

LIDE Industries - Mexia, Texas

## With Four Million Pounds of Plate Steel Blanks Required Monthly To Feed Tank Production, Texas Fabricator Commissions New Sesco CTL Line

More than 7,000 tanks are built annually at LIDE Industries (Mexia, TX)-- and it takes a lot of thicker plate steel to produce that many units. A key part of the equation in satisfying customer delivery requirements is found in their ongoing process of supplying steel plate blanks for rolling, welding and other downstream manufacturing processes. That can be a challenge when four million pounds of steel every month is required.

A new Cut-To-Length Coil Processing Line from the Sesco Products Group is now helping them to ensure the availability of raw material inventories, improved quality, the

**elimination of secondary material preparation processes, and the savings of hundreds of thousands of dollars annually in lower material purchase and scrap costs.**

Previously, LIDE contracted to have plate steel cut to useable blank shape and delivered on a daily basis. But there were issues in controlling their own destiny with raw materials, as well as quality issues with the squareness of the blank.

Bobby Lide, company Vice President states, "We

figured if we were using three to four million pounds a month and it was costing us \$30,000 to \$40,000 per month to have our material cut, the price of the machine vs. cutting our own material became a no-brainer. We figured it to be about a two year or less pay off. That was the key reason we purchased the Sesco CTL system."

The solution resulted in a Sesco Products Group 72" wide Reel/Straightener/Feeder with Hydraulic Shear and Drop-Type Stacker

**Unit.** The system can handle coil from 12" to 72" widths and up to 60,000 pound coil weights. It can process .250" x 72" wide cold rolled steel (thicker material processing often includes .375" x 60" work), as well as .187" x 72" stainless steel work. It provides a fast line speed of 60 FPM processing. Their line description follows:

- Large coils are loaded on the **traveling coil car** via a remote jog pendant, simplifying the loading on to the coil reel and providing a pre-staging for the next coil.



continued from front page



- The **traveling coil reel** is built with extremely heavy-duty components and an all-welded construction, as well as providing for automatic coil centering to assure proper coil location. During the uncoiling process, the O.D. is laser monitored and back tension is compensated for as the coil diameter depletes.
- Hands-free material threading happens in minutes due to its **hydraulic peeler/threader/hold down station**.
- To ensure precision material straightening and blank length shearing, a **combination seven roll (5.6" diameter rollers) straightener/feeder system** gives them simplified coil length/width and processing speed parameter control via a simple to use operator interface.
- Next, a **hydraulic shear** delivers appropriate blank lengths (up to 240") in a fast and precise manner, dropping the blank onto an air operated **drop stacker unit** (with a hydraulic scissor table capable of handling a full coil weight of 60,000#).
- A set of positive driven conveyor rollers position stacks to the **exit conveyor** for removal by a heavy-duty forklift.
- And the entire system is controlled at a single location by a **user-friendly Panelview 1000 touch screen system** with English/Spanish capabilities.
- Local sales/service support is supplied by **H&O Die Supply** (Dallas, TX).

There's more to the LIDE story...visit [www.cpec.com/Success-Lide.html](http://www.cpec.com/Success-Lide.html) to read more. And learn about our CTL/Blanking Line experience by clicking [www.cpec.com/Complete-CTL-Blanking\\_Line.html](http://www.cpec.com/Complete-CTL-Blanking_Line.html) (check out the lines we've built recently...printable .pdf format, found at bottom of web page).

## Manor Tool and Manufacturing - Schiller Park, Illinois Chicagoland Contract Stamper Pairs "Space Saving" Servo Feed Line With "Proven Workhorses"

It's a common stamping operation's wish: *"Sure, I'd like a shop full of the newest equipment, but our current volumes and capital equipment budget won't allow...I'd sure hate to give up on some of the great workhorses we've successfully operated for years. What's the answer?"*

Another typical question from both contract and OEM stampers alike: *"Floor space is getting tighter and tighter for us...how are we going to maximize our operational efficiency without feeling too cramped?"*

That's the two specific challenges recently faced by a Chicago-area contract stamper. Key to their success is how they've found ROI-minded solutions in continuing to operate existing presses with the latest in space-saving servo press feeds. And Coe Press Equipment Corporation was vital to helping the company find answers.

For nearly five decades, Manor Tool and Manufacturing Company (Schiller Park, IL) has grown to be an industry-leading, full service-oriented company offering contract stamping and deep draw operations (35 presses ranging from 1-3/4 tons to 400 tons), tool design/development and maintenance, as well as other types of manufacturing services such as various machining operations and smaller run assembly and fabrication work.



Specifically, Manor management had a three fold challenge in their larger press room area:

1. After running a used servo feed system on one of their most productive press lines (a 200-ton Bliss), they realized that a different feed line would be required. They found that there were **too many limitations during set-ups** that required a lot of adjustments, faults with the programming system, and the requirements of time-consuming shimming openings when running thicker stock.
2. This same press line had **line length limitations**...and a conventional feed line wasn't going to fit in their already tight plant layout.
3. Plus, they needed to investigate a better press feeding answer to **replace their outdated air feed system on their most recent press 400 ton press purchase**.

