



Total team approach sums up Hone-All Precision's commitment to SC21 supply chain initiative



Hone-All Precision Limited is a quality company that cares about its people, its environment and its product, and is intent on providing a world-class service to its customers.

TEC Concepts Ltd's Dave Bull (second from left) with fellow members of the specialist consultancy's SC21 senior management team.

(From left to right of picture: Jeremy Bell, Principal Consultant; Dave Bull, Director; Dr David Scrimshire, Director; and Dr Paul Castle, Principal Consultant)

In December 2009 Hone-All Precision Ltd signed up as a 'self-starter' to SC21, the collaborative programme designed to accelerate improvements in the competitiveness of the UK's aerospace and defence industry by raising the performance of its supply chain. SC21 is backed by AIDIS - the trade body formed by the merger of, among others, the Defence Manufacturers Association (DMA) and the Society of British Aerospace Companies (SBAC) - with signatories, currently numbering 626 UK-based suppliers, committed to working together to remove duplication and improve efficiency.

Many of the smaller businesses have been 'sponsored' by top tier customers, although 26-employee Hone-All Precision decided to take an independent route to achieving the Bronze level status currently accorded to some 30 suppliers. "The team here enjoys a challenge and, having successfully achieved AS 9100 accreditation in September 2009, we were determined to satisfy the exacting requirements of SC21 in the shortest possible timescale," says Wayne Wilson, Quality Manager and joint SC21 Champion.

shortened delivery times and minimised the movement of heavy material and components through the factory. We have also reduced energy usage by installing a new roof with clear panels to let in natural light, and opting for Carbon Trust-approved, highly energy efficient daylight quality lighting throughout the factory."

To help meet this challenge Hone-All Precision looked to TEC Concepts Ltd, a specialist research, development,

training and implementation organisation focused on business development. A founding member of the SC21 Task Force, TEC has been actively involved in the design and development of the SC21 campaign, including the development of a bespoke SC21 three phase implementation improvement programme. A five-day programme of diagnostic workshops was duly tailored to Hone-All Precision's specific requirements, one of more than 40 such programmes implemented to date by TEC Concepts.

The outcome, according to TEC Concepts' Director, Dave Bull, is that "as well as SC21 Bronze Award recognition of improvements in quality and delivery performance, the additional benefits [to Hone-All Precision] of the programme include greater value-added-per-person (GVA) and improved customer relationships. Hone-All Precision will now focus on the areas of improvement identified in the Continuous Sustainable Improvement Plan (CSIP) with the next goal being the Silver Award, and the company is also considering hosting a SC21 supply chain cluster."

Hone-All Precision's core expertise is in honing, deep hole drilling and boring, and gundrilling, although as visitors to the recent MACH 2010 manufacturing technology exhibition could see for themselves, this BS EN ISO 9001:2008/BS EN AS 9100:2003-accredited subcontractor provides a complete manufacturing service - from sourcing raw materials through to producing quality machined components.

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Hone-All Precision Ltd's core expertise is in honing, deep hole drilling and boring, and gundrilling.

Specialising in deep hole boring, deep hole drilling, CNC turning, CNC honing and milling, it is equipped to machine components up to 300 mm diameter by 3 m long, and has the expertise to produce high length-to-diameter ratio holes, often in difficult to machine materials such as Inconel and Hastelloy, while guaranteeing excellent surface finish and straightness. In terms of deep hole drilling this equates to a surface finish of $0.8 \mu\text{m}/32 \text{ CLA}$ and a total run-out (TIR) of $0.025 \text{ mm}/25.4 \text{ mm}$, while the typical surface finish for honing is $0.05 \mu\text{m}$.

As part of this on-going process Hone-All Precision has restructured its entire manufacturing operation following its relocation in 2008 to a fully-refurbished 20,000 sq. ft. factory. This provided the ideal opportunity to introduce various environmental initiatives, as well as significantly improving the process flow from raw material to finished component. The decision to relocate was taken and implemented before the economic downturn began and, while the timing of the move did initially present some difficulties, it has since provided the company with an ideal environment in which to implement a logical flow of work, from delivery of raw material to shipment of finish machined components, and to address every aspect of quality management and excellence.

The doubling of the floorspace available that resulted from the substantial six month-long refurbishment project has enabled additional investments to be made in machine tools and related equipment. This has been a vital part of the company's lean manufacturing strategy developed initially with input from Cranfield Manufacturing Business Consultancy, which has shortened delivery times and minimised the movement of heavy materials through the new factory. "Now, hopefully, the reward for the team will be to receive our Bronze Award at the ultimate of venues, the Farnborough Aerospace show," says Andrea Rodney, Bedfordshire's Businesswoman of the Year 2009. "After that, our focus is on meeting the SC21 Silver level criteria of 99.5-99.9 per cent quality performance, a demanding requirement

The Leighton Buzzard subcontracting company submitted its SC21 application within four months of beginning the actual process, having exceeded the recently-upgraded Bronze level performance requirements of 90-95 per cent on-time deliveries and 98-99.5 per cent quality performance. According to Managing Director, Colin Rodney, "we are committed to delivering the best possible service to our customers, all of whom benefit from the various improvements that we have made, and that we will continue to make, in our drive for world-class performance."



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