

# DN House: Chapter 2 Inc.

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Wisconsin manufacturer [Chapter 2 Incorporated](#), a leader in production machining work, runs their production machine tools over 5,000 hours per year. For those of you interested in the math: that ends up being three shifts a day for five days a week, plus some weekends. This takes an incredibly durable machine and a dependable service network. And that's just what Chapter 2 gets from their 30+ DN Solutions machines and [Ellison Technologies](#).

## From Prototype Jobs to Production Work

Founded in 1973 as a tool & die shop, Chapter 2 has grown into a full-service manufacturer supporting a wide range of industries including power equipment, lawn & garden, industrial equipment and medical. They've grown their services from machining jigs, fixtures and dies to offering automation design and build, fabrication services and their specialty: high volume precision machining.

"We can do anything from prototype to high volume work," said Kyle Johnston, CEO of Chapter 2. "While we make hundreds of thousands of transfer cases and flywheels each year, we also offer a full-service tool room with journeyman machinists that can deliver the best jigs, fixtures, dies and molds."



## Why Chapter 2 Turned To DN

Chapter 2 currently has 20 DN Solutions turning centers on their shop floor, including their first, a Lynx 300M, that they purchased over a decade ago. Back then, they were experiencing a boom in production work and were looking for a workhorse turning center to handle the increased volume.

"The machine hit all of our expectations," states Johnston. "Production cast iron machining can be challenging, and the machine has held up to that. We've tested the limits of the live tooling and drill capacities, and pushed the limits of the speeds and feeds."

That Lynx is still making parts today, and DN Solutions has been the go-to turning center for Chapter 2 ever since. The company has put its automation experience to work, configuring the majority of their PUMA turning centers into heavily automated cells that produce parts day and night.

## Serious Horizontal Machining Prowess

The first DN Solutions HP horizontal machining center found its way to Chapter 2 in early 2015. "We had multiple product lines with volumes increasing, and we needed to boost our capacity," said Johnston. "The DN turning centers, coupled with Ellison's service, were performing for us at such a high level. It made sense to stick with what was working."

Chapter 2 started with the HP horizontal machining centers, but has since switched to the [NHP](#). "We've seen an impressive efficiency improvement with the NHPs," Johnston said. "The faster tool change times and faster feed rates really help shave cycle times. We have one high-volume part that took ten minutes on the HP, but we've reduced it to 8.5 minutes on the NHP. A 15% cycle time reduction is not uncommon."

Chapter 2 utilizes their eleven DN Solutions' horizontal machining centers to run a wide range of parts in varying quantities, from dozens to thousands per month. Their expertise in creating clamping systems and creative tooling solutions has helped them to get the most out of their HMCs. And by getting the most, we mean running each machine for 5,000+ hours per year. "We utilize every minute," said Johnston.



**Ellison Makes Its Mark**

For a company like Chapter 2 that demands 5,000+ hours of machining time each year from dozens of machines, having the right support team is mission critical. "We feel downtime," said Johnston. "Service is just as important as the machine."

"Ellison maintains our uptime. Their response time is quick, and they routinely service machines within 24 hours. They've also worked with our team as a resource as we've learned the machines. That's helped us improve what we can handle internally on our own."

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