



Empire Die Casting Co., Inc. Company Information Survey

1.0 COMPANY

COMPANY NAME
STREET
CITY
STATE
ZIP
TELEPHONE
FAX

**EMPIRE DIE CASTING CO., INC
635 EAST HIGHLAND ROAD
MACEDONIA
OH
44056
330-467-0750
330-467-9118**

- CORPORATE
 PUBLIC
 PRIVATE
 MINORITY OWNED

DO YOU HAVE A UNION?
CONTRACT EXPIRES
UNION AFFILIATIONS

**YES
2013
TEAMSTERS LOCAL 416**

MAIN PRODUCT(S)

**RECREATION
MEDICAL SUPPLIES
BUSINESS MACHINES
GOVERNMENT
APPLIANCES
LAWN / GARDEN
PUMPS / VALVES
2ND / 3RD TIER AUTO
ELECTRIC INSTRUMENTS
HEAVY TRUCKING
HAND POWERED TOOLS
MECHANICAL DEVICES
HVAC**

ALLOYS

ALUMINUM AND ZINC

WHAT IS YOUR COMPANY'S
DIRECTION / MISSION?

**QUALITY DRIVEN PEOPLE
DEDICATED TO PRODUCING THE
BEST PRODUCT THROUGH CONTINUOUS
IMPROVEMENT IN COMMUNICATION,
TRAINING AND SERVICE.**

2.0 BUSINESS

YEARS IN BUSINESS	60
SALES LAST YEAR	\$ 40M
SALES THIS YEAR	\$ 50M
SALES NEXT YEAR	\$ 60M

3.0 FINANCE

BANK REFERENCE	
NAME	CITIZENS BANK
PHONE	248-324-8646
STREET	38701 SEVEN MILE ROAD
CITY	LIVONIA
STATE	MI
ZIP	48152

4.0 REFERENCES

UPON REQUEST

5.0 BUILDING SPACE (SQ. FT.)

ADMINISTRATION	15,000
PRODUCTION	100,000
TOOL ROOM	25,000
WAREHOUSE	25,000
OTHER	35,000
TOTAL	200,000+

6.0 EXECUTIVE AND KEY PERSONNEL

CEO	RICHARD P. ROGEL
PRESIDENT	ROBERT A. HOPKINS
EXECUTIVE VICE PRESIDENT	PAUL HEAD
FINANCIAL CONTROLLER	DENVER BORTZ
ENGINEERING	MARK KUBICKI
QUALITY	FRANK PRIJATEL

7.0 WORKFORCE

PRODUCTION	108
QUALITY ASSURANCE	10
ENGINEERING	5
MAINTENANCE	17
TOOLMAKERS	27
OTHER	28
TOTALS	195

8.0 ENGINEERING RESOURCES

FORMAL ENGINEERING DEPARTMENTS

**DESIGN TOOLING
MANUFACTURING SUPPORT
REPAIR / SERVICE**

SPECIAL ENGINEERING TOOLS

MAGMA FLOW SIMULATION

ENGINEERING PROCEDURES

**NEW PRODUCT DEVELOPMENT PROCESS GUIDELINES
DESIGN GUIDELINES**

FILE FORMATS ACCEPTED

**STEP FILES
. (IGES)
.DXF / .DWG
SAT**

9.0 MANUFACTURING

MANUFACTURING CONTROLS

**ASSEMBLY PROCEDURES
WORK ORDERS
INSPECTION PROCEDURES
LOT TRAVELERS / ROUTING SHEETS PROCESS
PROCESS CHARTS
CORRECTIVE ACTION
STATISTICAL PROCESS CONTROL**

SECONDARY CAPABILITIES

**MACHINING
ASSEMBLY / TESTING
SHOT BLASTING
VIBRATORY AND THERMAL DEBURR
PARTS WASHING**

SECONDARY – (OUTSOURCE)

**PAINT: POWDER, WET, POLAN, E-COAT
COATING: ANODIZE, ALODINE, IMPREGNATE, DICHROMATE, HOT COAT,
AND CHROME
HEAT TREAT / STRESS RELIEF
POLISHING, BUFFING, SANDING**

DO WE HAVE A MODEL SHOP AND PROTOTYPE CAPABILITIES?

YES – BOTH IN-HOUSE AND OUTSOURCED

10.0 QUALITY ASSURANCE

HOW ARE REQUIREMENTS / SPECIFICATIONS COMMUNICATED TO OUR SUPPLIERS?
THROUGH PURCHASE ORDERS AND BLUEPRINTS

WHAT IS OUR WARRANTY PERIOD?
90 DAYS ON PURCHASED PRODUCT

HOW DO WE MEASURE QUALITY?
CUSTOMER SURVEYS, CUSTOMER COMPLAINTS, COMPANY GOALS.

WHAT IS OUR QUALITY ACCEPTANCE RATE WITH OUR CUSTOMERS?
99%

DO WE HAVE A TRAINING PROGRAM FOR ENW EMPLOYEES?
YES – 12 HOUR COURSE COVERING SAFETY, JOB DUTIES AND CONTINUOUS ON THE JOB TRAINING

DO WE MONITOR OUR IN-PROCESS DEFECT RATE?
YES

HOW IS OUR IN-PROCESS DEFECT RATE MEASURED?
SCRAP AND RETURNS

HOW IS OUR PROCESSES CONTROLLED?
DIE CASTING PROCESS IS MONITORED THROUGH SHOT SCOPE. QUALITY INSPECTION SHEETS UTILIZED BY FLOOR INSPECTORS.

WHAT INSPECTION CAPABILITIES DO WE HAVE?
INCOMING INSPECTION, FAI, IN PROCESS INSPECTION, FINAL INSPECTION AND LAYOUT CAPABILITIES.

WHAT INSPECTION RECORDS ARE AVAILABLE AND HOW ARE THEY MAINTAINED?
QUALITY INSPECTION SHEETS, IN PROCESS, INCOMING INSPECTION, DOCK AUDITS, LAYOUT HARD COPY AND ELECTRONIC.

DO WE USE STATISTICAL SAMPLING PLANS?
YES

HOW ARE THEY DEVELOPED?
CUSTOMER-DRIVEN SAMPLING PLAN RANGES FROM C=ZERO TO AQL-3.0

OUR CALIBRATION / MAINTENANCE PROCESS.
GAGETRAK SOFTWARE (ALL GAUGES IN-HOUSE ARE CONTROLLED BY THIS SYSTEM).

HOW IS NON-CONFORMING MATERIAL CONTROLLED?
SEGREGATED AREA AND TAG SYSTEM

DESCRIBE THE DISTRIBUTION OF DRAWINGS PROCEDURES, SPECIFICATIONS, ETC., BOTH INITIAL RELEASES AND CURRENT REVISIONS, TO AFFECTED OPERATIONAL AREAS OF OUR ORGANIZATION.

CONTROLLED BY ENGINEERING DEPARTMENT. UPON ACCEPTANCE OF DRAWINGS, THE DRAWING IS DISTRIBUTED TO ALL DEPARTMENTS THROUGH A JOB MAINTENANCE FORM.

ARE WE ISO 9001 CERTIFIED?

YES

ARE WE IN THE PROCESS OF UPDATING OUR QUALITY SYSTEM?

YES

IS AN UP-TO-DATE QUALITY MANUAL AVAILABLE?

YES

11.0 GENERAL

DO WE HAVE A LIST OF INSPECTION / MANUFACTURING / TEST EQUIPMENT?

YES – TWO CMM OPTICAL COMPARATORS, SPECTROMETER AND STANDARD GAUGES.