

HANDY BUTTON MACHINE COMPANY gets up to 5 times more parts per die grind with Minster Adjustable Stroke O.B.I.'s

The world's largest producer of metal button parts has found that Minster presses live up to their reputation.

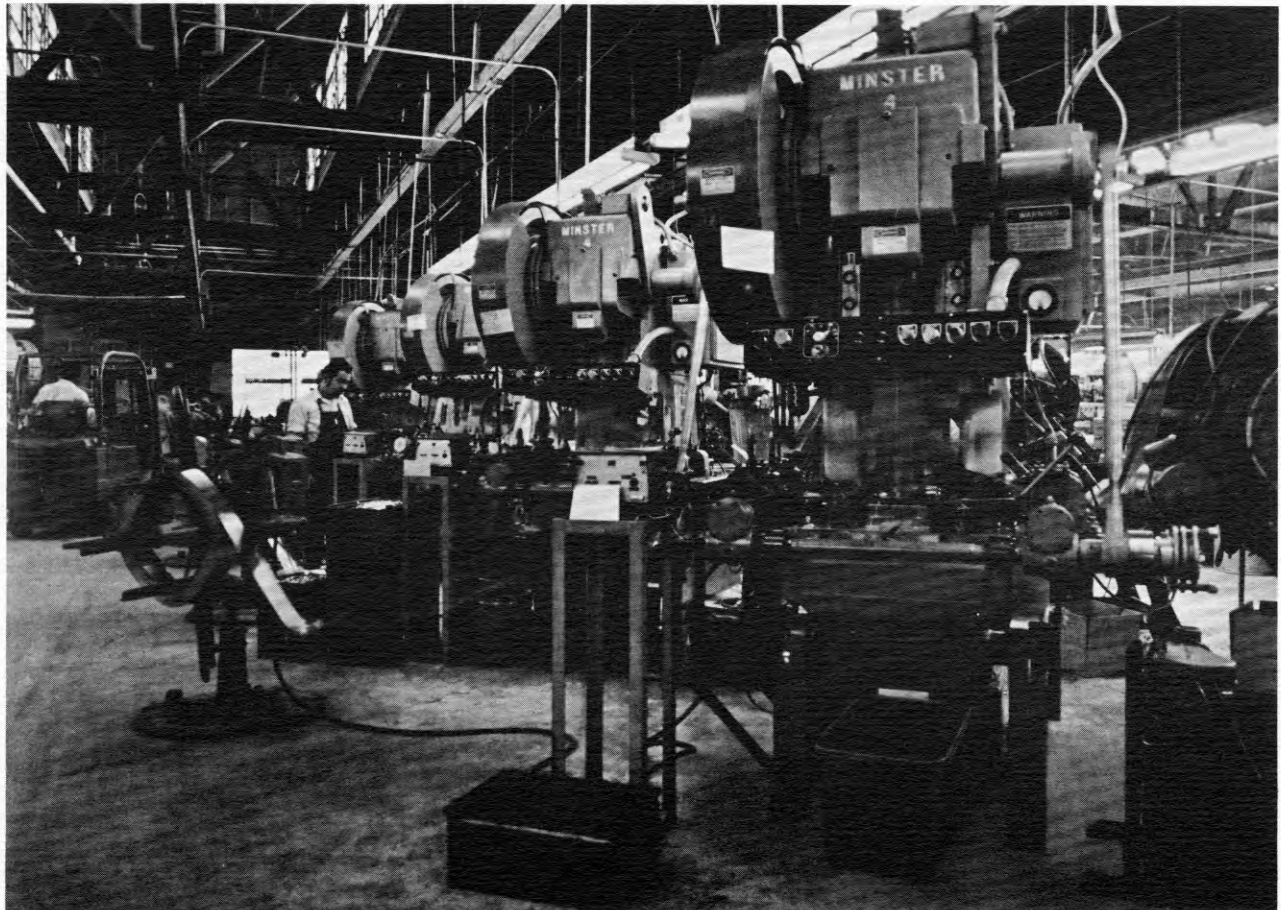
Handy Button Machine Company produces about 100 million parts every week. For many years the company had been buying and using a competitive make of press almost exclusively. Recently, however, they purchased four No. 4, 32 ton capacity Minster O.B.I.'s with the Adjustable Stroke feature. Prior to the installation the company had been getting from 30,000 to 60,000 parts between die grinds on Brand X variable stroke O.B.I.'s on certain difficult dies. When the same dies were run in the Minster No. 4's they were able to run up to 300,000 parts per die grind. Why such an outstanding gain in die life? Mr. Dave Little, Plant Supt. says, "It's a better press. Minster's reputation has always

been good and the press backs it up. I'm very pleased with the Minsters."

Press Design Makes the Difference

Actually, the longer die life experience at Handy Button can be attributed to Minster's press design which provides extra long V-type gibs and maximum length guiding of the slide at all times. Precision of slide alignment which results in long die life is also a Minster plus over the competitive press. (Do you know we always hold the slide square to 0.001" through its entire length?) Ability to withstand deflection is built into the "C" type high tensile alloy cast one piece press frame. The size and weight of the strength carrying members are the largest in the industry.

