

# The Minster 210 Gives Component Technologies, Inc. "Economical Access to High Speed"

Component Technologies, Inc., Painesville, Ohio, produces electronic connectors, performing not only stamping but also injection molding and plating.

The company was created in January, 1980, when an existing stamping & molding department became a division of Associated Enterprises, Inc. In 1983, Component Technologies was incorporated as a separate company.

Prior to 1980, the company was running connector stampings on five 32-ton gap presses at 360 strokes-per-minute, producing an average of 8 million parts a month. Early in 1980, straightside presses were installed which upped production speed to 600 spm . . . eventually increasing to 1000 spm. Today

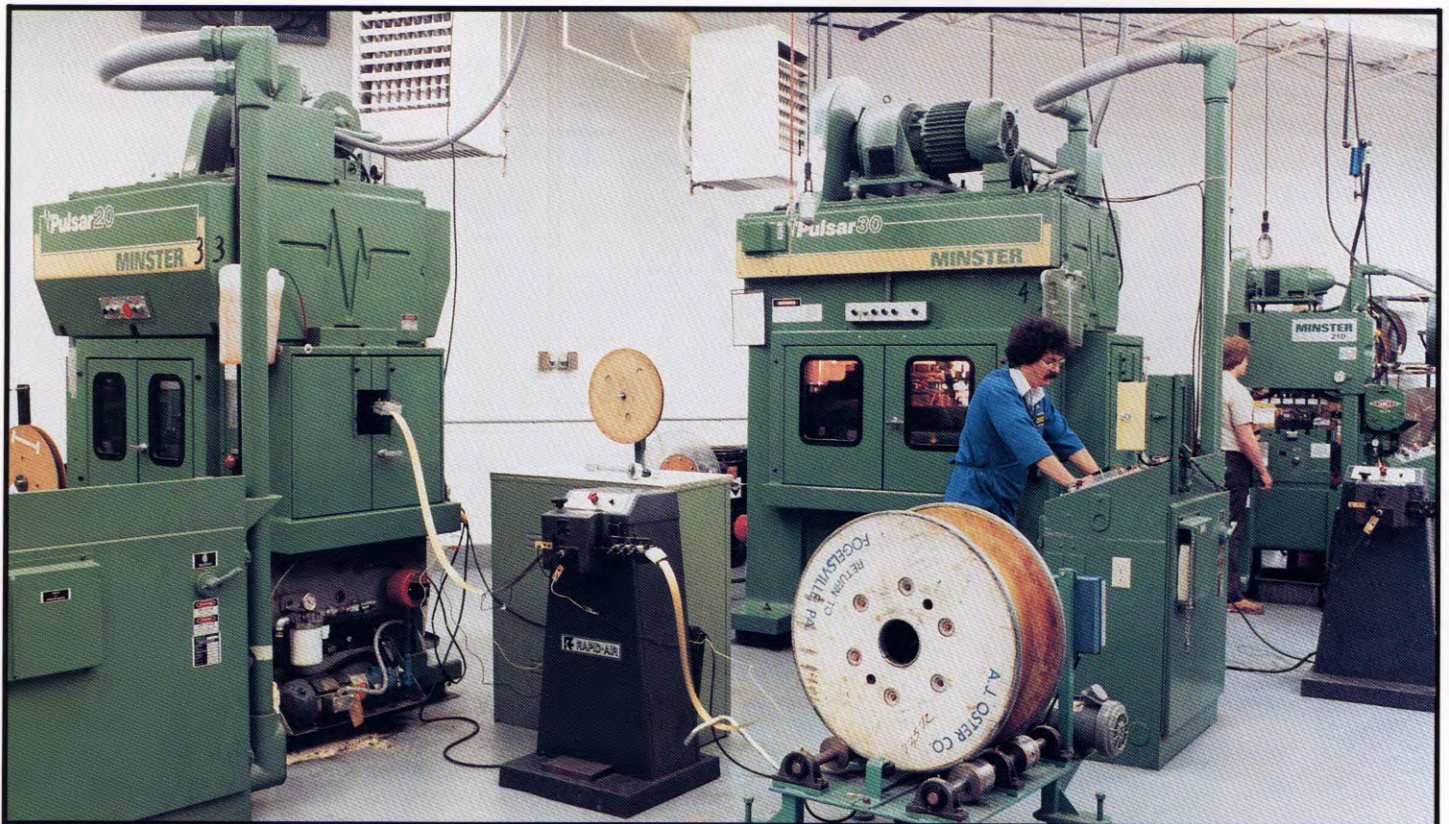
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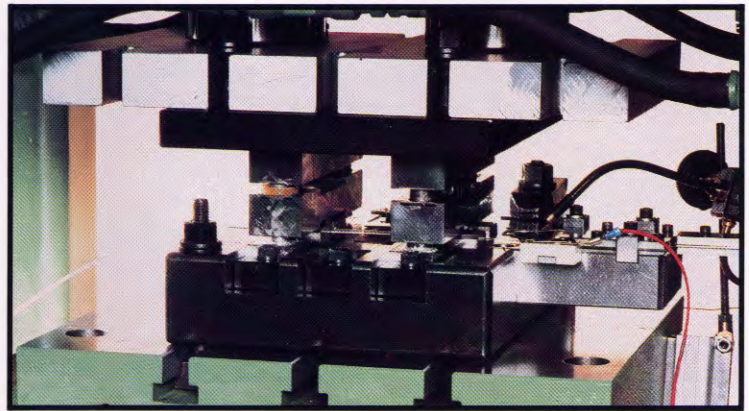
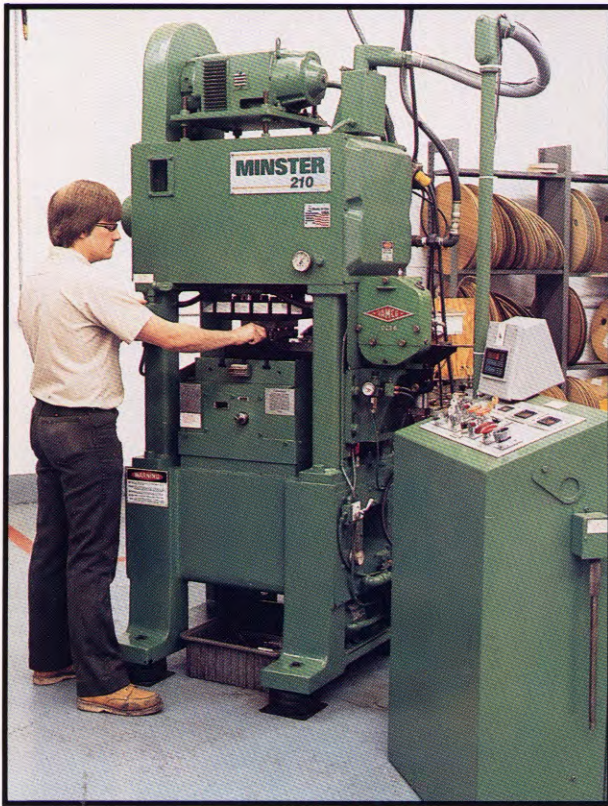
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Component Technologies is making stampings at up to 1600 spm (Minster Pulsar 20 with a 1" stroke). That's nearly a 450% increase since the beginning of 1980.

