

Minster lamination presses run at top speed 24 hours a day at A.O. Smith motor plant

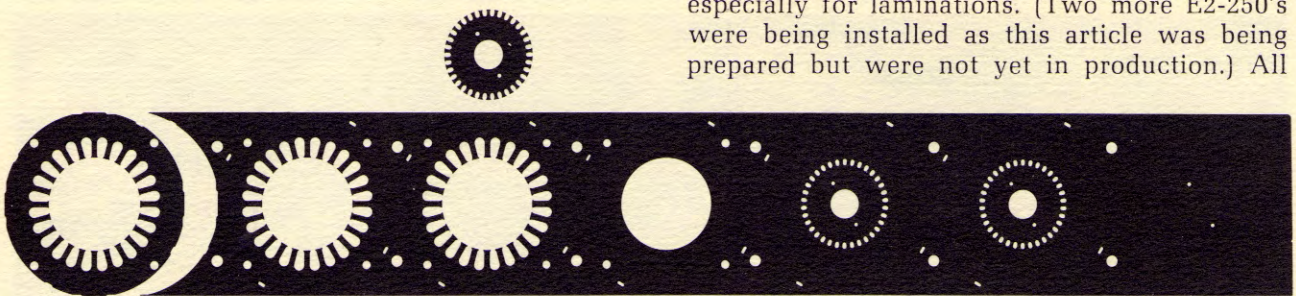
The men who purchase equipment for the Mt. Sterling, Kentucky, electric motor plant of A. O. Smith Corporation have several reasons for standardizing on Minster presses for their lamination production. One major reason is "dependability"; the fact that they can run their Minster presses at full capacity and top speed for three shifts, five days a week.

This plant, employing from 1000 to 1200 people in a 250,000 sq. ft. production area, has an enviable record for growth, productivity and safety.

The plant manufactures basic hermetic motors for room and central air-conditioning equipment. Over 9,000 motors ranging in size from 1/2 hp to 5 hp, are normally produced each day. With one exception, the motors are supplied as finished rotor and stator units ready for mounting in the customer's product. They also produce a complete 1/2 hp motor for a dishwasher.

DAILY LAMINATION PRODUCTION IN THE MILLIONS

The motor lamination production line at this A. O. Smith plant is comprised of a Minster 200 ton capacity P2 Piece-Maker[®] press, the first lamination press to be installed here, and five 250 ton capacity E2 HeviStamper[®] presses built especially for laminations. (Two more E2-250's were being installed as this article was being prepared but were not yet in production.) All



Lamination press line at A. O. Smith. Press in foreground is in process of installation.

presses are equipped with roller cam driven fixed feed length feeds. Carbide progressive dies are used to produce one rotor and one stator per stroke.

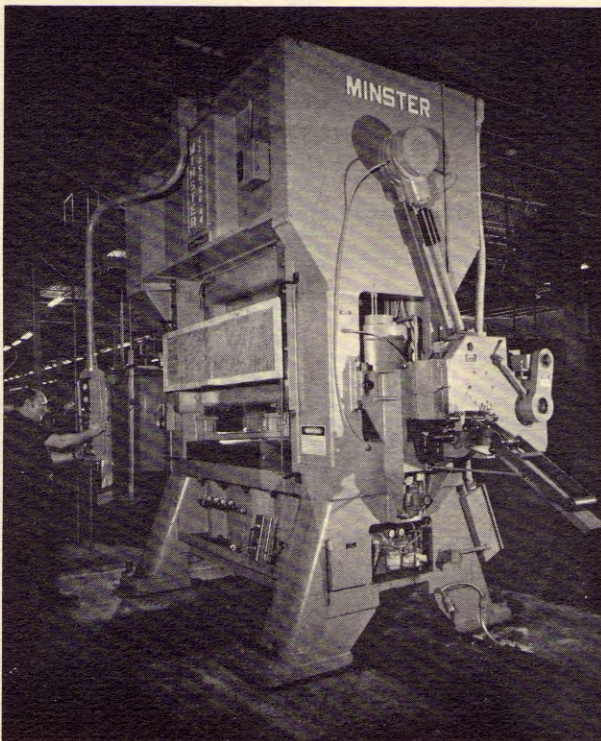
All six of the Minster presses are high speed (125 to 250 spm) machines and they run at top speed on electrical cold rolled or silicon steel day in and day out. An average daily production is about one and a half million sets of rotor and stator laminations or a total of 3 million pieces.