Four Minster No. 4 O.B.I. presses give Handy Button exceptionally good die life and production flexibility.





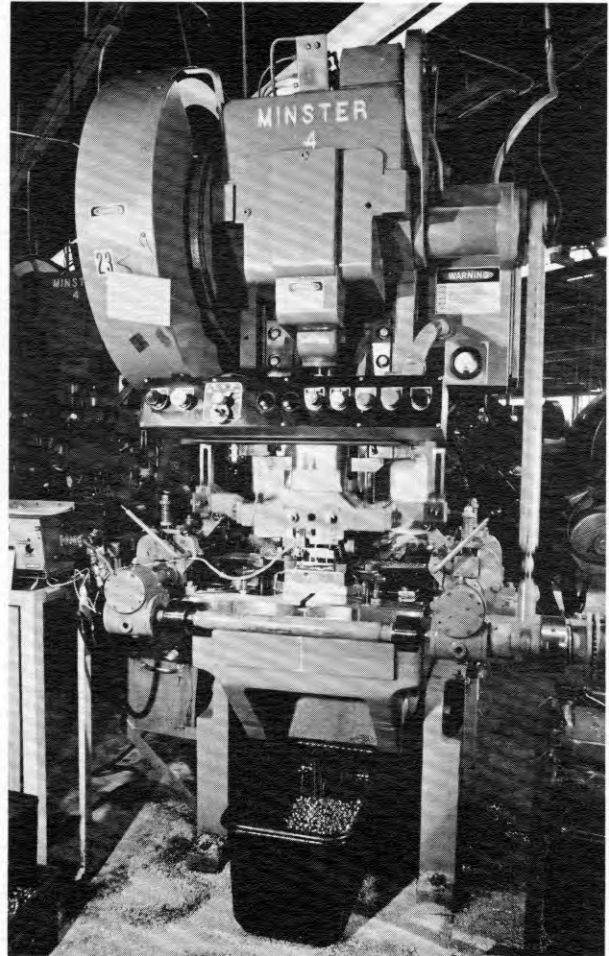
Mr. Dave Little, Plant Superintendent.

Adjustable Stroke Presses Give Handy Button Better Scheduling Flexibility

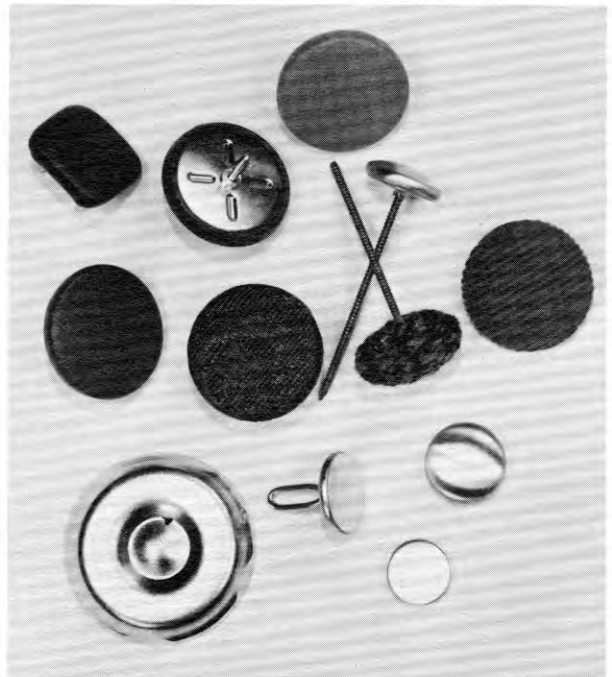
Overall, Handy Button has found several advantages in the use of variable or adjustable stroke presses, both Minsters and the other make. For example, they can run many different dies in the same press where before they were limited to two or three dies per press because of the fixed stroke. Thus, they are now able to schedule part runs as desired to gain maximum press utilization and eliminate idle time. In addition, with shorter stroke capability, speed can be increased on many dies from 100 spm to as high as 250 spm. Handy Button now has 14 adjustable stroke presses doing the work previously performed with 28 fixed stroke machines.

According to Mr. Little, Handy Button Machine Company will probably buy more Minster presses. "I'd like to have ten more just like them. The price is higher but we've already got that back in longer die life. With this experience with Minster presses we'll investigate more of them for future applications."

Handy Button Machine Company makes over 10,000 different items . . . the most complete line of covered buttons, grommets, glides, fasteners, T-nuts, brackets, upholstery nails, bedding hardware, etc. They also make button covering machines. Their markets are international including furniture, garment, upholstery, automotive and packaging. The 80 year old firm is headquartered in Chicago where it employs about 425 people (up from 160 employees in 1960). Another plant in Woodside, N.Y. serves the garment industry primarily. With their modern mass production methods, big volume and wealth of experience in product development it is easy to see why their slogan is "The Good Word is Handy".



This press, operating at 250 spm on a five-out die, produces a million parts per day.



Array of some of the 10,000 items in Handy Button Machine Company's product line.