



**MINSTER.**  
**IMPRESSIONS**

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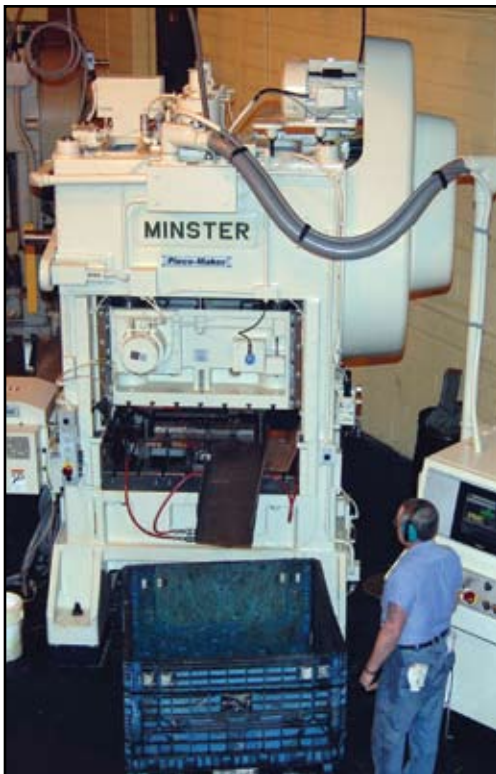
**KALIDA MANUFACTURING, INC.**  
**KALIDA, OHIO**



**Heavy Duty Building Products**

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*... Alpine Engineered Products finds Minster P2 and P2H presses the perfect tools for the challenging manufacture of metal truss plates.*



**Increasing Capabilities -- Page 11**

*... New Minster P2 presses at Allied Tool and Die have increased production and capabilities.*



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*... Minster presses are meeting the challenge of high tensile stamping at an automotive frame component supplier.*

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# Amada Press, Minster Feed, & Customer Services To Be The Focuses at Fabtech



*Amada TPL60Si Gap Frame Press.*

**T**he Minster Machine Company, a global provider of material forming solutions and services, invites you to visit us at the upcoming Fabtech International & AWS Welding Show. Visitors to the show will be able to find the Minster booth at location 19016 in the Stamping Pavilion at McCormick Place South in Chicago, IL.

The equipment highlighted in the Minster booth will be an Amada TPL60-Si mechanical gap frame press equipped with a Minster MEF2-CS-8S Servo Feed. Amada TPL Series presses feature an exclusive high energy two-stage transmission to provide the ability to run the most demanding jobs.



