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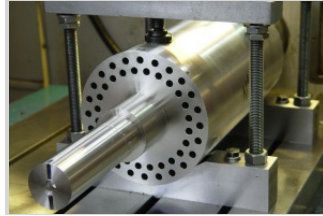
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## Experience makes all the difference in Hone-All Precision's line of work

Accredited to the AS 9100 aerospace quality standard and an SC21 Bronze level award company since August 2010, Hone-All Precision Ltd reports that aerospace continues to be a growth area for the Leighton Buzzard-based subcontractor.



"It is a highly competitive market sector, but our experience as a tier two supplier in other equally demanding industry sectors such as oil and gas, and motorsport has proved invaluable," says Andrea Rodney, director.

The company's most recent investment has been in two Sunnen horizontal tube honing machines, ideally suited to tube honing applications requiring high stock removal rates on larger diameter components. However, although specialising in deep hole boring, deep hole drilling/gun drilling and honing, Hone-All Precision has invested in the complete spectrum of precision machining. "This takes in everything", says Colin Rodney, managing director, "from sourcing raw materials, right the way through to fully machined components."

It is Hone-All Precision's experience of producing high length-to-diameter ratio holes, often in difficult-to-machine materials, such as Inconel and Hastelloy, while guaranteeing excellent surface finish and straightness characteristics, that continues to be the key to progress. In terms of hole drilling this equates to a surface finish of 0.8 µm/32 CLA and a total run-out (TIR) of 0.025 mm/25.4 mm, while the typical surface finish for honing is 0.05 micron. Typical components requiring deep hole drilling up to 20 mm diameter include con rods, drive shafts, steering columns, electronic housings, injection mould tools, prosthetics, rotors, actuators and landing gear. For holes greater than 20 mm diameter the alternative is deep hole boring.

A particular example of Hone-All Precision's hard-won expertise is its capability in terms of gun drilling deep holes in different positions and at different angles in a single set-up. This avoids the introduction of cumulative dimensional errors through multiple machine set-ups as well as eliminating the risk of drill breakage resulting from the drill 'catching' at a point of intersection between holes. "This is where we save our customers both time and money," says Andrea Rodney, "and where experience gained over more than three decades really does make a difference.

"In fact, it was experience that counted recently when an in-house candidate with several years' service in the deep hole boring section asked to be considered on equal terms for the position of quality engineer/inspector. This role has been created in response to the increasing complexity of machined components and the resulting need for additional capability in our QC department. Having outperformed several external applicants with his in-depth knowledge of engineering he has now started in his new role, reflecting our ongoing commitment to training and career progression from within."

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