

## Progressive and Transfer Operations Working Together

# Dual Coil Processing Line Brings Increased Processing Flexibility To Automotive Stamper

*Keeping presses running... it drives "profit or loss" for stampers.*

*But how do you develop stamping lines to cover every part currently produced and future versatility without breaking the bank?*

*This was a problem facing a Detroit-area metalstamper, but they found a way to add flexibility to their stamping lines to keep their current customers happy, while expanding their stamping capabilities to bring in new ones. Coe Press Equipment's/Sesco Products Group's ingenuity was vital to their success...*

The company produces assemblies and stampings for seat suppliers and direct automotive OEM work...parts such as brackets, individual stampings or other types of critical sub assemblies. Currently the company operates a variety of transfer and progressive die type presses that are nearly all set up with automated coil feed lines (only a few of them are fed via blanks).

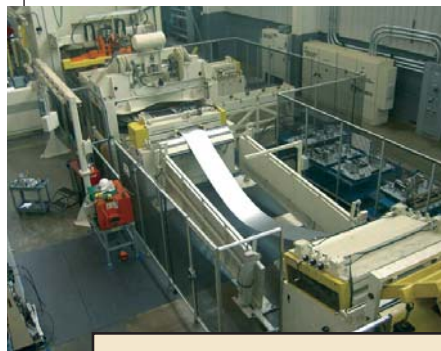
Their customers were clamoring for increased output and faster deliveries. And because the company needed to add "back-up" lines to some of its more vital stamping operations, they decided to

develop a unique line that could process both progressive and transfer-type stamping operations.

The unique solution uses a mechanical press, a servo-driven 3-axis transfer system, a high-capacity coil feeding system from Coe Press Equipment, and an oscillating shear press from Sesco Products Group.

The coil feeding portion of the system consists of:

- an AC servo-driven digital rollfeed (Model CPRF-772: 72" max. material



**Feeding both progressive and transfer press operations on a 1650 ton press...**

- Servo-driven 3-axis transfer system
- Coe high-capacity coil feeding system
- Sesco oscillating shear press (+/- 30° angles, up to 30spm)

width, .250" max. thickness) used as a "primary feed" for cut-to-length and cut-to-shape blanking for the transfer die applications,

- a "secondary feed" (Model CPRF-772) that is moved into the line's operating position and used during progressive die operations,
- a free-standing power straightener (Model CPPS-406),
- a coil reel (Model CPR-PO-60072) capable of paying off coils of 60,000 lb. weights, 72" widths,
- and a hydraulic traveling coil car (CPTCC-60072) for pre-staging coils.

A downstream Sesco oscillating hydraulic shear press is utilized to produce both square-cut and trap-cut blanks at speeds up to 30 strokes per minute. Trapezoidal-shaped angles up to +/- 30 degrees can be produced to provide optimum material utilization with "net-shaped" blanks.

A shifting magnetic blank eject conveyor is mounted to exit side of the shear press to positively drive the blanks clear of the shear blades.

Once blanks are produced in alternating right-hand and left-hand shapes, they must be properly

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oriented for presentation to the in-press 3-axis transfer system.

A synchronized servo-driven conveyor system is utilized to index the blanks from station to station. A servo-driven rotate station utilizing suction cup vacuum tooling is used to rotate every other part to match the required in-press orientation.

#### Blanks vs. Coil Feeding

The company reviewed blank handling options, but felt that they would have issues with a destacking system (raw material costs, inventory control/deliveries, damage-free blank handling, double feeding of blanks that would damage tooling).

They also felt that a dedicated transfer-style press system alone couldn't do enough work to support itself at current

sales volumes, but one that could do both transfer and progressive work and back up other press lines would allow them to recoup their investment.

One of their company manufacturing engineers states, "We didn't have orders for a lot of transfer parts. Obviously, that level of business would not keep a press



**"Square cut or trapezoidal shaped blanks are produced at a rate of 30/minute via this oscillating shear die, feeding downstream progressive die operations"**

like this running, so we knew we also needed to run it for various progressive die jobs. We have a 1200-ton press that had no back

up capacity, and we figured we could use it as back up for that press line."

He adds, "This cut-to-length line offers some unique advantages. You never have to worry about doubling up blanks, because you know you're only getting one part off the shear at a time. With the programmable oscillating shear press, we can take advantage of any kind of nesting issues, not fully developed blanks, but trapezoidal shapes where there is an advantage for material savings."

Read more details of this success story at [www.cpec.com/Success-Programs.htm](http://www.cpec.com/Success-Programs.htm) (including a short movie seeing the operation and hearing it in their own words).

Are you interested in a dual processing (progressive and transfer die operations on a single press) line at your facility? Send us an email request ([sales@cpec.com](mailto:sales@cpec.com)) or give us a call (586-979-4400).

## Coe In Stock Equipment

Machines are available for immediate delivery... special in-stock pricing now available. But hurry... limited supply on these high demand systems.



- **ServoMaster Series 1** (multiple servo roll feeds available —.156" x 6" and .125" x 12" capacities)
- **ServoMaster Series 2** (multiple servo roll feeds available —.156" x 12" and .125" x 18" capacities)



- **Spacemaster Compact Coil Lines (two available)**  
**CCL-S3-15032** (.250" max. coil thickness, 32" max. material width, 15,000# max. coil weight)  
**CCL-S3-20032** (.250" max. coil thickness, 32" max. material width, 20,000# max. coil weight)

Send us an email ([sales@cpec.com](mailto:sales@cpec.com)) or phone us (586-979-4400) with your interest in these "ready to roll" machines.



