



Carl Keller, Sr.,  
President of  
Diemasters, Inc.



Carl Keller, Jr.,  
checks part print.

## Diemasters Use Minster Precision-built Presses To Prove and Run Their Precision-built Dies



Diemasters ultra-modern facilities in Elmhurst, Ill.

Carl Keller, Sr., President of Diemasters, Inc., Elmhurst, Ill., has earned a position of respect in the tooling industry and built a thriving company "working on the tough jobs no one else wants to do."

A diemaker since 1933, Mr. Keller and six other partners formed their company in 1948. Today, after 25 years of operation, Mr. Keller is sole owner of a firm where "customers expect the best . . . and they get it."

Initially, Diemasters, Inc., concentrated exclusively on design and manufacture of dies, fixtures and other tooling. Recently, however, the company has begun production stamping, specializing in electronic parts.

In both sides of the business, Mr. Keller is sold on Minster presses. He reasons that in building extremely close tolerance dies, he wants a precision press for die tryout.

Because the dies are shipped throughout the world, a trial run of 5,000 to 10,000 parts is made in the plant to prove the dies work properly.

Diemasters have been using Minster presses for the past six years for die tryout. Mr. Keller watched Minsters run in customer's plants and saw they were making better parts. When his company moved into its new plant in Elmhurst in 1966, they got involved in coining work with a tolerance of "plus or minus a half thousandth." As Mr. Keller puts it, "You don't hold  $\pm .0005$ " on non-ferrous material unless your press will hold it. That's how we got Minsters."

For the production side of the business, two P2 Piece-Maker<sup>®</sup> presses—one 150 ton and one 100 ton unit—are the newest additions. Their major

production is automotive, electrical, electronic and thermostat parts.

To make sure he doesn't have to use anything but Minsters, Mr. Keller always keeps presses on order to meet his future business projections.

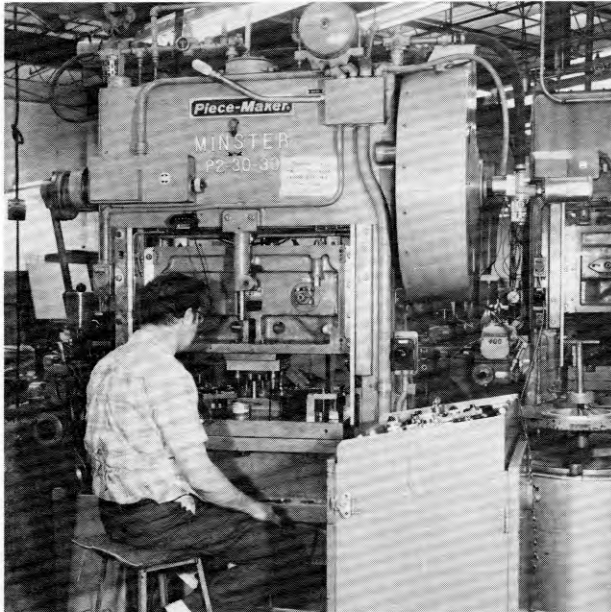
An outstanding tribute to Minster press quality is Mr. Keller's revelation that they interchange two dies between two Minster P2-30's in the shop without resetting the dies. Both rams are set within  $\pm .001$ ". And, according to Mr. Keller, they place either die on either press without moving the ram and get good parts—4,000,000 on each die in the first month and half, in fact. The part is a seal which is curled, formed and extruded and has to be held close. Regardless of which press the particular die is on, it is run at 275 SPM. That's proof that the main and connecting bearings on the presses are in very close tolerance.

Diemasters use their Minsters every day. "The presses don't get tired," says Mr. Keller, "I like the way they go. In the long run, they're the cheapest press you can buy."

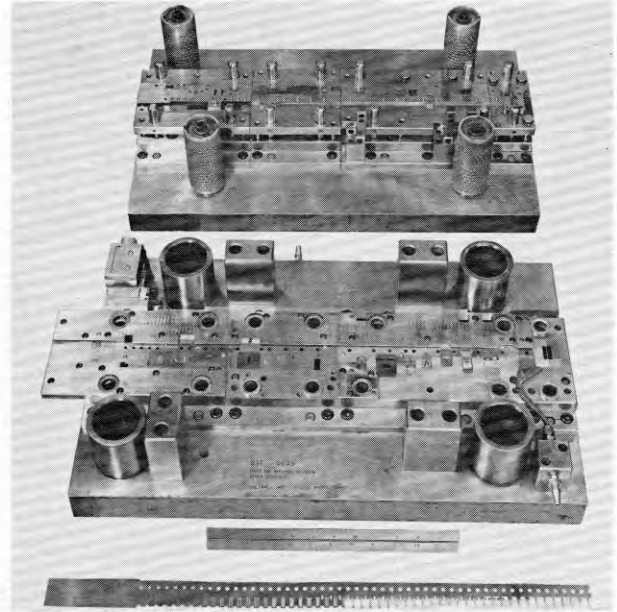
Mr. Keller also believes in taking care of a press. "We have 10" thick floors throughout the pressroom. To hold accuracy you have to put a press where it won't bounce around," he related.

Diemasters has 75 employees, and is an exceptionally well equipped company. Mr. Keller's four sons all participate in the business with him. Many of his employees have 15 to 20 years of service, and have acquired skills which permit the company to maintain its reputation for high quality work.

As for Minster, Mr. Keller says, "Just keep the quality you have. I can't ask for anything more."



One of two Minster P2-30's used for die tryout and production.



Precision-built Diemaster progressive die, with strip and part.

Two newest Minster presses are high speed, roll fed Piece-Makers running a variety of small automotive parts.

