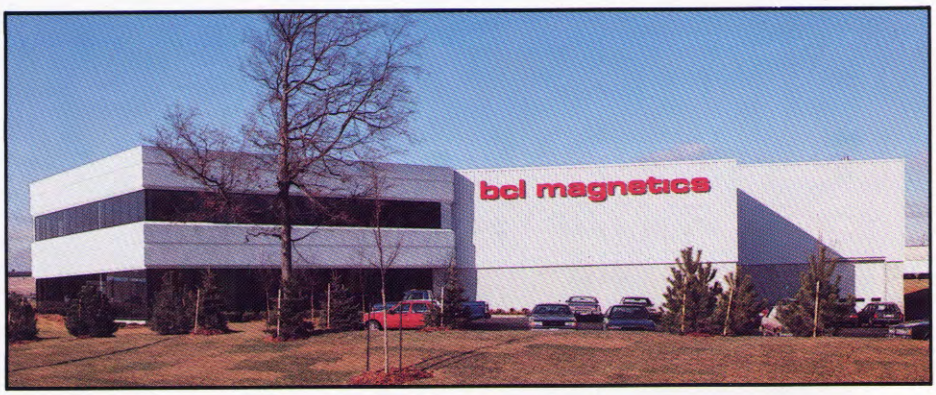
On the *FAST TRACK* in Laminations

"When we buy a press, we intend to be running that machine for at least twenty years. From what I've seen of Minster presses, I don't foresee that being a problem."

Ed Muzak
Plant Manager, BCL Magnetics, Ltd.



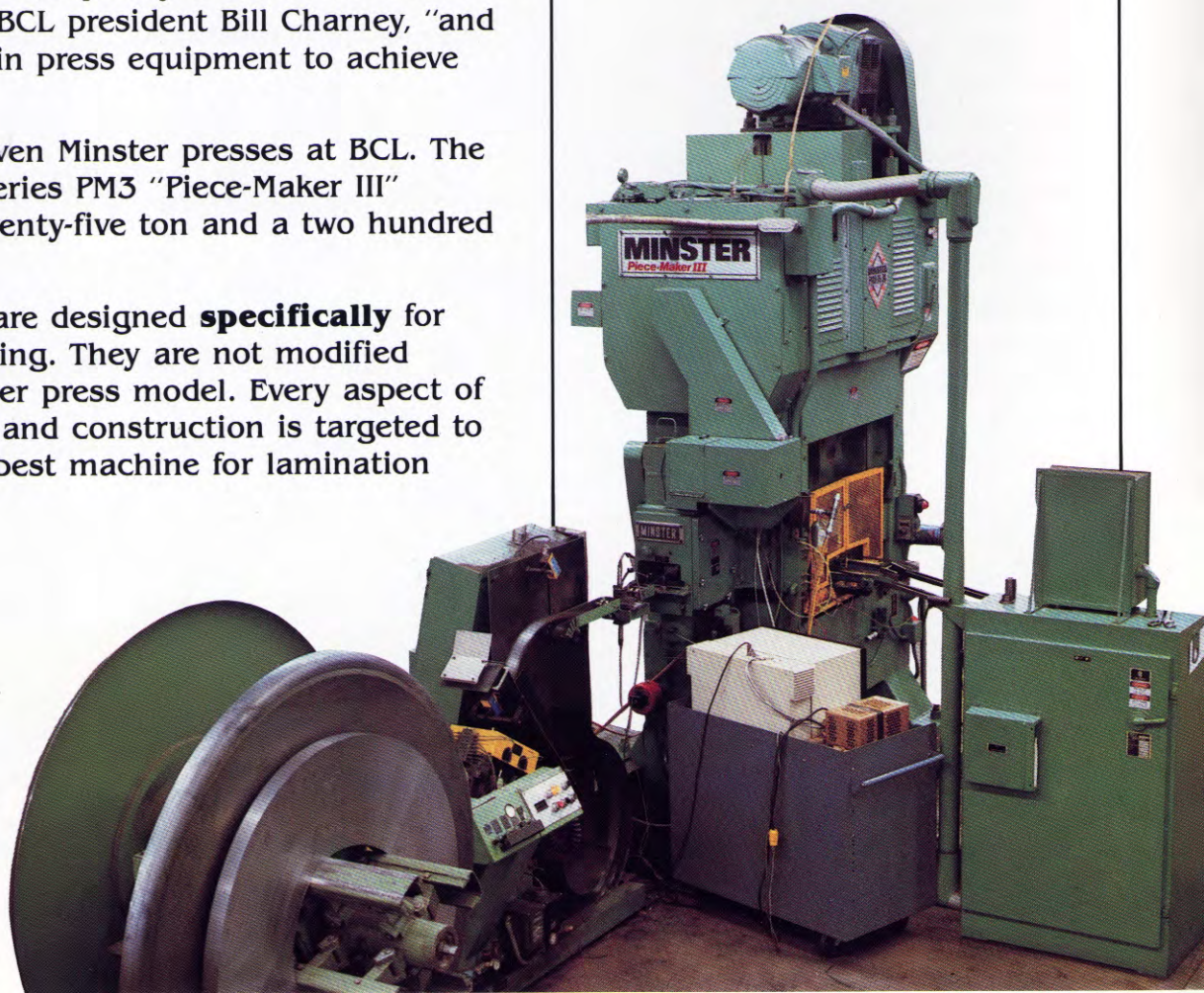
BCL Magnetics, Ltd., in Burlington, Ontario, Canada, is the largest lamination producer in Canada and the fastest growing in North America, seeing sales increase more than 3000% over the past ten years.