Their answer was a SpaceMaster Compact Coil Line, a system combines the processing of unwinding, straightening and feeding of coil stock in a single machine with a smaller space footprint (17') when compared to traditional coil feed lines. It will process .125" x 24" wide materials at 60,000 PSI yield strength (up to .250" materials can also be processed, material width

continued from page 2

and type dependent). It provides fast production speeds up to 60 FPM (up to 70 SPM performance at 6" feed lengths). True pilot release functionality, closed-loop digital servo drive & ServoMaster MMI control round out the products key features. Other pertinent information on the SpaceMaster Series III include:

- 11,000 lb. max. coil weight, 64" maximum coil O.D.,
- the 3.5" straightener rolls are configured in a 4 over 4 arrangement and on close centers for effective straightening,
- precision cluster gear drivetrain provides effective torque delivery and accurate feeding,
- a heavy-duty hold down arm with a motorized endwheel contains the coil from clockspringing and is synchronized with the motorized reel during payoff to maintain a tightly wrapped coil,
- handsfree threading is accomplished through the use of the lower hold-up table, threading assist roll, and debender mechanism,
- and efficient coil staging and loading is performed with the hydraulic traveling coil car.

Kevin Segebarth, Manor Chief Engineer sees "a night and day difference" in operating the newer feed system...and for many reasons.

"It's definitely a lot safer," he says. **"We don't**

**need two men to do a coil thread and we don't have to handle the material anymore.** We were running the thicker and wider materials and when you cut those bands you get the clock spring. **Plus, we only have about 21' for a feed line. It would have taken 26' to 30' to put in a traditional feed line.**

This gives us better access to our die storage area now because we can operate a forklift easily to access our storage racks along the back wall, as well as bringing coil materials to each of the press lines there. And we appreciate our local rep's (Stamping Systems-



Rolling Meadows, IL, ph: 847-934-5528) efforts that helped to show how this limited space solution from Coe would work well in our facility."

Get the complete Manor story at [www.cpec.com/Success-Manor\\_Tool.html](http://www.cpec.com/Success-Manor_Tool.html).

## Don't You Deserve The Best In Cut-To-Length/Blanking Line Technologies?

COE and Sesco delivers the best in CTL / Blanking Technologies... and we do it at a "valued price" that you can appreciate.

- .008" - .250" thicknesses,
- coil widths to 84",
- coils to 75,000 lbs.,
- processing speeds to 80 SPM and/or 300 FPM.

Past applications include these technologies:

- high-speed production shears, oscillating shear dies, & shear presses;
- inline coil strip washers;
- edge trimming stations;



- single and multiple station blank stackers (including cost-effective drop stackers);
- and a variety of stack handling options.

We look forward to talking to you about your processing requirements/desires. All it takes to get the process started is a phone

call (586-979-4400) or an email ([sales@cpec.com](mailto:sales@cpec.com)). Or take a look at our website for more information or ideas for your application. Give us a call today!



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## Recent Orders and Shipments — Guelph Tool, Inc. (Guelph, ON Canada)

COE has recently shipped a **fully-integrated coil feed line for processing heavy-gauge steel to this Tier I supplier.** It features a CPRF-548 roll feed and a CPPS-406-48 power straightener and are designed to handle high-strength material up to .250" thick x 12" wide at 70,000 PSI Yield Strength. The heavy-duty CPR-40048 coil reel and car are capable of handling coils up to 40,000 lbs. at 48" widths. Many heavy gauge processing features include a peeler / threader / hold down station for hands-free threading, a single-row straightener roll back-ups for no deflection, a 30 HP AC variable speed drive, and a pivoting knee-type threading table for effective strip threading into the servo feed. It will be integrated with a Blow Press and Linear Transfer for transfer press applications.



## KTH Parts Industries (St. Paris, OH)

COE and Sesco Products have received an order for a blanking line from Komatsu America Industries, Wood Dale, IL (on behalf of KTH) and **will be fully integrated with a new 800 ton blander and provided as a "turnkey system".** It is designed to process materials up to .125" thick x 72" wide at 100,000 PSI Yield Strength. It features a CPRF-772 roll feed, a CPPTH-72 peeler/threader/hold down station, CPCS-72 crop shear station, and a CPR-60072 coil reel and car. The line also includes a Machine Concepts leveler with 19 work rolls and a 4 high configuration for precision leveling of the high-strength coil. It is designed with an Allen Bradley line automation system and PLC based controls and features Panelview touchscreen operator interfaces, part recipe storage for all job parameters, Ethernet and Devicenet communications, and motorized and encoded positioning of all line functions.

## Tramontina USA (Mantiwoc, WI)

COE has recently commissioned **two coil feed lines to this leading cookware supplier.** The lines are integrated with Galdabini hydraulic presses and each line is designed to process up to .160" thick x 24" wide aluminum in a **non-marking application.** The lines feature CPRF-SM3-24 ServoMaster feeds, CPPS-350-24 power straighteners, and CPR-DE-6024 double-ended coil reels. Non-marking features include #5 matte chrome full width feed rolls, counterbalanced feed rolls, nylon covered catenary rolls, polished chrome straightener rolls, and nylon covered threading devices. Many of the line's productivity enhancement features include the ServoMaster Controller with 500 job memory, a peeler / threader / hold down station for hands-free threading, hydraulic threading and mandrel expansion, and a horizontal-top straightener for both top and bottom payoff of the coil.



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