*McCormick Place South  
Chicago, IL  
NOVEMBER 11-14, 2007*

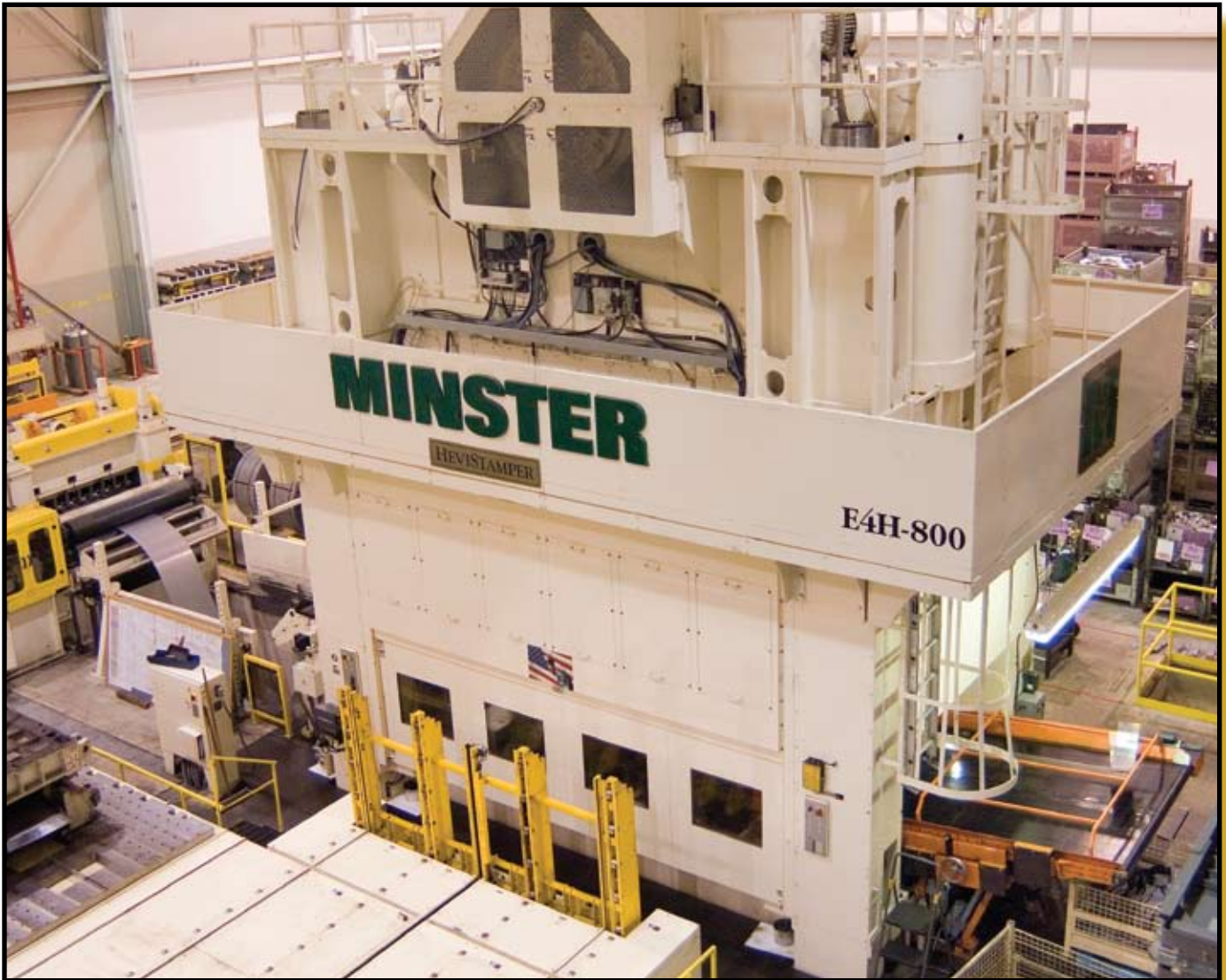
Amada's complete line of gap presses is sold and serviced exclusively in North America by The Minster Machine Company.

The Minster MEF-CS Feeds are designed with a combination of features that provide the user with the efficiency, accuracy and high reliability that is required for feeding most material up to .188" thick.



*Minster MEF2-CS-8S Servo Feed.*

In addition, Minster's full array of customer services, from spare parts, to remanufacturing, to retrofit clutches and equipment relocation will be displayed in Booth 19016. Be sure to stop by and see how Minster products and services can help you with productivity enhancements and profits.



*With a large die area, extreme accuracies, and faster speeds, a Minster E4H-800 press has increased capabilities at KMI.*

## Staying Versatile Key for Kalida Manufacturing

**W**ith four presses and close to 200 dies, versatile, reliable and quality manufacturing equipment is critical for Kalida Manufacturing, Inc. (KMI).

Located in the rural Ohio farming village of Kalida, KMI is a division of KTH Parts Industries and a world class Tier 2 automotive supplier, primarily to Honda. In addition to stamping, KMI incorporates

high tech welding technologies for complete manufacturing of automotive frame sub-components.

The presses at KMI include Minster E2H-350 and E2H-450 Hevistamper models.

“We are stamping more and more high strength steels,” KMI Vice President and Plant Manager Rick Esch said. “The ability to withstand the daily





*E2H presses help with the stamping of high tensile automotive frame components at Kalida Manufacturing, Inc.*

pounding of this high strength material while running accurately and consistently is why we went with the E2H presses.”

Since its founding in 1996, KMI has expanded five times, including the most recent addition which made room for a Minster E4H-800 four-point press. Utilizing link-driven eccentrics and other advanced design features, Minster’s new E4H series features improved rigidity, greater accuracy and higher production rates than typical four-point presses.



*Minster feed lines assist in rapid job change-overs at KMI.*

“Being able to run larger dies, and high strength coiled material were the key things we were looking for,” Esch said. “And with the Minster E4H-800 press we felt we were not limiting ourselves for the future.”

“It’s been a learning curve, but overall the E4H-800 press has done very well,” said Production Manager Bob Fish. “We’ve got some very high strength material going through that press and it’s chomping away at it with no problems. We’re running dies at 50-60 strokes per minute and still getting the accuracy and consistency we need.”

With the wide array of dies at KMI, timely and efficient tooling change-overs are important.