Their experience with Minster dates back to the beginnings of the company in 1976 when BCL purchased a high speed, sixty-ton Minster "Hummingbird." That press continues to produce laminations today . . . five days a week, twenty-four hours a day. "Our success has come from supplying the best in quality and service to our customers," says BCL president Bill Charney, "and it takes the best in press equipment to achieve that."

There are now seven Minster presses at BCL. The two newest are Series PM3 "Piece-Maker III" presses . . . a seventy-five ton and a two hundred ton machine.

These machines are designed **specifically** for high speed blanking. They are not modified versions of another press model. Every aspect of the PM3's design and construction is targeted to provide the very best machine for lamination production.

"This is a very sound, high quality piece of equipment," says Ed Muzak of the PM3. "It's like driving a fine automobile. That's the feeling I get when I'm around the PM3s."



In-die staking is performed routinely on this 75-ton PM3 at speeds up to 500 strokes-per-minute.

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BCL's PM3-75 typically produces staked lamination stacks in the die at up to 500 strokes-per-minute. Control of depth penetration and bottom-of-stroke consistency are critical in assuring a tightly held stack. Slide-to-bed parallelism is also very important, for example, in producing a rotor stack with a center hole that is in square. The PM3 delivers.

Loose laminations are produced on the PM3-200 at speeds of up to 600 spm. This can require feeding rates of up to 3700 inches-per-minute.

For the best performance under these demanding conditions, BCL chose to combine Minster "S-Loop" coil handling systems and Minster Cam Feeds with their PM3 machines. "I wouldn't buy a Minster lamination press without that feed on it," Muzak confides. "If you have a problem with a job that's been running, one thing you know for sure is that it's not the feed. The Cam Feed is accurate and consistent throughout the speed range."

BCL produces loose laminations on this PM3-200 at up to 600 strokes-per-minute. A Minster Cam Feed and "S-Loop" handling system (background) supply material accurately to the press at up to 3700 inches-per-minute.

BCL asks a lot from their equipment, but in the lamination business, that's to be expected. "We're in a very competitive field," says production manager Larry Anderson. "For us, downtime is just too expensive to allow. Our Minsters have proven very reliable, and that counts for a lot."