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## Doubling up on pressing production

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**A new high speed press has allowed Batten & Allen to double productivity and cut unit costs on a complex telecom component by using two tools in a single continuous operation.**

The Bruderer BSTA 510-125 high-speed press was installed in April 2011 at Batten & Allen's Cirencester factory.

The 1,250 mm length of the machine's bolster plate allows room for two large progression dies to be mounted in-line for manufacturing complex components in one continuous operation. Alternatively, there is sufficient bed width for two tools to be mounted side-by-side and fed with separate coils. In both cases, production output is doubled.

Stamping speed is up to 1,050 strokes per minute – 17.5 hits per second.

The press is fitted with a bolster plate that is extended by 150 mm to 1,250 mm, providing extra room for a longer progression tool, or two tools in-line.

The first job put on the new Bruderer press did not utilise its twin servo feeds, but exploited the long bed to accommodate two existing tools in series that were previously used on separate 25-ton presses. Designed to produce tin-plated brass components for a telecommunications equipment manufacturer, one tool carries out the blanking while the other completes the subsequent forming. All operations are now performed in one continuous process in the 51-ton press.

Mr Batten continued, "This technique results in a substantial saving in unit manufacturing cost, not least through reduced labour content."

He added that parallel stamping while feeding two strips through the press will be similarly beneficial, as they can utilise two existing, separate tool / die sets from other presses to provide extra, high productivity stamping capacity for all components. Increasing use of multi-out progression tools also assists in maximising output.

There are currently 24 Swiss-built Bruderer presses on the Cirencester site installed in a temperature controlled, 'closed-door' environment.



Telecom products are now made in one step rather than in separate blanking and forming operations

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