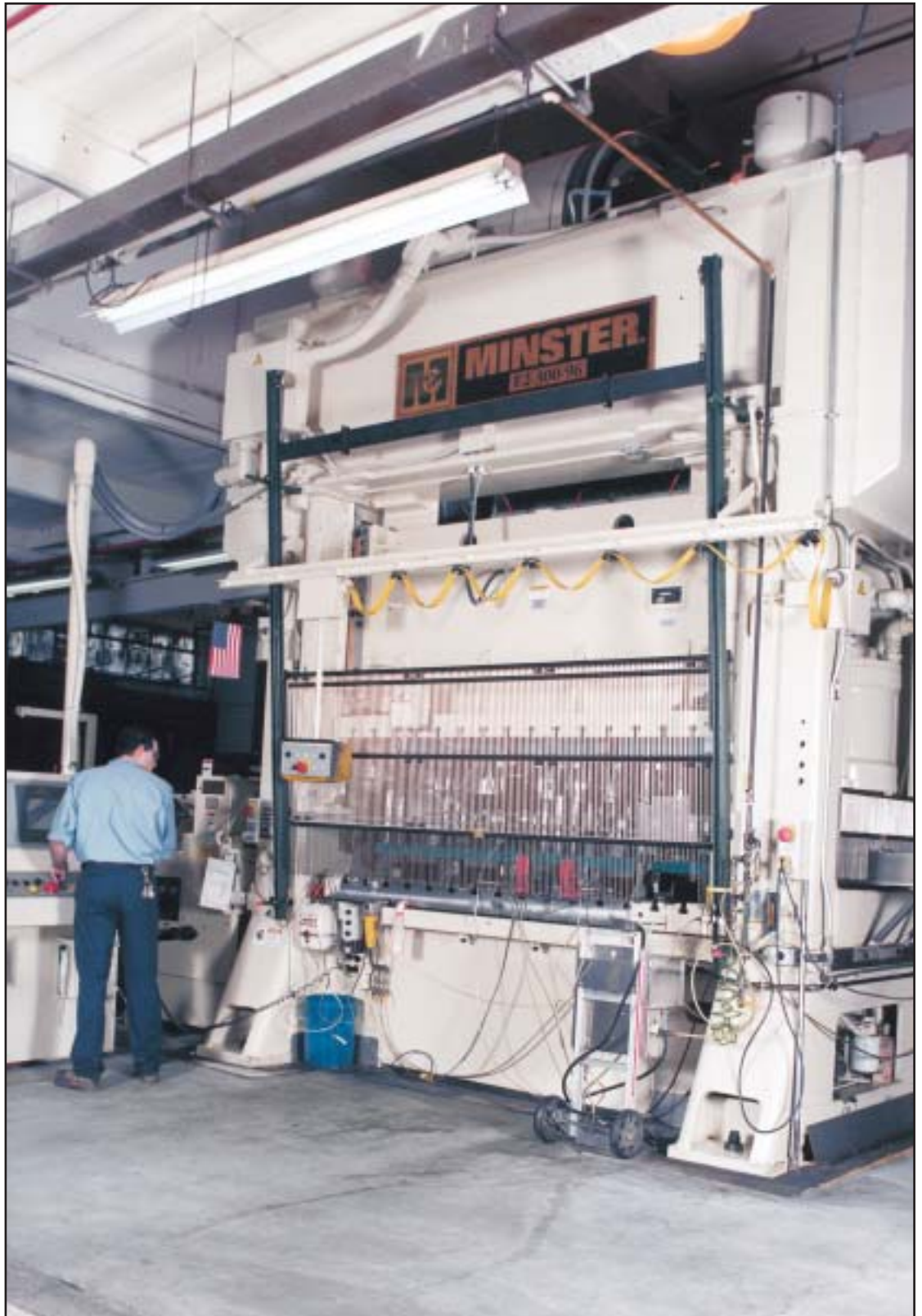


Larson Tool and Stamping Increases Productivity With Minster's ASM Drive

For more than 80 years, Larson Tool and Stamping has been manufacturing high quality metal stampings and assemblies. Located in Attleboro, Massachusetts, the family-owned business has combined creative engineering and innovative manufacturing techniques to attract a diverse customer base in the Northeast.

