

# Custom wheels

Custom wheels can be made to order.

But please understand the process of doing customs, and the time and effort involved. They are not cheap!

Let me explain. Shop rate is \$60.00 per hour. Let's say we have 2 hours in CAD design. You're already at \$120.00 and you have nothing tangible. Now let's pick out the tools and put some tool path to our CAD. Another 2 hours. Now we have to design fixtures, and build them. 2 hrs design and 8 hrs to build fixtures. Plus material for the fixture. Now we need the material for the wheels. It's has to be cut from stock or ordered in. Are you starting to see the cost? Now we can put the fixture on the machine, load tooling, load program, pick up X0, Y0, Z0. Half of the day is gone just on set up alone. Remember, its \$60.00 every hour, and we still haven't put a tool to the aluminum yet. OK, now lets start cutting.

Now there are two theories on manufacturing. First one is to take your time and fine tune every tool to make the first part off the machine good. Or, Push thru it and fix the gremlins on the 2<sup>nd</sup> piece of material. The material is cheaper than the time. It's only the size of a wheel. The rest of the wheels will only take the cycle time to run them.

Repeat for every operation, there might be 4 or more for a wheel.

Now we can debur any sharp edges and polish them. Next we can clean them and put them in a box to ship them to you.

Once the prototypes are done and all the bugs are worked out, wheels or other parts can go into production. Then the cost comes WAY down. All the work is already done, it just cycle time and material.

So, In short, don't have a cow when I quote you \$1600.00 for a set of 40 series bead locks with 3D surfaces and 3 spokes instead of 5 with a 15 micro.

**This is why it cost so much.**

Thanks

Rick