## Mucho Business... Found South of the Border

Business continues to be hot for Coe Press Equipment/ SESCO Products Group in Mexico. Take a look at just a snapshot of the work we're doing with leading OEMs and contract stampers...

**Cooper Lighting (Monterrey):** As a leading lighting supplier, Coe "scratch free" servo feed systems help the company to drastically increase productivity (tripling feed rates, in many jobs) while continuing to deliver quality parts in an ever-increasing JIT production schedule.

**Intermex (Chihuahua):** This stamping startup counted on Coe press feed systems to work with their Aida presses. Four different press cells utilizing complete servo-driven feeds and straighteners from Coe helped build their business from scratch.

**Manesa (Chihuahua):** Another contract stamper serving automotive, lighting, motor housing markets. Manesa upgraded seven older press lines with Coe Servo Drive Digital Roll Feeds/Power Straighteners/Coil Reels. Learn how job

changeovers have moved from 1.5-2 hours to as quick as ten minutes in today's environment.

**Small Parts (Juarez):** See how this contract stamper (small, medium and large part production, located just across the El Paso, Texas border) replaced their outdated air-feed systems with Coe ServoMaster servo press feeds and straighteners to improve their progressive die operations.

**Metalsa (Apodaca):** Automotive supplier of light truck chassis frames, automotive/truck suspension modules, and class 5-8 truck side rails uses Coe and SESCO lines to feed five different stamping lines (400, 500, 600 Komatsu straightsides; 1500 ton Eagle link press; 2000 ton Aida coil and blanking line with Gudel in-press transfer system).

Check out these and other success stories at [www.cpec.com/success-home.htm](http://www.cpec.com/success-home.htm). Don't forget to check out our Spanish Language web site by clicking on the link at [www.cpec.com](http://www.cpec.com) (bottom left side of screen — "Spanish-Language web site"). Stories are available in English or Spanish.

**All Coe/SESCO activities are supported through our strong Mexico sales partner: Promotores Tecnicos, S.A. DE C.V., Monterrey and Mexico City offices, phone 011-525-273-8352.**

## Keeping Your Workhorses In Top Condition



**Coe Press Equipment provides the industry's best technical service to keep your metalforming equipment running at optimized conditions. We understand that fast response is important and we take pride in our reputation to provide both on-site and "right now" technical phone service to troubleshoot your problem...whatever your service concern.**

We're ready to tackle your specific needs...from production troubleshooting, preventive maintenance programs, machine repair and all recommendations for replacements and upgrades. All backed by the biggest inventory of replacement and repair parts and a responsive team to meet your challenge of today. (More than 50% of our parts requests are shipped within 24 hours of request. Count on our 24/7/365 technical support, too.)

And because we know that sometimes today's economic conditions won't allow new equipment purchases, count on Coe to provide the best in equipment rebuilds to bring your older press feeds, straighteners, reels/coil cars and other Coe or SESCO brand equipment...other makes and models including:

- Littell
- CWP
- Rowe
- Dallas
- P/A Industries
- Colt Automation
- Dynamic Feeds
- and others

Don't just take our word...visit <http://www.cpec.com/Success-Hudson.htm> to read how a recent rebuild helped an automotive stamper achieve faster processing speeds with an older feed line. And take a look at our "Parts and Service" pages when you're on the website.

Discover how our capabilities are ready for your test...today or tomorrow...at any hour of the day. Give us a chance to quote your needed service, part, rebuild, etc. Then rest assured, Coe will always be there when you need us!

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## Recent Orders and Shipments —

### Daimler Chrysler (Belvidere, IL)— Oscillating Shear Die

 SESCO Products Group recently delivered a high-speed Oscillating Shear Die to produce trapezoid and parallel shaped blanks. It achieves a 50 SPM hit rate. A solid cast “bump die” uses an adjustable blade gap to better process various material thicknesses and utilizes four-way indexing shear blades. Includes a custom-designed base to integrate in their existing ASRS used to store their blanking dies, as well as being designed to locate and clamp the die on the moving bolster. Other features include: precision ground rack and pinion gear mechanism with high torque AC servo motor, self-centering edge guides, pivoting ball transfer table, shifting exit conveyor, and Control Logix based PLC and machine controls.



### Dana (Hopkinsville, KY)— SpaceMaster Compact Coil Line/ Hydraulic Production Shear and Drop Stacker

 This Tier 1 supplier wanted to employ coil feeding into their stamping facility, but had floorspace limitations. Coe engineered a SpaceMaster Compact Coil Line/Hydraulic Production Shear and Drop Stacker to meet their challenges for producing thicker material blanks up to 210” long x .220” thick and 16” wide (high strength materials to feed downstream press operations in building commercial van frame rails). The line features 15,000# coil capacity, motorized coil guides and a hydraulic traveling coil car. The hydraulic shear is integrated into the feeder base to minimize floor space. The automated stacker features multiple lane power chain conveyor and hydraulic scissor lift that facilitates “cranesaving” banding and storage.



(Check out all of our success stories at [www.cpec.com/Success/Home.htm](http://www.cpec.com/Success/Home.htm))

### Johnson Controls (Battle Creek, MI)— 3 Fully Integrated Coil Feed Lines

 An order has been received for 3 fully integrated coil feed lines for this automotive seating supplier. A single 72” wide x 50,000# system will work with a 1000 ton Komatsu press, while the other two lines are 60” wide x 40,000# systems working with 800 ton Komatsu presses. All are outfitted with 3-axis transfer systems supplied by Wayne Trail Technologies, as well as Coe state-of-the-art-controls, Allen Bradley-based drives and controls with Panelview Plus operator interfaces. Tons of features to improve setup and operating efficiencies will be provided with these lines.



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