

Newest Minster 500 ton capacity E2 HeviStamper press produces several different drawer body blanks.

## Stanley-Vidmar declares Minster E2 HeviStamper® presses “tops” for precision progressive die operations

It is common for Minster E2 HeviStamper press users to place repeat orders based on performance, low maintenance record and first-rate service provided by Minster's technical people. Stanley-Vidmar, Allentown, Pennsylvania, the company which pioneered the Modular Storage Drawer System is an excellent example. They purchased their third E2 press because they experienced good service, quality and minimal downtime with two others according to Mr. R. F. Buchholz, Plant Manager. “Our E2-300 was single stroked at 21 spm for five years . . . literally millions of strokes . . . with no clutch problems. Our relationship with Minster has been excellent . . . absolutely tops. And so is the press,” says Mr. Buchholz.

Stanley-Vidmar produces an exceptional variety of Modular Storage Drawer Systems and other products for the organized storage of small parts and tools.

Basic parts produced include several types of drawers, partitions, dividers, etc. . . . all made from heavy gage steel. The company utilizes large master progressive dies with “sub-dies” like this one (shown in the photograph) which is used to stamp drawer body blank parts. These parts, of 33 $\frac{5}{8}$ ” x .0359” thick cold rolled steel are run in the newest 500-ton capacity E2 press. Maximum feed length is 45  $\frac{7}{8}$ ”. Eight sets of sub-dies are used in the same master die. Upper and lower die cushions are used in this press for two good reasons: a. Replacing springs is expensive. b. By adjusting cushion pressure, slipping caused by variations in the steel's surface finish can be controlled.

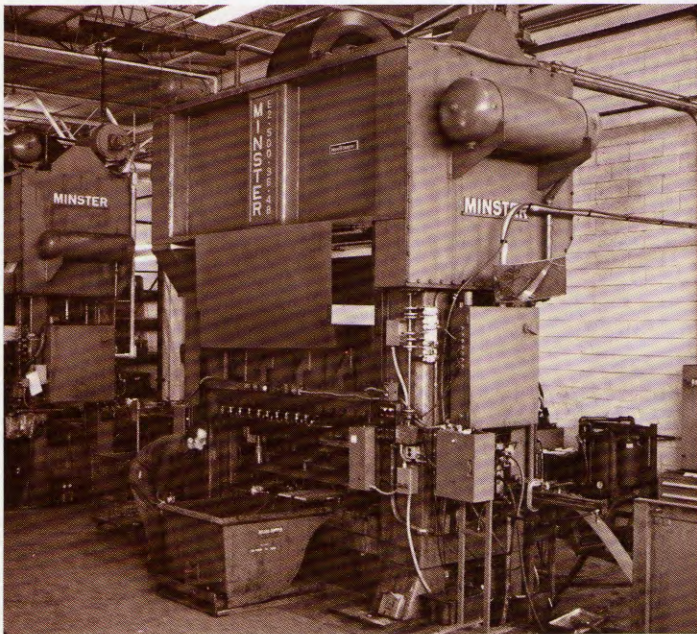
### **SIGNIFICANT SAVINGS ATTAINED WITH E2 IN MAKING DRAWER PARTITIONS**

Previously smaller presses were used to make four different parts—each formed

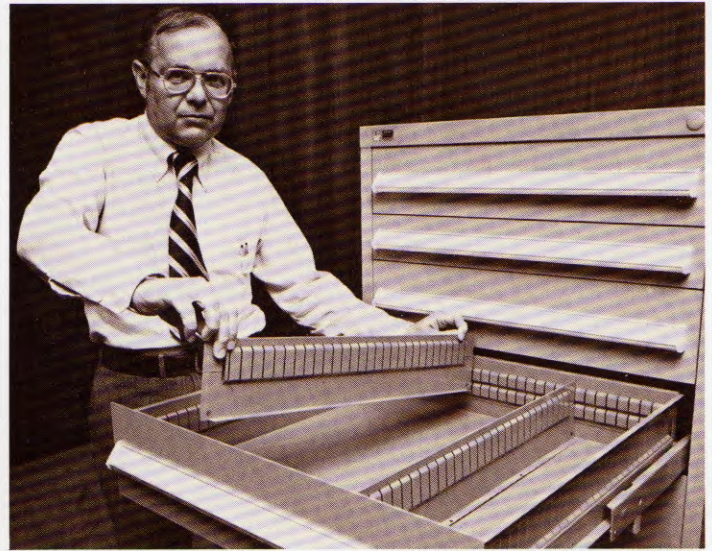
the basic configuration of an individual drawer partition size. Then, two more parts were added by spot welding and the edges had to be rolled. After assembly the partition was painted. Four different material sizes had to be inventoried.

**New Method:** With Minster E2-500 press and seven station master progressive die (seven complete sub-dies) a finished partition is completed with every press stroke. Material is pre-coated low carbon cold-rolled steel, and one standard coil can be used for all four sizes. Assembly and painting operations are eliminated and steel inventory greatly reduced. The die was designed for 12 spm but actually runs considerably faster. The variable speed feature of the E2 press provides flexibility for varying feed lengths and the ability to slow the press down for de-bugging. There's no need to build a die to match a fixed press speed.

