



*Minster DAC-H200-96 cupping press and coil line in production at Grupo Modelo's can plant located in Zacatecas, Mexico.*

**G**rupo Modelo, Mexico's largest brewery, has dramatically increased production at its Zacatecas can plant with the addition of a new Stolle Hyperdyne Cupping System, featuring a Minster DAC-H200 cupping press and a Minster MSCF-72 servo cupper feed.

Now producing more than six million cans a day, the Zacatecas plant supplies cans to seven Modelo breweries. Founded in 1925, the Modelo group brews and distributes 12 brands of beer, including Corona Extra, the number one Mexican beer sold in the world. Other popular brands include Modelo Especial, Negra Modelo, Victoria and Pacifico.

The latest cupping line at Modelo's Zacatecas plant is the second of two Hyperdyne Systems, recognized as the highest production cupping systems available in the can industry.

Capable of speeds of up to 350 strokes per minute, the newest Hyperdyne System features state-of-the-art 14-out tooling provided by Stolle Machinery. The



*Minster's new MSCF-72 servo cupper feed has helped increase productivity at Modelo's Zacatecas Can Plant.*

die features non-round blank for metal savings, and numerous innovations and features designed for efficient press operation along with part and scrap removal.





*The Minster DAC-H200 press is an integral component of Stolle Machinery's Hyperdyne System, recognized as the highest production cupper system available in the can industry.*

repeatability and eliminate the need for a special foundation. The hydrostatic piston guiding system and a temperature-stabilized frame allow for extreme accuracy. In addition, Minster's patented quick lift feature provides for quick and easy tool access and release of die jams at the bottom of the stroke.

"With the accuracy of the press, we see very little maintenance on our dies, and the part quality is consistently good," Méndez said.

Minster's servo cupper feed compliments the speed capabilities of the DAC-H200 press, employing a standard Allen Bradley heavy-duty digital servo motor and drive. The servo offers feed progression control with the touch of a screen, which is seamlessly integrated into the main press control.

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Both lines feature a Minster DAC-H200 cupping press, and Production and Maintenance Superintendent at the Zacatecas can plant, Francisco Covarrubias Méndez, said the second Minster press at the facility is just as impressive as the first.

"Our Minster presses are great assets. They are very easy to maintain, and never present a problem." Méndez said. "The presses work like mules and never complain."

The Minster DAC-H200 press features a reciprocating dynamic balancer to help maintain precise



*A sample of some of the many types of cans produced the Zacatecas Can Plant.*



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**Francisco Covarrubias Méndez**  
*Production and Maintenance Superintendent*  
Grupo Modelo Zacatecas Can Plant

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Other feed efficiency enhancements include a maintenance-free direct drive feed roll system, and a robust feed hinge feature, allowing quick access to the die space for maintenance.

With the Modelo can plant operating in a continuous production environment, Méndez said quick and efficient coil changes are essential.

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Méndez said another advantage of having the Minster equipment at the Modelo plant is the close proximity of Minster service and sales support in Mexico.

“We get outstanding support from Minster,” he said. “The service response is quick and very proficient. The people at Minster are very good to work with, and are always willing to help us out.”

The Zacatecas can plant is a turnkey operation for numerous types and styles of cans. And with the implementation of the new Hyperdyne line, the facility is expected to exceed production of more than four billion cans a year making it one of the most productive operations of its type in the world.

And with the rising success of the various Modelo brands of beer, Méndez said he expects continued growth for Mexico’s leading brewer.

For additional information, visit Grupo Modelo online at [www.gmodelo.com.mx](http://www.gmodelo.com.mx). For information about the Hyperdyne System, visit Stolle online at [www.stollemachinery.com](http://www.stollemachinery.com).



*Production Superintendent Francisco Covarrubias Mendez (right) and assistant Alberto Gonzalez in front of finished cans waiting to be shipped to Modelo breweries.*