Contents

Pre	face t	o the Second Edition	
		o the First Edition	iı
	- .		
1.	Introduction		j
	1.1	What Is Design for Manufacture and Assembly?]
	1.2	How Does DFMA Work?	8
	1.3	Reasons for Not Implementing DFMA	16
	1.4	What Are the Advantages of Applying DFMA During	
		Product Design?	21
	1.5	Typical DFMA Case Studies	22
	1.6	Overall Impact of DFMA on U.S. Industry	34
	1.7	Conclusions	39
		References	40
2.	Selection of Materials and Processes		
	2.1	Introduction	43 43
	2.2	General Requirements for Early Materials and Process	
		Selection	45
	2.3	Selection of Manufacturing Processes	46
	2.4	Process Capabilities	48
	2.5	Selection of Materials	55
	2.6	Primary Process/Material Selection	65
	2.7	Systematic Selection of Processes and Materials	71
		References	83
			vii

3	Prod	luct Design for Manual Assembly	
_	3.1	Introduction	85
	3.2	General Design Guidelines for Manual Assembly	85
	3.3	Development of the Systematic DEA Mail 11	86
	3.4	Development of the Systematic DFA Methodology Assembly Efficiency	93
	3.5	Classification Systems	93
	3.6	Effect of Part Symmatry on Handle Tr	96
	3.7	Effect of Part Thickness and Signature	96
	3.8	Effect of Part Thickness and Size on Handling Time Effect of Weight on Handling Time	101
	3.9	Parts Requiring Two Hands for Manipulation	103
	3.10	Effects of Combinations of Factors	104
	3.11	Effect of Symmetry for Ports that Course 1 No. 27	104
	0.11	Effect of Symmetry for Parts that Severely Nest or Tangle and May Require Tweezers for Grasping and Manipulation	
	3.12	Effect of Chamfer Design on Insertion Operations	104
	3.13	Estimation of Insertion Time	105
	3.14	Avoiding Jams During Assembly	108
	3.15	Reducing Disc-Assembly Problems	109
	3.16	Effects of Obstructed Access and Restricted Vision on	111
		Insertion of Threaded Fasteners of Various Designs	
	3.17	Effects of Obstructed Access and Restricted Vision on	112
		Pop-Riveting Operations	
	3.18	Effects of Holding Down	115
	3.19	Manual Assembly Database and Design Data Sheets	115
	3.20	Application of the DFA Methodology	118
	3.21	Further Design Guidelines	119
	3.22	Large Assemblies	125
	3.23	Types of Manual Assembly Methods	128
	3.24	Effect of Assembly Layout on Acquisition Times	130
	3.25	Assembly Quality	133
	3.26	Applying Learning Curves to the DFA Times	137
		References	141
			143
4.	Electri	ical Connections and Wire Harness Assembly	147
	4.1	Introduction	147
	4.2	Wire or Cable Harness Assembly	149
	4.3	Types of Electrical Connections	152
	4.4	Types of Wires and Cables	159
	4.5	Preparation and Assembly Times	160
	4.6	Analysis Method	182
		References	190

Contents ix

5.	Design for High-Speed Automatic Assembly and Robot Assembly		
	5.1	Introduction	191
	5.2	Design of Parts for High-Speed Feeding and Orienting	192
	5.3	Example	196
	5.4	Additional Feeding Difficulties	199
	5.5	High-Speed Automatic Insertion	199
	5.6	Example	201
	5.7	Analysis of an Assembly	202
	5.8	General Rules for Product Design for Automation	203
	5.9	Design of Parts for Feeding and Orienting	208
	5.10	Summary of Design Rules for High-Speed Automatic	
		Assembly	210
	5.11	Product Design for Robot Assembly	211
		References	217
6.	Printed Circuit Board Design for Manufacture and Assembly		219
	6.1	Introduction	219
	6.2	Design Sequence for Printed Circuit Boards	220
	6.3	Types of Printed Circuit Boards	220
	6.4	Terminology	222
	6.5	Assembly of Printed Circuit Boards	223
	6.6	Estimation of PCB Assembly Costs	238
	6.7	Case Studies in PCB Assembly	244
	6.8	PCB Manufacturability	249
	6.9	Design Considerations	252
	6.10	Glossary of Terms	263
		References	266
7.	Design for Machining		267
	7.1	Introduction	267
	7.2	Machining Using Single-Point Cutting Tools	267
	7.3	Machining Using Multipoint Tools	275
	7.4	Machining Using Abrasive Wheels	284
	7.5	Standardization	290
	7.6	Choice of Work Material	291
	7.7	Shape of Work Material	293
	7.8	Machining Basic Component Shapes	294
	7.9	Assembly of Components	307
	7.10	Accuracy and Surface Finish	308
	7.11	Summary of Design Guidelines	311
	7.12	Cost Estimating for Machined Components	313
		References	337