The association between Component Technologies and Minster began in 1983 when the company again sought to upgrade the capability of their stamping operation. Four press builders were under consideration for new equipment. Increased running speed was an objective . . . but not the only one. Says Component Technologies' operations manager



Three high speed Minster presses occupy the production bay at Component Technologies' Painesville, OH, plant.



*Minster 210 and Component Technologies' modular tooling concepts have combined to meet the challenging demands of the connector stamping market.*

Bob Campbell, "Speed is impressive, but it's not the only factor. Accuracy, deflection and guiding are all very important."

In investigating the products of the four press builders in question, Bob Campbell relates that all four could offer high speed, but Minster's retractable bolster won us over. With it we can troubleshoot a die at the time a problem occurs, by looking into the die while it's still in the press, with the strip in place.

In November, 1983, Component Technologies took delivery of a new 30-ton Pulsar. Rick Nasca, the company's lead man in the stamping department, remembers what happened shortly after the Pulsar was delivered. "We had a high-demand (ten million parts every six weeks) carbide die from which we needed maximum production. We put that die in the Pulsar 30 and ran at 1400 spm for 45 million hits without a problem."

By the following December, a Pulsar 20 was installed, and it too was quickly put to the test. "We ran that press at 1600 spm for nine consecutive 24-hour days," says Bob Campbell, "and it never hesitated to perform."

In 1985, Minster approached Component Technologies about being one of a limited number of test sites for a new 10-ton machine. The objective was to install the new press in a production environment for six months and measure its performance. The company agreed to participate, and in June, 1985, a Minster "210" was installed.

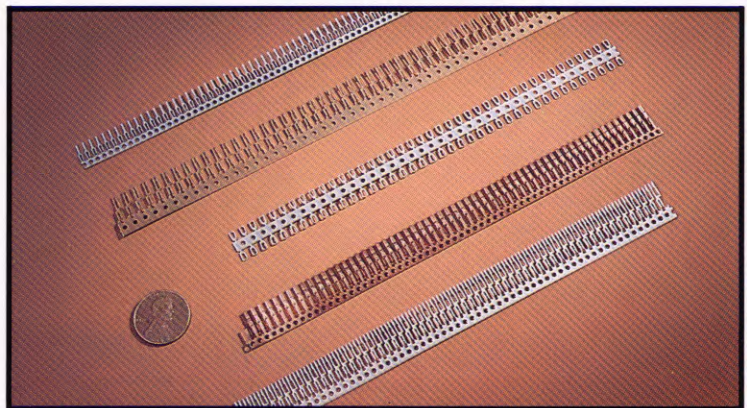
"We liked the concept of the 210 press from the start," says Component Technologies president Scott Humphrey. "The 210 gives us the press speed, tonnage and die area we needed at an economical price."

At the same time the 210 was under test, another development was taking place at Component Technologies' research and development area in Pittsfield, PA. "We were seeing the size of connector stampings become smaller and smaller," says die engineer Bob Coons. "Even with a two-up die, the tonnage requirement was minimal." As a result, a unique modular stamping die design was developed to better fit the changing demands.

The marriage of this new tooling concept and the Minster 210 proved to be a good match. Today, Component Technologies runs a 210 in Painsville and another at the Pittsfield research area.

Bob Coons feels it was "Minster's willingness to work with us that made the project a winner. The technical information and vibration analysis testing they provided prevented us from having problems. We might otherwise have gotten there eventually but not nearly as fast."

The modular tooling concept and the Minster 210 are an unqualified success at Component Technologies, producing intricate connector stampings at high speeds, three shifts a day . . . an example of builder and user working together to create a combination of press and tooling to meet new demands.



*These connector stampings are produced by Component Technologies on a Minster 210.*