



*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.*