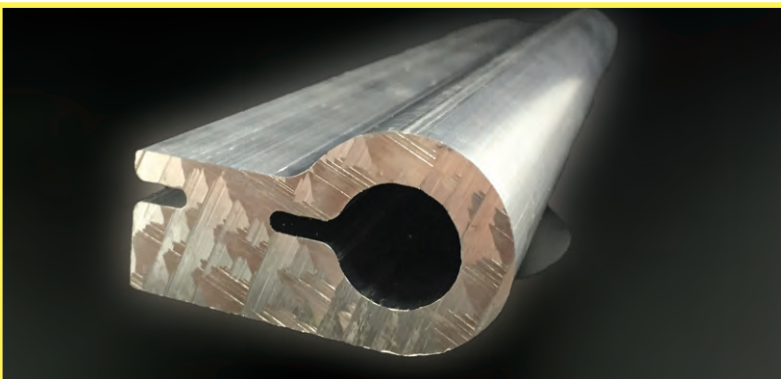
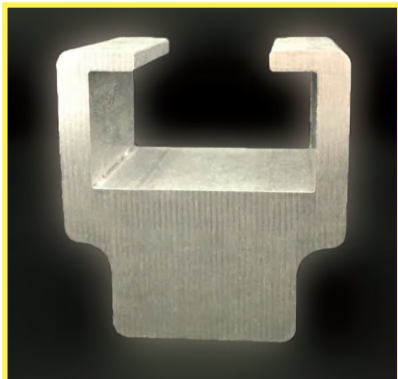


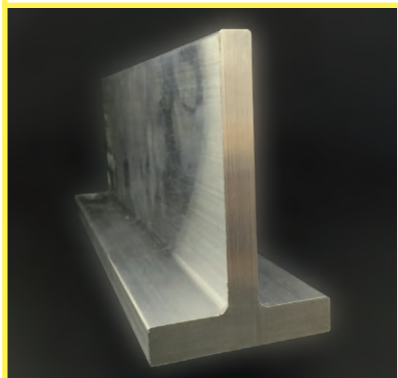
YOUR **PREMIER DISTRIBUTOR** OF **CUSTOM ALUMINUM EXTRUSIONS**

Near Net extrusions can dramatically increase your cycle times on machined parts. Custom extrusions greatly decrease your scrap rate per part; saving you time and money. Less machine time will increase the longevity of your costly tooling. Faster cycle times allows you to get finished parts to customers faster, helping you increase your cash flow and meet demanding lead-times. Increase your productivity by letting Tube Service help you incorporate this Lean Manufacturing process into your production plan.

Tube
SERVICE CO.



FULL RANGE
of seamless, extruded and
as-welded tubular products



**We're
Moving
LASER
FAST!**

800.776.8823
Santa Fe Springs





A Reliance Steel & Aluminum Company

Aluminum, Carbon, Stainless, Alloy

■ 9351 S. Norwalk Blvd., Santa Fe Springs, CA 90670	800.776.8823	Fax 562.695.4027
■ 1571 N. Johnson Ave., El Cajon, CA 92020	800-673-4969	Fax 619.447.5572
■ 666 S. Milpitas Blvd., Milpitas, CA 95035	800-669-2169	Fax 408.945.0949
■ 1107 E. Jackson St., Phoenix, AZ 85034	800-528-9451	Fax 602.252.5489
■ 14509 E. 33rd Pl. Unit A, Aurora, CO 80011	888-776-8823	Fax 303.321.9100
■ 6650 N. Ensign St., Portland, OR 97217	800-255-5990	Fax 503.944.5430

See our catalog on our website @ www.tubeservice.com

NEAR NET BENEFITS

Material weight savings

Machine time savings

Tool cost savings - less wear

Better yield - custom extruded lengths

Increase productivity - more CNC jobs

NEAR NET #1 ROUND ROD SAVINGS

Opportunity for Rod

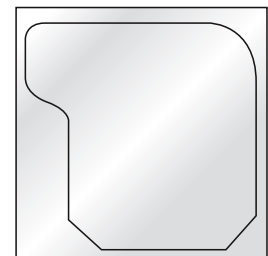
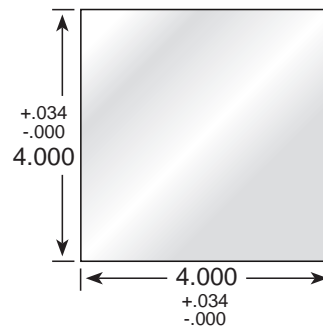
- 1.125" RD 6061-T6511
- EAU is 100,000 lbs

Customer finish size is 1.065" (+/- .0005")

- Customer needs .025" minimum to clean up
- Competition offers 1.125" RD 6061-T6511

Offer a die @ 1.094" (+/- .004) - near net size

- Die charge ~\$750
- Saves .031" on diameter = ~18#/pc;
5,500 lbs savings = \$8,800
- Mach savings of 0.25 seconds per pc = \$3,300 at \$75/hr



NEAR NET #2 SAVINGS

Acc-U-Bar 4" SQ Cut to 1.00" long

Near Net Cut to 1.00" long

Lbs / ft	18.98	13.68
Lbs / pc	1.58	1.14
Order pc qty	750	750
Gross lbs	1,185	855
Cost / lb	\$1.60	\$1.85
Material cost	\$1,896	\$1,582
Material savings		\$314
Machine min / pc	7.0	2.0
Mach rate / hr	\$75	\$75
Pcs / hr	8.6	30
Total mach cost	\$4,375	\$1,250
Machine savings		\$3,125
Die charge		(\$750)

Total Savings

\$2,689

Total Savings / pc

\$3.59

Total Savings / lb

\$2.27