“With the first Minster press we tried to go with a different feed



***Small sample of automotive parts produced at KMI.***

line,” KMI Staff Engineer Bryan Niese said. “We had some issues, and ended up replacing it with a full Minster feed line. We noticed productivity gains and less downtime right away. With the full integration of the Minster feed line you can program multiple tool sets. All of the clamping information and the pre-sets to run the tool are already programmed in the Minster Production Management Control. It really made a big difference.”

Working through the installation of a new product has challenges, but Niese said the Customer Service Department at Minster responded well.

“From a service standpoint, Minster is just the best,” he said. “Whether it’s getting parts, support during off-hours, or service on the equipment, the people at Minster are just great. They are willing to work with us, and that means a lot.”



***E4H feed line includes Machine Concepts straightener.***



## Alpine Building on Success With Minster



*New manufacturing and office facilities for Alpine Engineered Products in Litchfield, Illinois.*

**A** division of Illinois Tool Works (ITW) Building Components Group, Alpine Engineered Products is a leading worldwide supplier of technology-driven products for the building component industry.

In recent years, one out of every four homes built in the United States used Alpine products. And it's a good chance those products would have included truss plates manufactured at the Alpine facility in Litchfield, Illinois.

Opened less than a year ago, the new manufacturing facility at Litchfield includes 19 Minster presses assisting in the production of metal truss plates used in the production of wood trusses for the building industry.

"We manufacture more than 250 sizes of truss plates in different gauges and strengths of steel," Plant Manager



*Minster P2H presses have helped increase production at Alpine.*



**Minster straightside presses at Alpine Engineered Products.**

Robbin Huffman said. "It is quite a challenge for us, because we have a lot of product coming through here."

Sophisticated manufacturing cells at Alpine use conveyor systems to move product out of the presses and directly into shipping containers destined for truss builders and other building component manufacturers.

"We have to keep the inventory moving, and we are very fortunate to have 19 Minster presses out there, because we need reliable equipment," Huffman said.

*"All of our straightside presses are Minsters and I wouldn't have it any other way. I've worked with different presses and I've been around different presses. With Minster the reliability is there -- no doubt about it. The engineering that goes into the Minster presses makes a big difference."*

**Tim Wirth**  
Assistant Plant Manager  
Alpine Engineered Products





Since 2004, Alpine has added five new Minster P2H presses to its manufacturing arsenal. Assistant Plant Manager Tim Wirth said the P2H presses have been instrumental in increasing production capabilities.

“We wanted the higher speed you can get with the P2H,” Wirth said. “Those presses also have a very well designed guiding system, and the fact that they are enclosed is very good for our galvanized applications.

“All of our straightside presses are Minsters and I wouldn’t have it any other way,” Wirth added. “I’ve worked with different presses and I’ve been around different presses. With Minster the reliability is there -- no doubt about it. The engineering that goes into the Minster presses makes a big difference.”

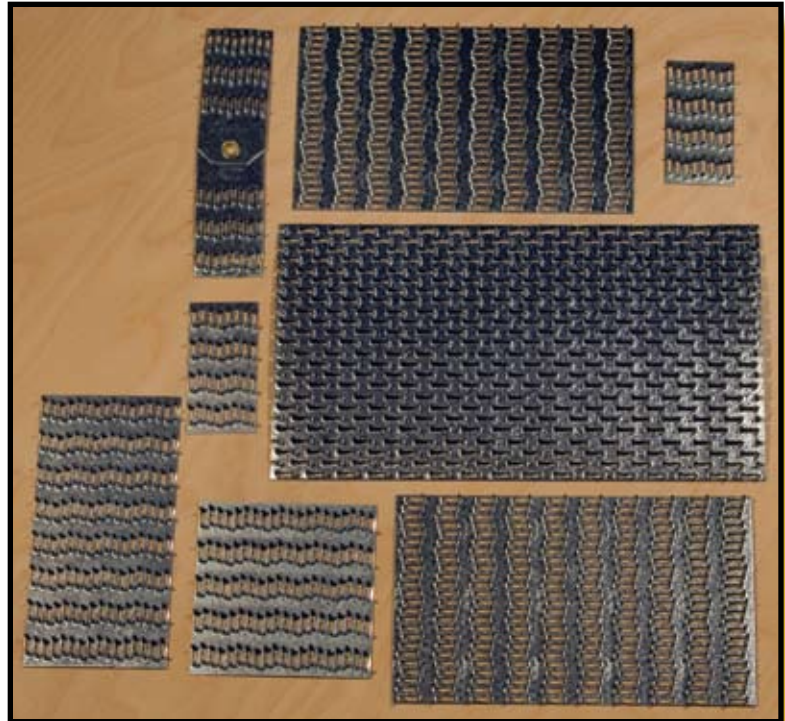


*Minster MEF2-CS bracket feeds help integrate production.*

Because Alpine produces so many different sizes of truss plates, quick and efficient tooling changes are important. Maintenance Manager John Gibb said that features on the P2H presses have saved valuable production time.

