

SOLUTIONS

from Gasser

FALL 2010 / VOL. 21

CAPABILITY MATTERS

When it comes to producing precision components to exacting specifications, capability does matter. It matters when we consider which press should be used to stamp or deep draw your part. We have more than forty presses, from 5 to 500 tons, both mechanical and hydraulic. It is important that your part be produced on the right-size machine to assure the most cost-effective operation. Feeds, speeds and pressing power will match the material, thickness and configuration requirements of your part for flawless performance from beginning to end of the production run.

Capability matters when it comes to the tolerances required by your part. Our Engineering Department works in "hundredths," "thousandths," and even "tenths" to meet your part specifications. And so do our machine tools. We build all our own tooling at Gasser for blanking, stamping and deep drawing operations. This tooling is kept sharp, ready for use and maintained in our 10,000-tool die library. It is important that we have the capacity to handle this volume in our own facility with the die sets all color-coded for easy storage and retrieval. Individual punches and their matching die cavities measure from 1/16" up to 12" in diameter and tolerances are held from +/- .005" to as close as +/- .0005" to meet your part specifications.

Capability matters, too, when it comes to any secondary machining that may be required on your part. We have large and small CNC lathes and machining centers to accommodate your part for operations that may range from drilling and boring to complex milling and contouring to tolerances as close as .0001."

Finally, capability is quite obvious when it comes to our warehouse capacity. A 20,000 square foot facility holds a constantly moving inventory of the materials needed for customer parts. The latest computerized control system manages the flow of sheets, rolls, tubes, plates and castings from materials coming in the receiving door to parts leaving the shipping door.



Whether your part is smaller than a fingernail or larger than a dinner plate, we can produce it to your specifications.



This coil-fed press is set up for a long production run.



Gasser has more than forty presses, ranging from 5 to 500 tons to match your part requirements.

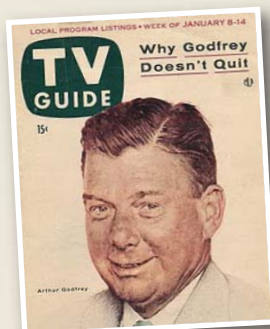
GASSER & SONS, INC.
440 Moreland Road
Commack, NY 11725

THIRTY-FIVE YEARS AFTER GASSER WAS FOUNDED, IN 1951:



1/10/51
First jet passenger trip made

2/1/51
First X-ray moving picture process demonstrated



6/25/51
First color TV broadcast, Arthur Godfrey Show on CBS



TRADE SHOWS

We look forward to welcoming you to our booth at these upcoming shows:

Design-2-Part Show
February 23-24
Grapevine, TX

Design-2-Part Show
March 16-17
Atlanta, GA

ABOUT GASSER...

- Founded in 1916, owned by the founding family's third generation.
- Providing deep drawn, stamped and machined precision parts to industries ranging from medical X-ray, electrical and electronic, to laser, electro-optical, defense, aerospace and semiconductor.
- Equipped with mechanical, hydraulic and transfer deep drawing presses, as well as machining and turning centers.
- "People" resources, with a staff of over 100, that include degreed engineers, tool & die makers, machinists, CNC operators and programmers, a quality control team and the backing of ISO 9000:2008 certification.
- Computerized manufacturing and warehousing systems to schedule and track your job from raw materials, through the manufacturing cycle, to finished parts and coordinated delivery.

Celebrating
94
 YEARS
 1916 - 2010

FOREIGN EXCHANGE RATES

As of 11/12/10 Per US \$

Canadian Dollar	1.01
British Pound	.62
Chinese Yuan	6.63
Euro	.72
Japanese Yen	82.11
Swiss Franc	.97

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**CERTIFIED
 ISO 9001:2008**

