

# Minster *Hummingbird*<sup>®</sup> System is essential part of Success Formula set by BCL Magnetics Ltd

When Bill Charney, Bob Briggs, and Jim Longenecker started BCL Magnetics Ltd in Burlington, Ontario, their goal was to offer something better than the other lamination specialists. Together, they had a total of over 75 years of lamination experience and a carefully prepared formula for success.

Bill Charney says, "We set high standards and we decided to start with the top-notch press in the industry. We chose the Hummingbird because we felt it was the press that would give us what we wanted — longer efficient runs, longer die life and better mechanical properties in our parts."



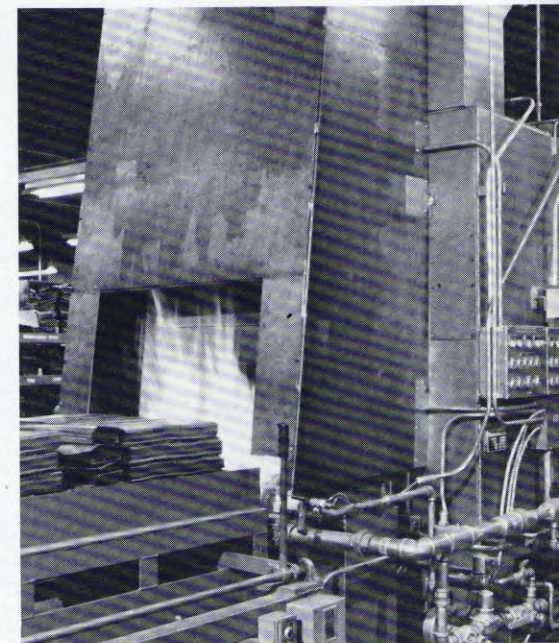
BCL Magnetics Ltd modern plant in Burlington, Ontario, Canada.



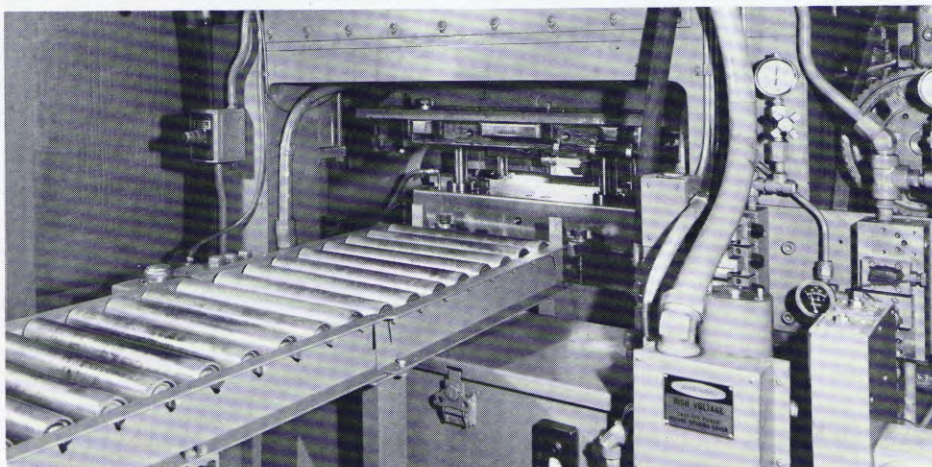
Hummingbird line includes Minster coiled material handling system, Minster Cam Feed, press within noise enclosure. (A box stripper in this die forms a tunnel into which scrap slugs drop and are then blown into the container outside the enclosure.)

BCL Magnetics Ltd produces laminations for the tele-communications and transformer industries, the sub-fractional hp motor market as well as ballast laminations for the fluorescent and HID lighting industries. Other products include magnetic core materials and magnetic shielding for transformers.

They use the full range of electrical materials . . . from 12¢/pound steel to \$12/pound nickel alloys. To fully develop the electrical properties of the magnetic materials, the company has a large continuous annealing furnace to magnetic anneal their parts.



Large annealing furnace for continuous magnetic annealing operation.



