for the machining work.
- Plan:** - Two different machining operations needed to be performed on the assemblies. First the 1/2" stainless steel assemblies had gotten out of round and they needed to get a 4" wide groove all around the assembly trued up for bearing support. Secondly the top of the assembly needed to get flattened to square the face off for a bearing nut on the end.
- Operation:** - Our Axial Feed Machine (attached to a HD 50 Clamshell) was selected to create the 4" groove for the bearing surfaces. Next our versatile Portable Milling Machine was mounted on a 36" HD Clamshell for the top facing. A 60" Mill base was attached to a 4Z Mill and this gave the unit up to 18" of travel to face the end. A chuck from an 836 REP was installed in the assembly to give extra stability to the milling operation.
- Results:** - The end results were completed on time and to the customer's specifications. The ability to have the machining in-house allowed Ricci machinists the opportunity to use all the capabilities of the shop and our hands-on machining equipment, to help get the job done efficiently and accurately.

