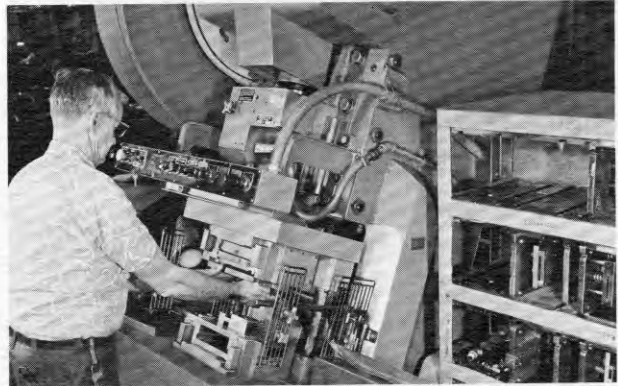


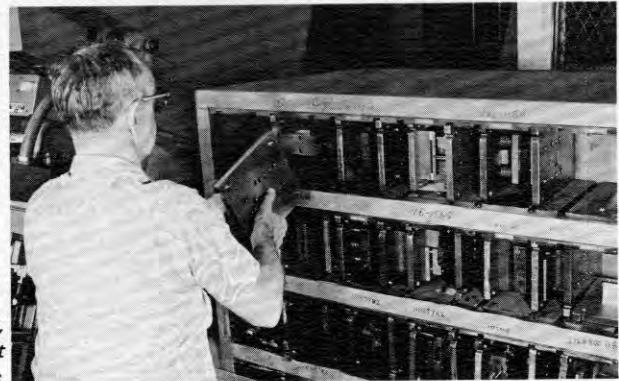
Die-Namic Process at Westinghouse Increases Press Utilization by 40%



Typical parts for Westinghouse electrical products made with Die-Namic Process.



Quick die change sequence with Die-Namic process allows operator to keep machine running without lengthy waits between part runs.



Die-Namic dies are stored in rack at press location. Convenient, compact, and space-saving, this arrangement eliminates time lost waiting for dies to be delivered to the press.

Three divisions of Westinghouse Electric Corporation at Beaver, Pennsylvania are reaping the benefits of reduced part cost and increased machine utilization provided by a Minster Die-Namic press installation.

One Die-Namic press is used to make over 100 parts for a wide variety of electrical products:

Low Voltage Breaker Division

Circuit protective devices including molded cast Circuit Breakers, Disconnect Switches, Transfer Switches and Accessories.

Control Products Division

Manual and Magnetic Starters, both open and enclosed, Electromechanical and Static Relays, Pushbuttons and Limit Switches.

Distribution Equipment Division

Bus Duct and Related Accessories.

Westinghouse currently has more than 80 Die-Namic dies purchased at about 40% less than the cost of conventional dies. Types of dies include progressive, blank, extrusion and shave types. Brass, steel, copper and beryllium, with a maximum thickness of 1/8", are used

to produce the kinds of parts illustrated here. They have the D-68 Series Die-Namic Process with a 60 ton press. The press is inclined and they use a strip stock table. Die storage is located at the right side of the press.

More Press Utilization

Changing the conventional die on a regular O.B.I. press averages about 30 minutes. With Die-Namic a die can be changed by the operator in 4 minutes, or a 26 minute savings of downtime per die change. With an average part run of 2,000 pieces, the operator has about 6 die changes a day. This totals up to 2 hrs. and 36 minutes less idle machine time per 8 hr. shift.

Figuring conservatively that at least another press hour is saved by eliminating the waiting for a die-setter, total press utilization can be at least 40% per 8 hr. shift.

Inventory Reduction

One of the important advantages of the Die-Namic installation at the Westinghouse plant in Beaver is the ability to reduce parts inventory. By being able to quickly change dies they can limit their press runs to a one month supply of parts.