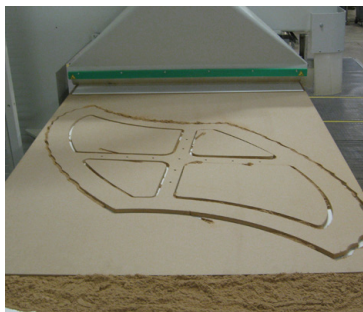# Delmac makes Chicago company a believer in nested-based machining

Busellato CNC router exceeds expectations for architectural millwork firm

As a millwork firm serving some of Chicago's leading commercial and residential architects, designers and builders, Stay Straight Manufacturing has always prided itself on quality and craftsmanship. With a shop full of traditional machinery – including a table saw, vertical panel saw and a manual 13-spindle line drill – that level of quality also came at a price: time.

"The amount of time it took us to create a job's worth of accurately sized custom parts was pretty significant," says Tony Potter, production manager for Stay Straight. "Everything was manual and that required a highly skilled person to make sure that everything was accurate."

Looking to shed its cell-based production process for something more efficient, Stay Straight began to research its options, which included adding a nested-based router.

"At first I was skeptical of the nested-based production method when we first started looking at CNC routers," says Potter. "I was comfortable with work cell because that is what I was familiar with."

Last year, Stay Straight decided to purchase a CNC router and chose a Busellato JET Optima RT with a 4' x 10' table from Delmac Machinery Group. "Delmac came in with a machine at a value and price point that we could justify," says Potter. "One thing we really liked about Delmac was that they provided both a CNC router and a software package. The Genesis Evolution Numerical

Control has add-on applications for nesting parts (JetNest) and turning DXF files from our CAD program into machine code (Autolink and Backlink). There was no need for us to buy third-party cabinet design software." Another selling point for Stay Straight was the Busellato's standard offload device and dust extraction, something it says is an added cost with most other machinery suppliers.

In the year that Stay Straight has operated its CNC router, Potter says the two biggest attributes of the new addition are time and accuracy. "The accuracy and speed of the machine have met or exceeded our expectations every time. In addition, we were able to increase our output without having to increase the size of our staff."

Pottery says the debate between work cell and nested-based machining is a thing of the past. "When you are cutting by hand, mistakes are made, even with a highly-skilled person. I love the old panel saw, but the router just runs circles around it. I don't think there is much of a debate about it for a small shop like us."

Although Stay Straight primarily uses its Busellato for cutting out boxes, its new CNC capabilities allow the company to take on new work and cut curved parts.

"With the Busellato, we certainly have been able to complete more complicated work that we would have passed up on or we would have taken and been less profitable on in the past," says Potter.

BUSELLATO CNC ROUTERS
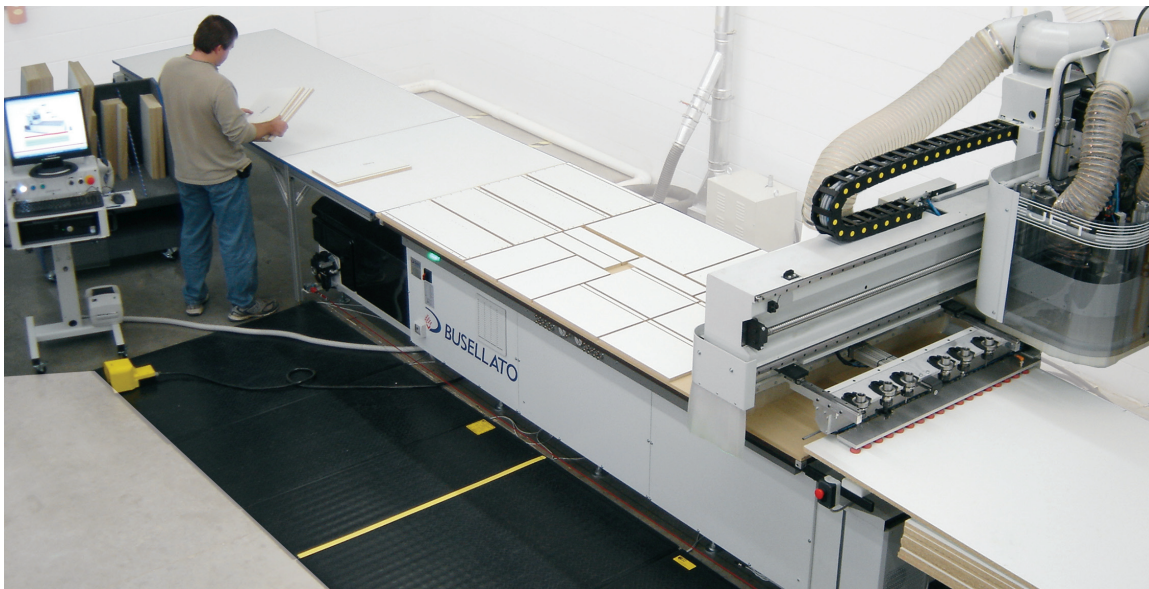
LINEAR   LEAN   LOGICAL

Busellato CNC Router with Linear Flow Automated Load/Unload System:

- Material flows in one direction
- Operator does not have to load up 4 x 8 panels
- Single unloading area allows time for labelling and organization
- Machine vacuums table during the load/unload cycle, no airborne dust
- Exceptionally efficient dust extraction during machining with 4-way directional air blast
- Advanced nest editing features in Genesis Evolution
- Optimized acceleration/deceleration curves for fast processing
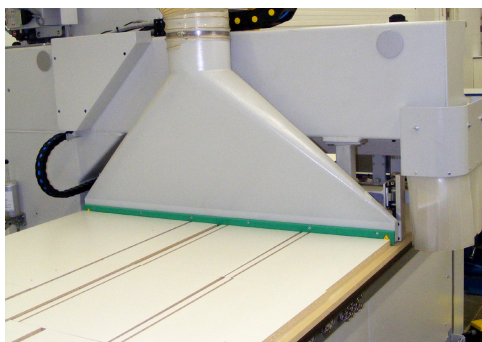
Automatic Unload

Automatic Load

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