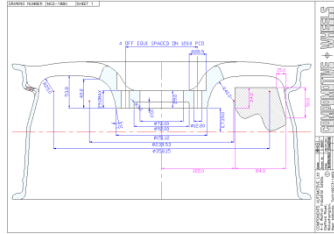


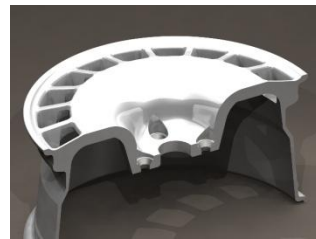


MANUFACTURING COMPOMOTIVE WHEELS

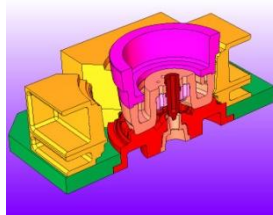
DESIGN & DIE PRODUCTION



AUTO CAD & SOLID WORKS ARE USED TO DESIGN ALL COMPOMOTIVE WHEELS



3D COMPUTER GENERATED PROTOTYPE WHEEL IMAGES ARE PRODUCED



EDGE CAM IS USED TO PRODUCE TECHNICAL DRAWINGS FOR TOOLING TO ALLOW THE DMC TO PRODUCE NEW MOULDS



DMC SPECIALIST DIE MAKING MACHINE PRODUCES NEW MOULDS

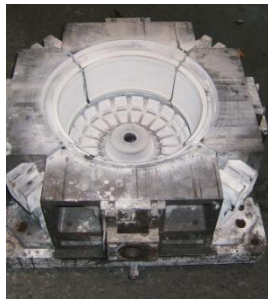


NEW HMC1460 6X14 BOTTOM CORE PRODUCED BY DMC MACHINE

FOUNDRY



DIES SIDES



DIE SIDES & BOTTOM CORE



TOP & BOTTOM CORE



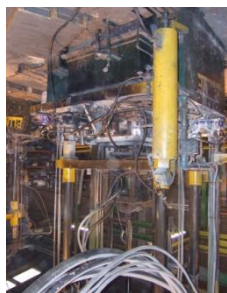
COMPLETE DIE TOP CORE, BOTTOM CORE & DIE SIDES ARE ASSEMBLED READY TO GO ON CASTING MACHINE



COMPOMOTIVE DIE STORES



PRIMARY ALUMINIUM IS MELTED IN THE FURNACE @ 900 DEGREES C



BATCHES OF 60>250 WHEELS ARE LOW PRESSURE CAST IN SPECIALIST PLUME MACHINES



CAST WHEELS ARE FETTLED IN FOUNDRY TO REMOVE SPRU & FLASH FROM CASTING

MACHINE SHOP



WHEELS ARE SENT TO A SPECIALIST HEAT TREATMENT PLANT TO BE HEAT TREATED TO OPTIMUM HARDNESS TO DUCTILITY RATIO BEFORE ANY MACHINING COMMENCES



FIRSTLY THE FRONT FACE IS MACHINED ON 60>250 WHEELS ALL THE SAME SIZE & DESIGN BY STATE OF THE ART CNC MACHINE



ON A SECOND CNC MACHINE THE INSIDE & OUTSIDE RIM IS THEN MACHINED ON THE SAME BATCH OF WHEELS




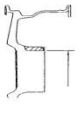
ALL WHEELS ARE PRESSURE TESTED



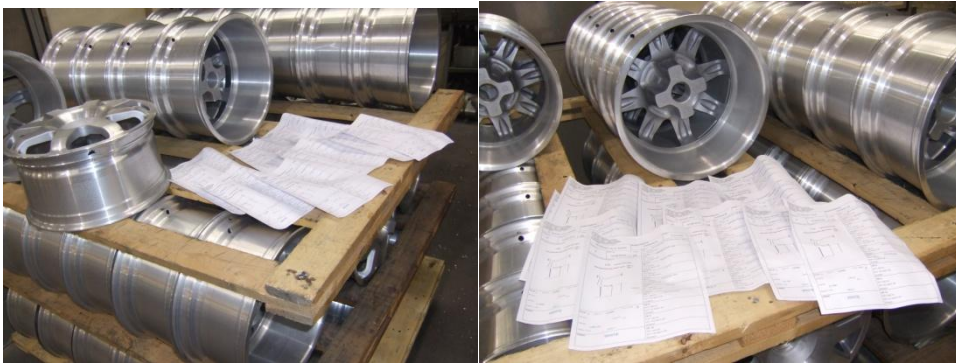
TURNED WHEELS (INSIDE /OUTSIDE RIM & FACE) ARE PUT INTO OUR BLANK CASTINGS STORES AWAITING SPECIFIC ORDERS

MACHINE SHOP CONT...