4 Close-up of die-loading conveyor at rear of press to facilitate die changes.

### HUMMINGBIRD OPERATION AT SPEEDS FROM 200 TO 1200 SPM.

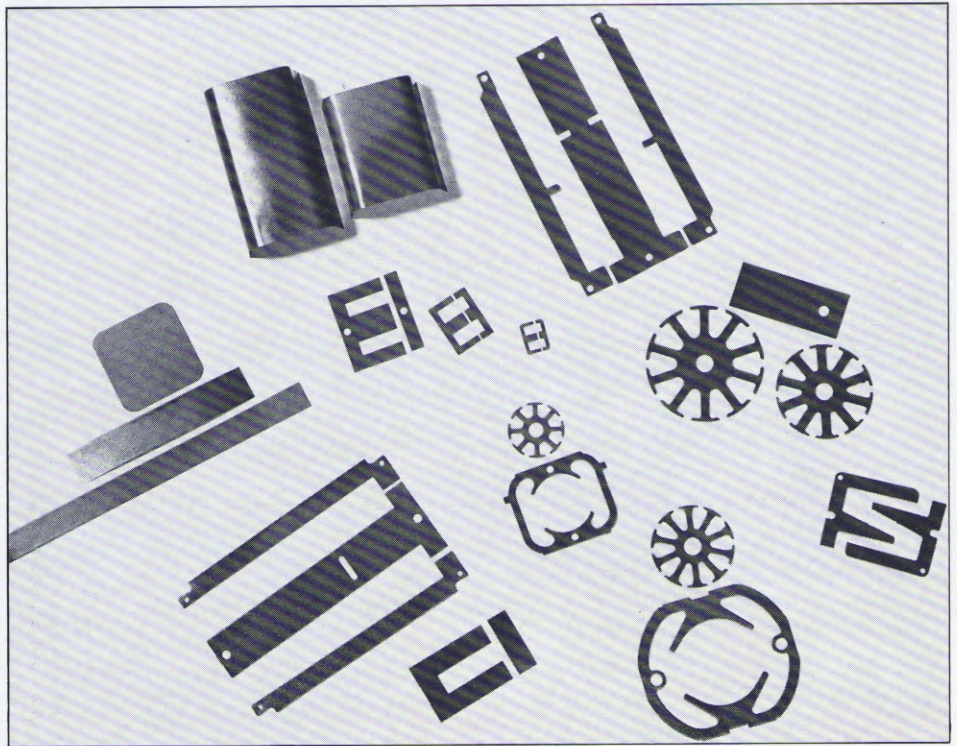
The 60 ton capacity Hummingbird press with noise enclosure, a Minster high speed cam feed and Minster coiled material handling system is a totally integrated production package. The press stroke is 1.57" and feed lengths run at BCL range from 3/4" to 5".

BCL Magnetics Ltd — the first lamination specialist to run a Minster Hummingbird — has, through experience, designed their own parts chutes and have also fitted a die-loading conveyor at the rear of the press to overcome forklift access problems. Scrap is removed through an under-floor conveyor system.

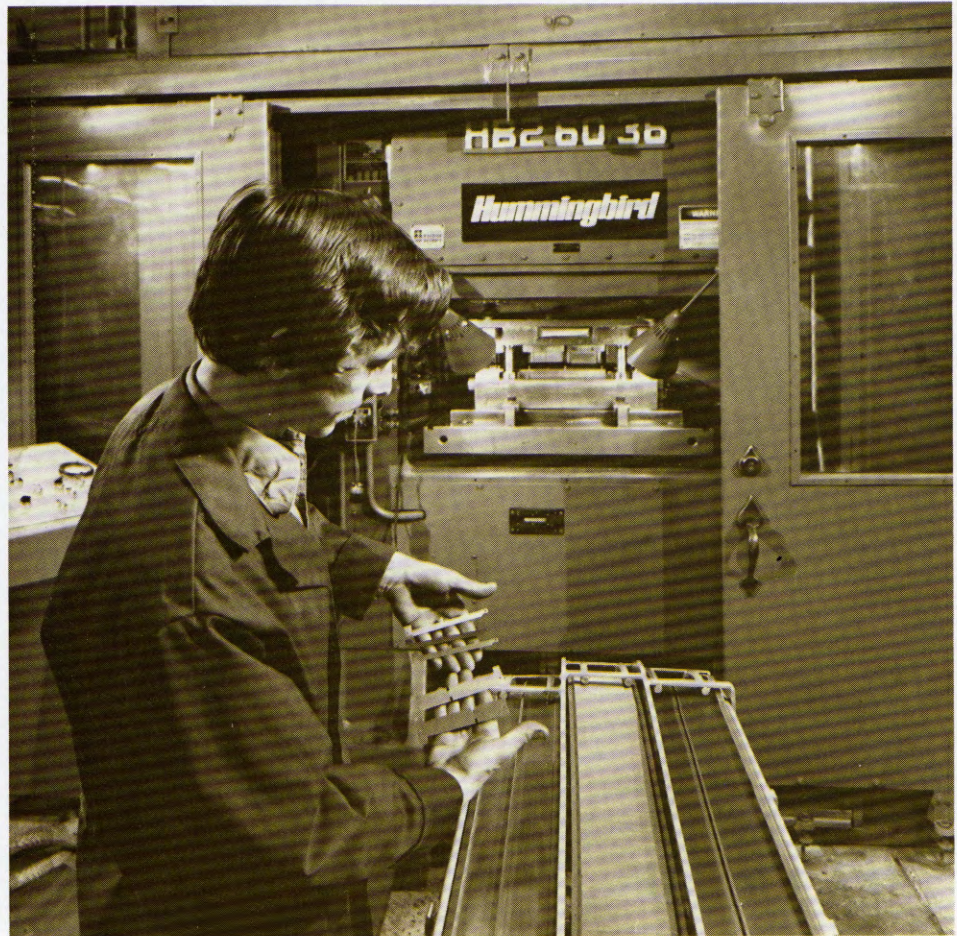
The company's philosophy of how to be successful includes:

- efficient material handling
- long part runs
- quality part production
- efficient annealing, packaging and scrap handling

Mr. Charney remarked, "The service we've received from Minster has been excellent in every respect. The Hummingbird fits right into our philosophy of how to be successful. As you can see, a dependable press and feeding system is an essential part of the formula."



Wide variety of high-quality laminations produced on a Minster Hummingbird Automated Stamping System at BCL Magnetics Ltd in Canada.



Laminations are produced at high speeds in the 60 ton Hummingbird press.