“We consider ourselves a medium-sized contract stamper,” said Larson Tool and Stamping President Dan Larson. “If you can hold it in one hand and feel some weight, we’re interested in it.”

Numerous hydraulic, mechanical and transfer presses at Larsons reflect the company’s diverse capabilities. Until recently the tonnage range of the mechanical presses was 22 to 200 tons. However, working with stainless steel drawing



A Minster E2-300 Press equipped with ASM drive at Larson Tool and Stamping in Attleboro, MA.



A complete Minster coil line, including a double reel, straightener and feed, are integrated through Minster's Production Management Control (PMC) to optimize productivity at Larson Tool and Stamping.

applications, the decision was made to increase tonnage capacity at Larsons.

"We decided to go with the 300 ton Minster, and that was a big jump for us," said Vice President of manufacturing Charles Cederberg.

Larsons installed an E2-300 equipped with Minster's Alternative Slide Motion (ASM) drive and an integrated Minster material handling line

with Minster's Production Management Control.

Designed to provide reduced slide velocity with acceleration and deceleration of the crank rotation within the same stroke, Minster's ASM proved to be just what Larsons needed to increase production.

"We've eliminated a lot of downtime for tooling work. I would say with the Minster press our die life has increased by three times and our production is up 100 percent. One particular job we were running at 28 to 30 strokes per minute has increased to 54 to 60 strokes per minute on the Minster press."

Charles Cederberg
*Vice President of Manufacturing
 Larson Tool and Stamping*

"Minster's link drive really boosted our production rates," Tooling Manager Raymond Niquette said. "We are able to maintain the draw speed and still produce parts at a higher rate. Another big difference is



A sample of some the the parts being produced at Larson Tool and Stamping.

in die wear. Before, we were always chipping dies with these jobs. On the Minster press there is a big difference. Die life has improved dramatically.”

“We’ve eliminated a lot of downtime for tooling work.” Cederberg added. “I would say with the Minster press our die life has increased by three times and our production is up 100 percent. One particular job we were running at 28 to 30 strokes per minute has increased to 54 to 60 strokes per minute on the Minster press.”

Cederberg said another unsuspected surprise has been the reduction up die lubrication.

“Before we were using 15 gallons of oil for 80,000 parts. Now, on the Minster press, we’re using two or three gallons,

” he said. “With Minster’s ASM drive we are able to get the draw speed down to produce better parts without sacrificing the speed of the overall stroke.”

Controlled by Minster’s PMC, the E2-300 at Larson Tool and Stamping operates in coordination with a Minster Coil Line.

“The system has really been efficient,”

Cederberg said.

“You program in the tool number at the control and the straightener and everything makes the proper adjustments for that particular job.

The double reel has also been

very beneficial. We’ve seen some real productivity gains.

“With the die protection and all of the monitoring done by the control, we are able to run the press unattended,” Cederberg continued. “While the press is running, the operator can be setting up a coil or getting oil ready. He can even go to lunch now and leave the press running.”

“My first experience with Minster was eight years ago,” Dan Larson said. “We purchased a press with a 32-inch bed for a blanking job. “I was impressed with how that press handled the snap thru and how much the die life improved.

“Our new Minster press has allowed us to make productivity gains and retain business,” he added. “Excellent repeatability on the press has allowed us to run with zero defects. And we don’t have any late problems... I have to say that the system on the Minster press has fulfilled my every dream.”

Larson Tool & Stamping



90 Olive Street
P.O. Box 2970
Attleboro, MA 02703-0970
Tel: 508-222-0897
Fax: 508-226-7407

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www.larsontool.com