CUSTOMER		WORKS ORDER No.	DATE
QUANTITY	PART No.	OP 1 QTY. REQD. QTY. TO NEXT OP. ISSUED	
MACHINED REQUIREMENTS		OP 2 QTY. REQD. QTY. TO NEXT OP. ISSUED	
→ BACK FACE MM		OP 3 QTY. REQD. QTY. TO NEXT OP. ISSUED	
MACHINE BEFORE PAINT FACE - MM		OP 4 QTY. REQD. QTY. TO NEXT OP. ISSUED	
		OP 5 QTY. REQD. QTY. TO NEXT OP. ISSUED	
		OP 6 QTY. REQD. QTY. TO NEXT OP. ISSUED	
PCED	PCD X	PCD 000P	OP 8 QTY. REQD. QTY. TO NEXT OP. ISSUED
DETAILS	MATERIAL		OP 9 QTY. REQD. QTY. TO NEXT OP. ISSUED
MARKING			OP 10 QTY. REQD. QTY. TO NEXT OP. ISSUED
FINISH			OP 18 QTY. REQD. QTY. TO NEXT OP. ISSUED

ORDERS ARE TAKEN BY OUR SALES STAFF & A TECHNICAL MACHINE SHOP NOTE IS PRODUCED. BLANK CASTINGS ARE TAKEN FROM OUR TURNED CASTING STORES & PUT READY TO BE MACHINED TO THE CUSTOMERS SPECIFIC ORDER. IF WE DO NOT HAVE BLANK CASTINGS WHEELS HAVE TO BE CAST @ FOUNDRY & ORDER IS KEPT PENDING.



WHEELS ARE SORTED INTO BATCHES OF SAME SIZE & PUT ON PALLETS



OFFSET & CENTRE BORE ARE MACHINED BY STATE OF THE ART CNC MACHINES



PCD IS DRILLED BY STATE OF THE ART CNC MACHINES

FINISHING & PAINT PLANT



CUSTOMERS ORDERS & STOCK ORDERS THAT ARE BACK FACED(OFFSET), BORED (LOCATION) & PCD DRILLED ARE THEN MOVED TO PAINT PLANT AREA TO WAIT FOR FINISHING



WHEELS ARE DEBURRED/FITTELED WITH A SPECIALIST MACHINE TO REMOVE ANY ROUGH EDGES & BUMPS



WHEELS TRAVEL ROUND THE PAINT PLANT THROUGH A 7 STAGE PRE-TREATMENT PROCESS.

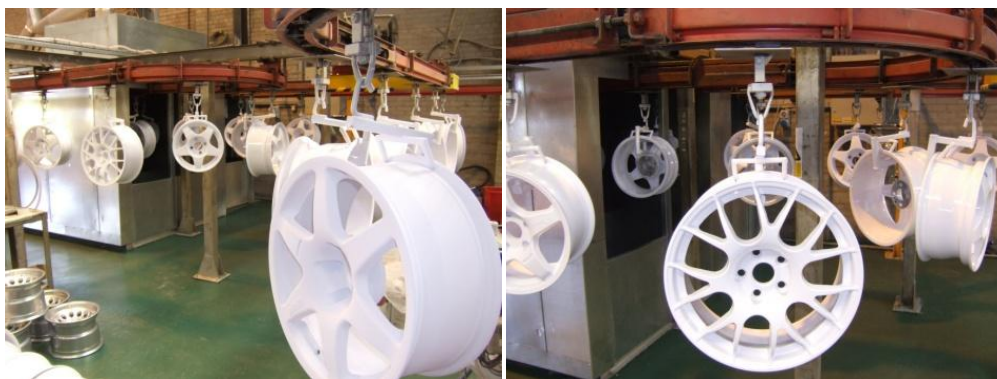


POWDER PAINT STORES

PAINTING CONTINUED..



USING A ELECTRO STATIC PAINT GUN WHEELS ARE POWDER PAINT UNDERCOATED & TRAVEL AROUND THE PAINT PLANT & THROUGH OVEN FOR THE FIRST TIME. WHEELS ARE CHECKED AGAIN & ANY MARKS FOUND ARE HAND RUBBED DOWN.



WHEELS ARE THEN COLOUR POWDER PAINTED IN BATCHES OF SILVER, GOLD, GREY, BLACK OR WHITE & TRAVEL AROUND PAINT PLANT & THROUGH OVEN AGAIN. WHEELS ARE CHECKED AGAIN & ANY MARKS ARE HAND REMOVED & REPAINTED IF NEEDED.



SILVER, GREY & GOLD WHEELS ARE THEN CLEAR POWDER PAINT POLYESTERED & TRAVEL AROUND PAINT PLANT & THOUGH OVEN AGAIN. A SINGLE WHEEL CAN GO ROUND THE PAINT PLANT MINIMUM 3 TIMES FOR WHITE /BLACK & COLOURS MINIMUM 4 TIMES

INSPECTION, PACKAGING & DESPATCH



WHEELS ARE MOVED ROUND TO THE DESPATCH AREA TO HAVE INSERTS FITTED.
FINAL INSPECTION IS MADE PRIOR TO BOXING.



WHEELS ARE PACKED IN HIGH QUALITY CORRUGATED BOXES SPECIFIC TO THE SIZE OF WHEEL



WHEELS THAT ARE MANUFACTURED FOR STOCK GO INTO COMPOMOTIVE'S FINISHED WHEEL STORES



CUSTOMERS ORDERS ARE BOXED & Banded THEN DESPATCHED BY DPD NEXT DAY



HAPPY CUSTOMER RECEIVES HIS COMPOMOTIVE WHEELS