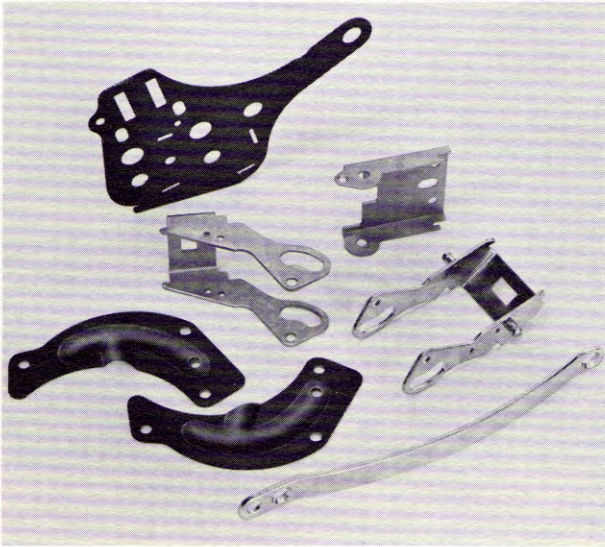


Monarch Marking System plant in Dayton, Ohio.

Typical parts run in the Die-Namic Process. Part runs range from 200 to 6000.



Monarch Marking Systems



**has control over
190 parts with Minster
Die-Namic® Process**

Monarch Marking Machines are manufactured and assembled in a modern 243,000 sq. ft. structure in Dayton, Ohio. In the manufacturing process, one Minster Die-Namic 75 ton press is used for 240 separate operations in part production—and Die-Namic dies are being added at the rate of 4 to 6 a month.

Marking machines are only “one side” of the business world of Monarch Marking Systems, a Subsidiary of Pitney Bowes. As World Leaders in Merchandise Identification Systems, the company produces many millions of tickets, tags and labels every day in the Dayton facility. The marking machines are designed to imprint, dispense and usually affix these labels to a wide variety of items.

Such marking systems are based on the widespread need among retail stores and throughout industry for price marking, product identification, and inventory control.

The tickets, tags and labels of such systems are produced in all sizes and shapes. They are stuck on, pinned on and tied on.

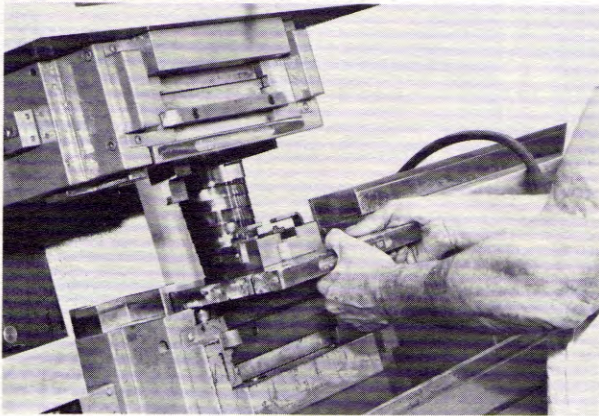
Just as Monarch Marking Systems provide their customers with the means to imprint variable information on price tags and identification tickets, the Minster Die-Namic Process gives tremendous flexibility to part production in Monarch's manufacturing process. Typical die runs on the Die-Namic range anywhere from 200 up to 5000-6000, according to Charlie Myers, Manufacturing Engineer.

“That's the beauty of the Die-Namic”, says Mr. Myers. “It doesn't take any time at all to change dies. We can run just the number of parts Production needs rather than have set-up time dictate the size of the run on slow moving parts. And if we get a rush job, we can break in anywhere. It only takes a minute to change dies.”



Mr. Charles Myers, Manufacturing Engineer, Monarch Marking Systems with Monarch's Model 116 Senso-Ply hand-held imprinter-applicator. Used in retail firms for price-marking and labeling in one operation. Industrial firms use the Senso-Ply for numbering and lettering.

Press operator inserts lower half of Die-Namic die into press-mounted fixture. He can change dies and be back in production in about one minute.



Mr. Myers also commented that dies for the Minster Die-Namic Process are easily stored near the press and that plates for the dies were about one-third the cost of regular die sets.

The Die-Namic press at Monarch is a 75 ton machine. Parts are formed from steel in various thicknesses from .005" to 1/8". The press is hand-fed at the present time but is presently being equipped with an air-operated feed.

In the four years that Monarch has had the Die-Namic Process it has proven to be a very low-maintenance, low-repair installation. "We had to call the Minster service department once when we knocked the press out of alignment while doing something we really shouldn't have. It wasn't the fault of the press."

Monarch has two other presses, both Minsters. And according to Charlie Myers, "When the time comes to buy another press, we'll buy another Minster."



All Die-Namic dies are neatly and conveniently stored a few feet from the press. Die changes are done very quickly.

This Minster Die-Namic® press is used for more than 240 different stamping operations in the manufacture of parts for Monarch Marking Machine products.

