

SIGNODE Kentucky Averages Millions of metal clips per week with Automated B1 Press Line



Ten B1 presses in unusual automated line at Signode Corporation.

Signode Corporation, the major producer of steel strapping and strapping machines for packaging operations, has approximately sixty Minster B1 High Speed Gap presses. These presses, located at Signode plants in Kentucky, Maryland, Illinois and in Australia and Belgium, produce spring and steel strapping clips. Let's take a look at the unusual and highly automated press installation at their Florence, Kentucky, plant where ten Minster B1's make spring fastener clips for the Paslode Division of Signode.

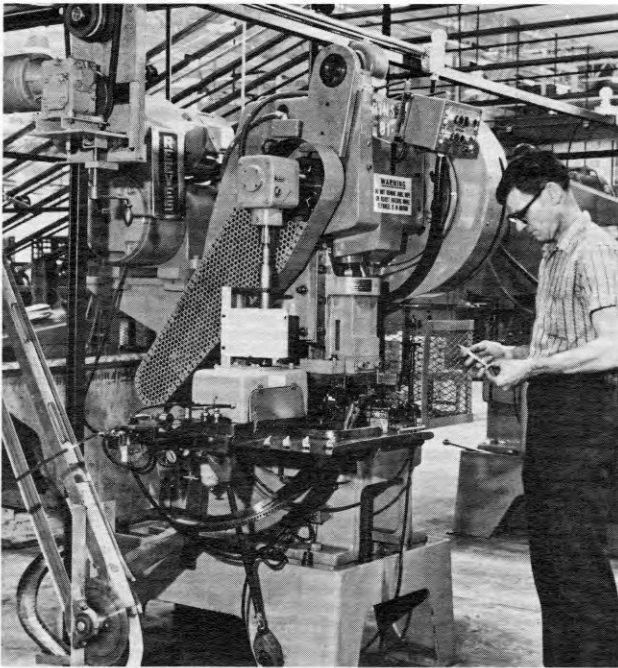
The Part

Paslode markets power tools and clips used for spring assemblies in the automotive seat, mattress and furniture industries. Sticks of clips are magazine-fed in a Paslode Air Power Clipper. The metal clips are stamped from .042" thick x .875" wide steel, in "sticks" (similar to paper staples). The individual clips, produced at high

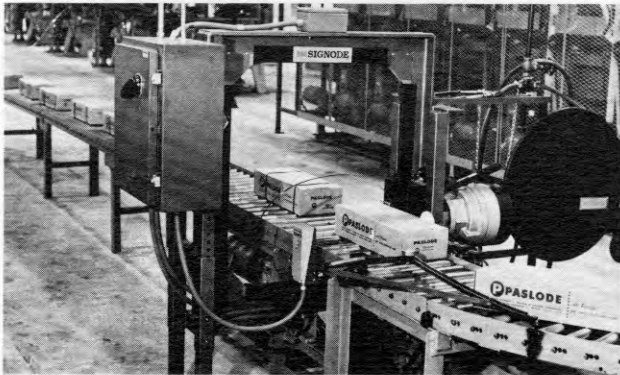
speed, are held together in the sticks by a tiny nib and recess stamped into each clip as it is formed in highly sophisticated progressive dies.

Press Line is Highly Automated

At Signode's Florence, Kentucky, plant, the "Nib and Recess" department has a line of ten Minster B1-22 presses arranged with five presses on the right facing the outgoing end of the line and five facing in reverse direction, with an aisle between. All coil stock is fed from low level, horizontal reels outside of each line. Conveyors running from each press carry sticks of clips to packing tables where they are manually packed in cartons. Two men act as combination die-setters, operators, inspectors and coil loaders and are responsible for all ten presses. A third man can handle all the packing when six or seven presses are running at once, thus, unless all ten presses are running, three men handle the entire line from coil to package.



Close-up of one press. Note feed and conveyor system.



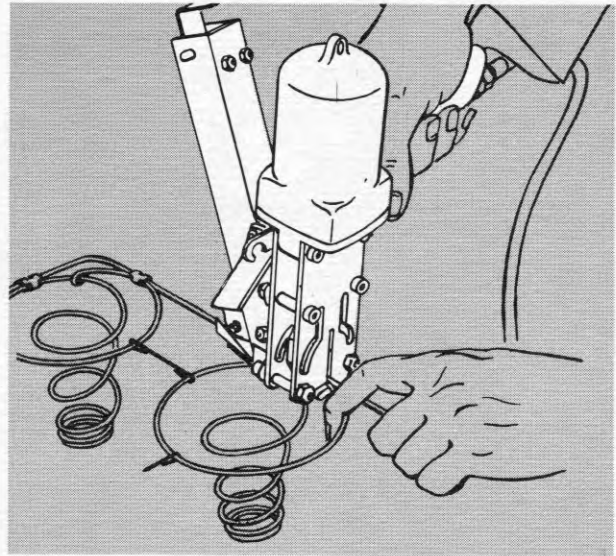
Cartons of Paslode clips are steel-strapped on . . . you guessed it . . . a Signode strapping machine.

Reason Why B1 Presses Are Used

High speed stamping of this type where the close tolerance of the "nib and recess" is so important requires absolute press rigidity and stability. The Minster B1's have exactly that. They provide reliable performance at high speed. They are more sturdily built than other presses and Mr. J. P. How, plant manager reports, "Maintenance or problems with the presses themselves are a rarity."

Each B1 press in this automated installation is equipped with Signode-designed and installed electrical controls, dies and special parts handling equipment. Feeds are rotary shaft-driven slide type.

Chances are excellent that you have Signode clips in your car and furniture. Take a look at your artificial pine Christmas tree, too. It may also be held together with Signode clips, painted green.



Application of clips is by Paslode Air Power Clipper.



Metal clips are produced in "sticks".