The A. O. Smith production staff obviously knows how to equip and operate a lamination press room. For example, they use single reels, yet have developed a technique for "quick changing" coils so elapsed time between the end of a coil and production on a new coil is about 45 seconds.

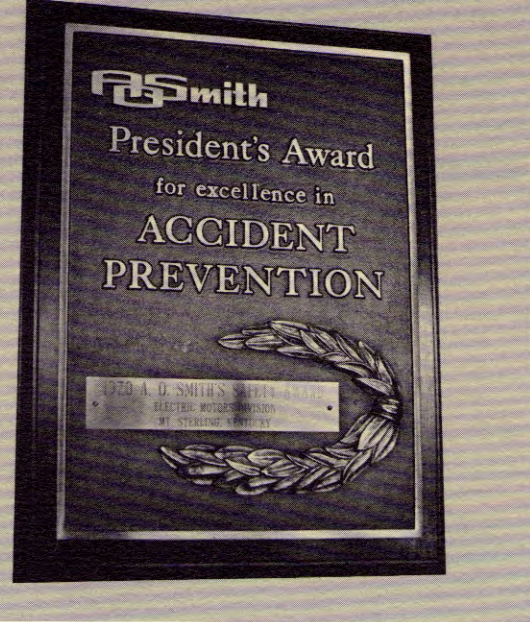
WHY A. O. SMITH BUYS MINSTER PRESSES

Mr. Sam Von Krosigk, Manager of Manufacturing Engineering at the Mt. Sterling plant, is emphatic on reasons for the selection of Minster presses. He says, "Dependability is a real factor. Service in production is very fine. The presses take a good beating well."

Regarding the dependability factor, Norm Maggard, Manufacturing Engineer said, "We can't afford to have them down. Very rarely do we have downtime and seldom is it due to a press."



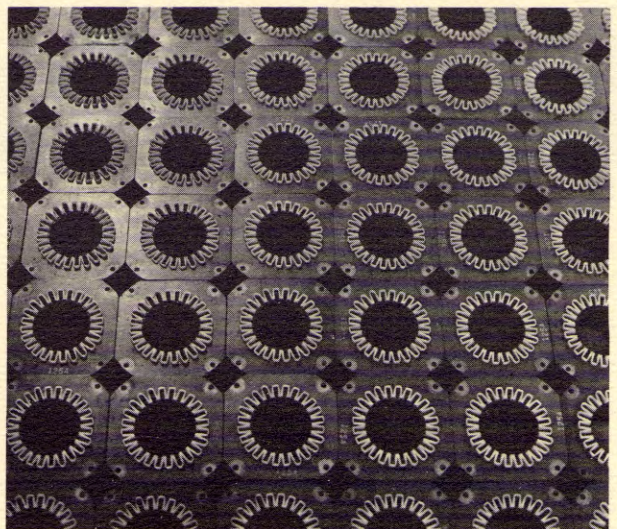
Minster E2-250-60-42 HeviStamper lamination press is being installed. It is one of two brand new presses put in during May 1971. This is an example of forward planning for future growth typical of this plant. Note solidity and mass of the E2 design. It has all the construction features needed for high speed lamination work.



This large engraved plaque in the plant lobby is the "Presidents Safety Award," highest award in the A. O. Smith Corporation. It was won by the Mt. Sterling motor plant in 1970 for a record of over 2.0 million man hours worked without a disabling accident.



Norm Maggard, Manufacturing Engineer, left, and Al Tufono, Maintenance Superintendent, check press installation progress.



Core bonded stator lamination stacks ready for winding.