CROSS-TRAINING BOOSTS PRODUCTIVITY

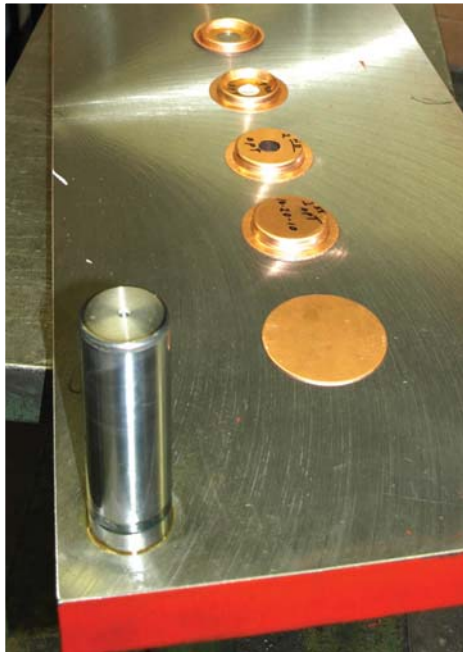
The machining departments at Gasser range from long rows of CNC lathes and turning centers to busy "cells" of CNC machining centers. Once an operator is proficient on one machine, he or she begins a cross-training program on another, and then another. When a part comes off one of our stamping or deep drawing presses, it often needs secondary machining operations to complete the component. It may need to be turned, milled, bored, drilled, tapped or chamfered to specifications that may be as close as .0001" tolerance. We make sure that the person responsible for each machine will perform those operations on our customers' parts quickly and productively.

Cross-training programs provide for the situation that if a particular machine operator is out for some reason, such as illness or vacation, there is always another ready to fill in to keep the flow on schedule. Also, while a machine is working on a part run, that machine's operator is capable of performing additional operations or setups on another machine. Moreover, all operators are involved in the quality control aspects of their part runs. At Gasser, cross-training programs give the operators new skill sets to optimize their capabilities and assure our customers of speed and precision in the manufacture of their components.



This machine operator is being cross-trained on a CNC turning center.

PROGRESSIVE PRECISION



The progressive die being built for this part will weigh over 800 lbs. when completed.

Gasser designs and manufactures progressive dies for high precision stamped components that are required by many industries. Our engineers design these dies to achieve optimal progress at each station, while minimizing the amount of leftover scrap. As a feeding system uncoils the strip material and sends it through the die, each station performs one or more operations until a finished part is made. The final station separates the part from the strip, called the carrying web, which is binned for recycling.

Gasser builds progressive dies that can weigh upwards of a thousand pounds and perform up to a dozen or more operations with each stroke of the reciprocating stamping press. As the press moves up, the top die moves with it and the strip advances one station. When the press moves down, the die closes and performs the stamping operation. The strip material goes from a blank to a precision stamped, formed and separated part, with a completed part coming off the die at each stroke of the press.

Because additional work is done at each station as the strip



Twelve stations bring this part from blank to completion.

advances, we make sure that the feed is very precise to assure alignment within a few thousandths of an inch as it moves from station to station. Our dies are made of high grade tool steel to maintain sharp cutting edges and withstand the abrasion and repeated shock of long production runs.

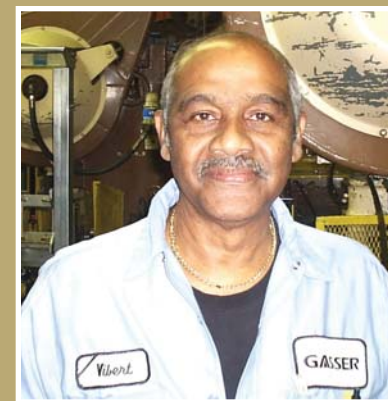
For short runs, machining components on lathes and machining centers may be more practical, but when you take into account multiple setups and operations on these machine tools, you can't beat a progressive die for long production runs of parts made quickly and with repeatable accuracy.



A stamping press is prepared for a progressive die at Gasser.

MILESTONE

In this issue we salute **Vibert W. (Max) McKenzie** for his 18 years of service to Gasser & Sons. Max is a die setter in our production department, making sure that our customers' part runs get off to a great start. Thank you for your dedication, Max.



\$OLUTION \$EARCH.

The correct solution to last issue's puzzle is: I had 32 gold coins. The winner of the drawing of the correct answer is Brian Tilbury of Spellman High Voltage Electronics Corp. Enjoy your \$100 Home Depot gift card, Brian!

HERE'S THIS ISSUE'S BRAIN TICKLER:

A progressive die set can be completed by 4 die makers in 11 days. If 8 more die makers join the team 5 days after work has started on the die set, then how many more days are required to complete the job?

Send your answer, along with your name and address to sales@gasser.com and have your winning answer entered into a drawing for a \$100 Home Depot gift card. Good Luck!