x Contents

8	Dani	C. T	
0	. Desi	gn for Injection Molding	339
	8.2	Introduction	339
	8.3	Injection Molding Materials	340
	8.4	The Molding Cycle	342
	8.5	Injection Molding Systems	344
	8.6	Injection Molds	346
	8.7	Molding Machine Size	351
	8.8	Molding Cycle Time	353
	8.9	Mold Cost Estimation	359
	8.10	Mold Cost Point System	367
	8.11	Estimation of the Optimum Number of Cavities	369
	8.12	Design Example	372
	8.13	Insert Molding	374
		Design Guidelines	375
	8.14	Assembly Techniques	376
		References	379
9.		n for Sheet Metalworking	381
	9.1	Introduction	381
	9.2	Dedicated Dies and Pressworking	383
	9.3	Press Selection	403
	9.4	Turret Pressworking	409
	9.5	Press Brake Operations	413
	9.6	Design Rules	416
		References	422
10.	Desig	n for Die Casting	422
	10.1	Introduction	423 423
	10.2	Die Casting Alloys	423
	10.3	The Die Casting Cycle	425 425
	10.4	Die Casting Machines	42 <i>5</i> 426
	10.5	Die Casting Dies	420 429
	10.6	Finishing	430
	10.7	Auxiliary Equipment for Automation	430
	10.8	Determination of the Optimum Number of Cavities	432
	10.9	Determination of Appropriate Machine Size	433 439
	10.10	Die Casting Cycle Time Estimation	439 443
	10.11	Die Cost Estimation	443 453
	10.12	Assembly Techniques	453 457
	10.13	Design Principles	457 458
		References	458 459
			439

Contents xi

11.	Design	for Powder Metal Processing	461
	11.1	Introduction	461
	11.2	Main Stages in the Powder Metallurgy Process	463
	11.3	Secondary Manufacturing Stages	464
	11.4	Compaction Characteristics of Powders	468
	11.5	Tooling for Powder Compaction	475
	11.6	Presses for Powder Compaction	478
	11.7	Form of Powder Metal Parts	481
	11.8	Sintering Equipment Characteristics	484
	11.9	Materials for Powder Metal Processing	489
	11.10	Contributions to Basic Powder Metallurgy Manufacturing	
		Costs	492
	11.11	Modifications for Infiltrated Materials	511
	11.12	Impregnation, Heat Treatment, Tumbling, Steam Treatment,	
		and Other Surface Treatments	512
	11.13	Some Design Guidelines for Powder Metal Parts	514
		References	515
12.	Design	for Sand Casting	517
	12.1	Introduction	517
	12.2	Sand Casting Alloys	519
	12.3	Basic Characteristics and Mold Preparation	519
	12.4	Sand Cores	524
	12.5	Melting and Pouring of Metal	525
	12.6	Cleaning of Castings	526
	12.7	Cost Estimating	527
	12.8	Design Rules for Sand Castings	537
	12.9	Example Calculations	542
		References	546
13.	Design	for Investment Casting	549
	13.1	Introduction	549
	13.2	Process Overview	549
	13.3	Pattern Materials	552
	13.4	Pattern Injection Machines	552
	13.5	Pattern Molds	554
	13.6	Pattern and Cluster Assembly	554
	13.7	The Ceramic Shell-Mold	555
	13.8	Ceramic Cores	556
	13.9	Pattern Meltout	556
	13.10	Pattern Burnout and Mold Firing	557
	13.11	Knockout and Cleaning	557

xii Contents

13.12 Crts # 1 7	
13.12 Cutoff and Finishing 13.13 Pattern and Core Material Cost	557
THE COLUMN COST	557
13.14 Wax Pattern Injection Cost 13.15 Fill Time	561
13.16 Cooling Time	562
	562
-journal and Reset Time	564
and the second per ration of the	566
- Cole injection Cost	567
13.20 Pattern and Core Mold Cost 13.21 Core Mold Cost	567
Total Cost	572
- Land Cluster Assembly Cost	572
of taris per cluster	574
- ameni i rece Cost	575
and Etting	576
TIOI WATERIAL COST	576
13.27 Investing the Pattern Cluster 13.28 Pattern Meltout	577
TITOTOUL	578
and Fieles	578
13.30 Total Shell Mold Cost 13.31 Cost to Melt Metal	579
Tribit Micial	579
- dist intent Cost	583
13.33 Ready-to-Pour Liquid Metal Cost 13.34 Pouring Cost	584
13.35 Final Material Cost	584
13.36 Breakout	584
13.37 Cleaning	586
13.38 Cutoff	587
13.39 Design Guidelines	587
References	590
References	591
14. Design for Hot Forging	
14.1 Introduction	593
	593
14.2 Characteristics of the Forging Process 14.3 The Role of Flash in Forging	593
14.4 Forging Allowances	595
14.5 Preforming During Forging	600
14.6 Flash Removal	603
14.7 Classification of Forgings	609
14.8 Forging Equipment	610
14.9 Classification of Materials	613
14.10 Forging Costs	622
14.11 Forging Die Costs	622
SB 210 Costs	631

Contents			xiii
	14.12	Die Life and Tool Replacement Costs	636
	14.13	Costs of Flash Removal	637
	14.14	Other Forging Costs	640
		References	641
15.	Design	for Manufacture and Computer-Aided Design	643
	15.1	Introduction	643
	15.2	General Considerations for Linking CAD and DFMA	
		Analysis	643
	15.3	Geometric Representation Schemes in CAD Systems	645
	15.4	Design Process in a Linked CAD/DFMA Environment	660
	15.5	Extraction of DFMA Data from CAD System Database	663
	15.6	Expert Design and Cost Estimating Procedures	665
		References	668
Nom	enclatur	re	669
Inde.		-	683
	enclatui	References	6