

Minster SE4 Press Lines Increase Flexibility and Reduce Costs for W.C.I.

Three new press lines were installed in early 1989, at the WCI Laundry Division's Webster City, Iowa, facility. The Minster SE4-800 presses each have a 168 x 84" die space. They are equipped to produce full tonnage at 1/2" off bottom, and have a stroke of 18 inches.

All three presses are equipped with press-driven transfers, hydraulic clamping for the upper die and bolster, and powered rolling bolster die change (front and back). They also included complete feeding and coil handling lines.

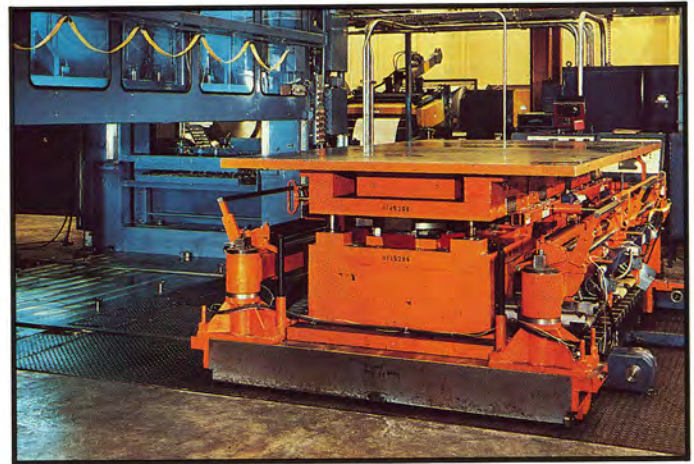
Transfer pitch is adjustable from 12 to 40 inches, with typical production speeds of 15 to 25 strokes per minute.



This 28" diameter drum back for a WCI dryer is produced in four stations. Previously production would have required five people and four presses.

Eight hydraulic clamps in the bed and fourteen in the slide secure the lower die/bolster and the upper die, respectively. After unclamping, hydraulic lift cylinders raise the bolster and die on four wheel assemblies. They are then moved from the press (front or back) to the staging area by a ball screw drive.

With off-line set-up work on the die done at the bolster in the staging area, rather than in the press, part changeover (in terms of press time) takes 60 to 90 minutes. This would compare to



Quick-die-change features have reduced press time for changeover by approximately 80%.

5 to 8 hours changeover time for one of WCI's six-press lines producing a similar part. WCI also expects to save significant time on die maintenance by running the bolster and lower die out of the press for easier access.

These new lines at WCI produce a variety of parts for home laundry equipment. They have increased capacity, while replacing existing manually-fed press lines. And as a result of their fast changeover capability, flexibility has been improved and Just-In-Time production has been made possible.