“The Quick Lift on the P2H’s is great.” Gibb said. “The time we’ve saved during tooling changes, roll changes, and clearing material jams is tremendous. It’s so nice to flip a switch and have the slide go up, and then you don’t have to worry about finding the shutheight again, because you flip the switch and it goes right back to where it should be.”

Some of the newer presses also include Minster MEF2-CS bracket mounted feeds.



“I wish all of our presses had the Minster feeds,” Maintenance Technician Bob Stratton said. “The integration and ease of use is there. Just one touch screen controls everything. The feeds are easy to work on and easy to use.”

Minster locates field service personnel regionally throughout the United States, and Huffman said she has been impressed with the response time from Minster.

“We get great support. There is a Minster service guy that lives in the area, and he always gets here right away if we need him,” she said. “In fact, sometimes a service guy just stops in to see how things are going.”

In addition to the Litchfield, IL facility, Alpine also has stamping operations in Haines City, FL and Sacramento, CA. To learn more about the products and services offered by Alpine Engineered Products, visit the company online at [www.alpeng.com](http://www.alpeng.com).



# Compact Feed Line Small on Space Big on Speed



**T**he Minster Machine Company is introducing a compact feed line designed to consolidate the functions of a three or four-piece coil line into one machine, eliminating the need for a material U-loop, and saving valuable manufacturing floor space.

The Minster Compact Feed Line (MCFL) is designed for general purpose applications at industry-leading speeds up to 250 strokes per minute without pilot release (120 strokes per minute with straightener pilot release) and feed lengths up to 30 inches. The MCFL features the exclusive Minster "Smart Technology" control and "Smart Maintenance" software.

Working in conjunction with Minster's Production Management Control, "Smart Technology" is a sophisticated control that automatically synchronizes feed speed to match the press rate and material demand, and the reel payoff to match the line speed material demand.

In addition, the "Smart Technology" control measures the strip thickness and, using the programmed material yield, establishes the initial work roll penetration

settings and provides the ability to fine tune the settings, eliminating guess work. Production information and measurements are continually provided to the operator, allowing for increased production and quick coil changes.

The "Smart Maintenance" software includes full line diagnostics, maintenance reminders and complete system and performance monitoring. Reports and diagnostics can be downloaded via Ethernet or USB, and "Smart Maintenance" can be integrated with Minster's PMConnect production monitoring software.

Standard features exclusive to Minster's MCFL include: multi-path torque distribution; drop-away lower straightener bank for pilot release; powered lower work roll adjustment; closed-loop pilot release, feed and straightener rolls; auto-set work roll penetration; coil load positioning; and more.

The MCFL is available in three standard sizes with maximum coil width at 50 inches, thickness at .375" and coil weight at 60,000 lbs.



*New Minster P2-100 with High Speed Package has increased production at Allied Tool and Die.*

## Allied Tool and Die Thrives on Heavy Metal

**S**tampings requiring unique metals and manufacturing expertise are pretty much the norm at Allied Tool and Die, Inc. in Cleveland, Ohio. More than 61 years of tooling and stamping experience has given Allied a reputation for being able to deliver the “tough job” whether it’s surgical instruments, computer equipment, automotive, or consumer products.

Allied Tool and Die President Fred Montag is continuing the work of his father Walter, who founded the company in 1946.



*Allied Tool and Die facilities located in Cleveland, Ohio.*

“Tooling was the primary focus early on, and IBM was our largest customer,” Montag said. “My father bought the first new Minster press to use as a try-out press. The people at IBM said we were making better parts than they were, so





***Minster E2-250 press is one of the “work horses” at Allied Tool and Die.***

we started running parts for them, and things took off from there.”

Initially specializing in small precision stampings and assemblies for the office machine industries, Allied has evolved into one of the industry’s experts for stamping products from high-strength spring, stainless, and a variety of other non-ferrous and non-typical materials.

“All of our straight side presses are Minsters, and it is the precision of the Minster presses that allows us to offer such a complete and unique product offering,” Montag said. “We not only strive to tackle all of the tough material jobs, but we also offer many value-added services like special coatings, heat treating and assembly. We want to be a one stop shop for our customers.”

