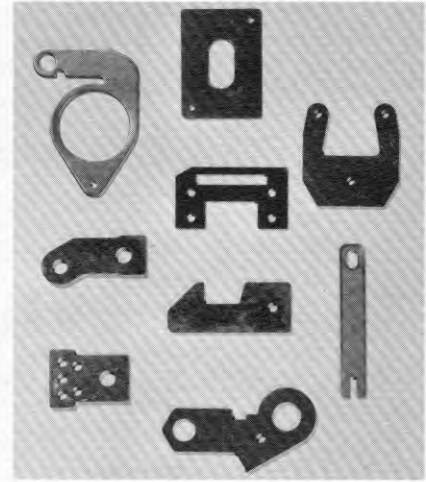
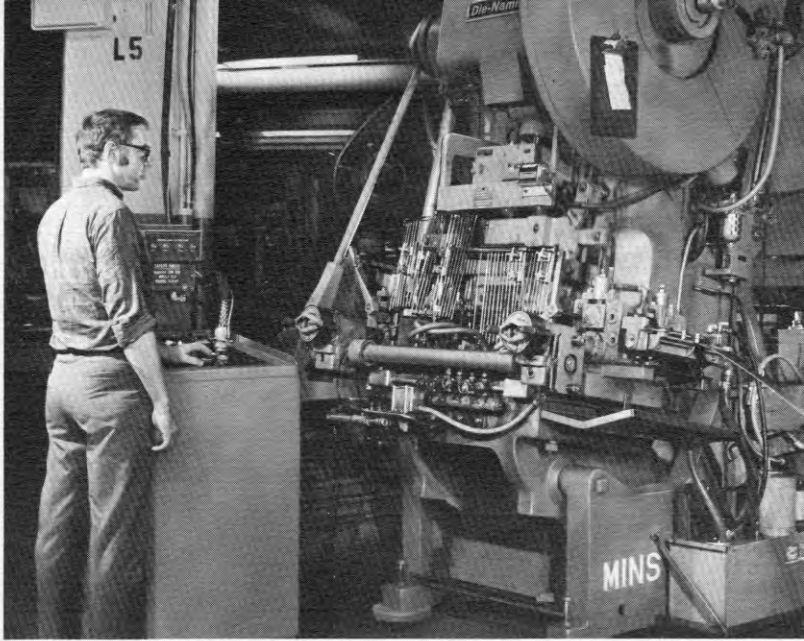


# ***Allen-Bradley uses Die-Namic Process to Lower Cost of Motor Control Parts***





The fast die change of the Die-Namic Process has lowered the cost of stampings for short run setups at Allen-Bradley Company, Milwaukee, Wisconsin, producer of industrial controls. Cost savings come from higher press productivity, reduced parts inventory and less expensive dies. Growth in the number of electric industrial controls and electronic components manufactured caused the need for a wide variety of parts in limited quantity. Die-Namic proved to be the answer.

### Automatic Die-Namic Production

For primary part runs ranging up to 10,000 to 15,000 Allen-Bradley uses a Minster No. 6 Die-Namic press equipped with a double roll feed for feeding coil stock. The press speed ranges to 180 spm. Two step compound dies are used to produce parts from steel, brass and copper. The feed is designed to handle stock up to .093" thick and 8" wide.

An average part run utilizes 1 coil of stock and takes from 2 to 3 hours to complete. With the ability to make die changes in less than ten minutes, several different part runs can be made in an 8 hr. shift.

### Manually Fed Die-Namics

Two 60 ton Die-Namic presses are located in Allen-Bradley's secondary operation department. These operate at 90 spm and are hand fed for part runs of 5 to several hundred pieces. Five or six die changes are usually made each day on each press. Die-setting time has been reduced from about 40 minutes to less than 10 minutes with the use of the Die-Namic Process.

### Less Costly Dies

Allen-Bradley replaces worn conventional dies with the simplified Die-Namic dies. Cost is about one-third less. Die-Namic dies are also, of course, easier to handle and store. They require one-half the space needed to store regular dies. Over 200 Die-Namic dies are now in use at the Milwaukee plant.