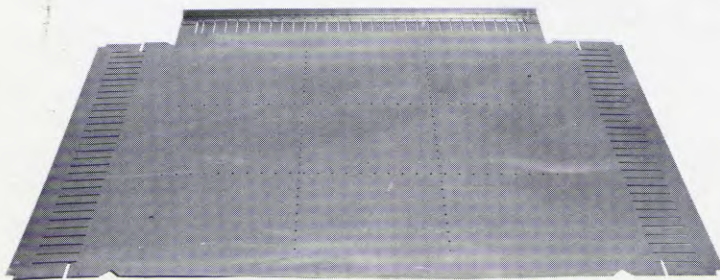




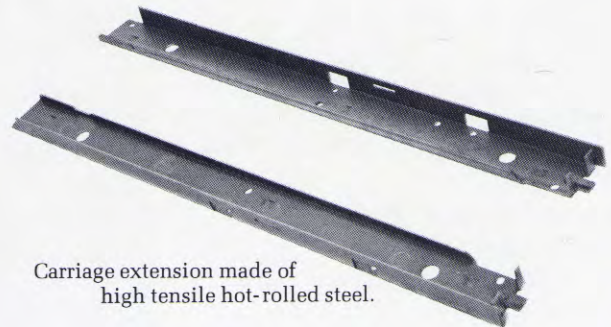
Another E2-500 is used to make partitions and carriage extensions. The E2-300 is partially shown at left.



Mr. R. F. Buchholz, Plant Manager, displays one of the cabinets used in the Stanley-Vidmar Modular Storage Drawer System. He is holding a slotted partition which is screwed to the bottom of the drawer. Stanley-Vidmar's unique Modular Storage Drawer System is in use in thousands of plants for efficient storage of parts and tools. The product line is broad, encompassing many, many styles of cabinets, benches and other components which are custom designed into a system to meet a customer's specific storage needs.



One of four drawer blank parts.

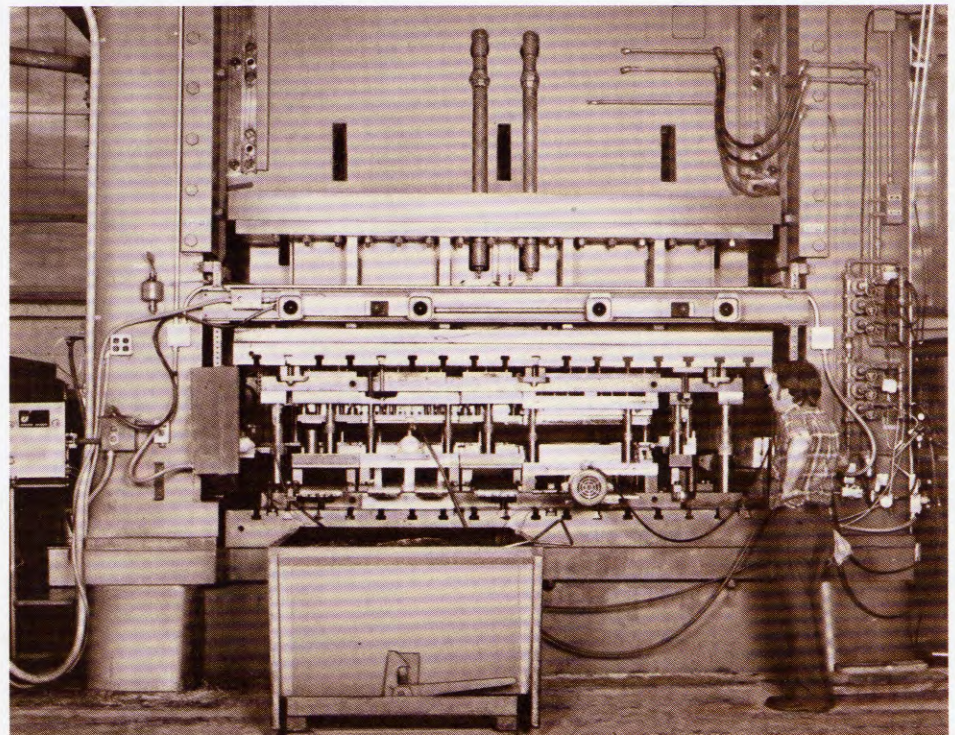


Carriage extension made of high tensile hot-rolled steel.

### LOW MAINTENANCE RECORD

Dave Belles, Manager of Engineering at Stanley-Vidmar, relates, "The E2-300 press ran for years on single stroking with progressive dies, and the worst thing we've had to do is replace worn belts and brake springs. My experience around presses tells me that you couldn't do better with anybody else's press. Even under off-center loading, ram indication stays within tolerances, and there's very little wear on gibs."

Stanley-Vidmar's experiences with the HeviStamper are the result of the continuing improvements Minster has built into the Series E2 presses over many years. The massive, structurally stable box-type framing resists deflection and allows the press to retain accuracy under the toughest load conditions. Precision slide guiding is maintained by 8 point gibbing. The Minster MonitorFlow® recirculating press lubrication system, the patented Minster Combination Air Friction Clutch and Brake are all features which contribute to customer satisfaction.



Close-up of master die and sub-dies used in newest E2-500 press.