Allied recently expanded its capabilities with some high volume jobs, and in order to meet customer demands, Montag ordered a Minster P2-100 press to complement the three existing P2-100s, along with three Minster E2 Hevistamper presses and other P2 presses ranging from 60 to 250 tons. The



***A small sample of parts that are produced at Allied Tool and Die.***



***The Minster MEF2-CS Feed with Pull Thru Straightener at Allied Tool and Die rates at a maximum roll lift rate of 425 strokes per minute.***

newest P2 press features Minster's High Speed Package, with a bracket mounted Minster MEF2-CS feed and pull-thru straightener. The feed is also equipped with the High Speed Package.

"The High Speed Package added 100 strokes per minute, but the load monitor, auto shutheight, auto counterbalance and PMC Control also helped increase our production," Montag said. "With the PMC, all of the press and feed settings are integrated. Our set-up time dropped by more than half with the press controls and features of our new P2 Press."

Shortly after taking delivery of the New P2-100 press system, Montag ordered another identical press and feed line.

"We've built our business around the Minster presses," Montag said. "From our first Minster press to the new

straightsides we have the tools to compete in a very competitive market by offering quick delivery and quality products and services."

"We have to deal with zero lead time, so any down time is a thing of the past," he added. "We depend on our Minster presses to run, and run, and run. And I can't say enough about Minster's service. We needed a part on one of our older presses, and it was here the next day -- unbelievable."

To learn more about impressive manufacturing capabilities of Allied Tool and Die, visit the company online at [www.alliedtool-die.com](http://www.alliedtool-die.com).



***Allied Tool and Die builds and maintains tooling for all it jobs.***



# Knowledge is Power ... and Productivity

## Training an Investment That Pays Off

**E**mpowering employees with the knowledge to do their jobs more efficiently and effectively can pay dividends on many fronts.

The Minster Machine Company offers several value-added training programs designed to meet the specific needs of each customer.

“There can be a lot of turnover in stamping plants, and when you’re hiring new employees training becomes an important tool,” said Minster Training Coordinator Rob Meyer.

“Our training is all about optimizing and increasing efficiencies,” Meyer added. “There’s a lot more to running a press than pushing buttons and boxing parts. We focus on things like the proper feed angle, proper positioning of the tool on the bolster, and die protection.”

“We can train operators on optimizing production speeds, which sometimes means slowing a job down to prevent constant die crashes,” Meyer said.

Minster also offers popular preventative maintenance programs.

“Our maintenance training focuses on increasing the longevity of equipment and avoiding unplanned downtime,” Meyer said. “It’s very competitive out there, and if equipment is



**Minster Training Coordinator Rob Meyer (left) shows functions of the Production Management Control.**

not properly maintained, downtime can be catastrophic.”

Minster offers regularly scheduled training programs, new equipment start-up training, and hands-on training. Training programs can be customized to the specific needs of a customer and are offered on-site or at Minster’s Customer Education Center.

To discuss training needs or to get a training quote, contact Rob Meyer at 419-628-6000 or email him at [training@minster.com](mailto:training@minster.com).

# HIGH TENSILE APPETITE

The Minster E2H press series has no equal when it comes to the features that make it the ideal choice for stamping high strength materials.



High tensile strength steels have become the material of choice for automotive designers. These materials present a unique challenge for stampers and equipment manufacturers. See for yourself how Minster has met the challenge ...

- **40% Reverse Load (Snap-Thru) Rating:**  
2 to 4 times greater than a standard press.
- **Increased Vibration Dampening:**  
~ At least 15% more overall mass than all other presses.  
~ Cast Iron major frame components.
- **"Zero- Free Clearance" Bearings and Drive System**
- **Increased Speeds:**  
Faster than other presses ~ no exceptions.
- **Alternative Slide Motion**
- **Quick Lift Slide:**  
Only available from Minster.
- **Infinitely Adjustable Stroke:**  
Only available from Minster.

**Consult Minster for additional features and benefits exclusive to the E2H press.**



Patented Hydraulic Clutch & Brake for maximum torque and faster starting and stopping.

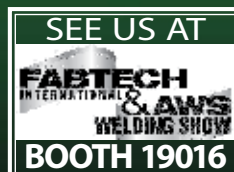


"Zero-Free Clearance" Oil Film Bearings for reduced wear and greater accuracy.



Full-Featured Minster Production Management Control incorporates all press functions.

[www.minster.com](http://www.minster.com)



**MINSTER**  
THE MINSTER MACHINE COMPANY

*A Century of Heritage Pressed Into  
a Lifetime of Quality*