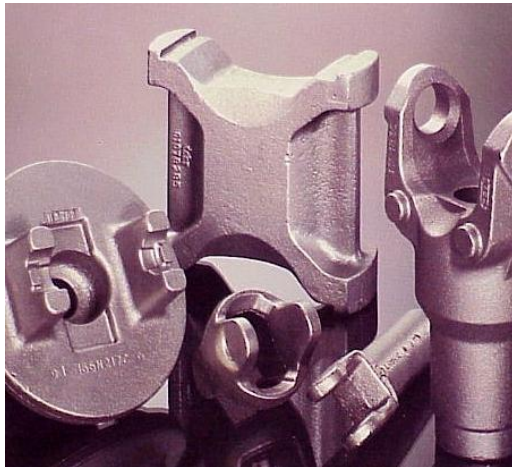


Dotson Dispatch



More than 500,000 ductile iron yokes and steering knuckles are cast every year by Dotson. Most yoke castings are poured with a 100-70-03 as cast specification and weigh between 2 and 50 pounds. The trucking industry and off-road vehicles are our largest customer sector.

Dotson Capabilities:

- Gray Iron
- Ductile Iron
- Austempered Ductile Iron
- 1 to 75 Pounds
- Machining
- Painting
- Plating
- Assembly



Cores – All sizes – All shapes

Over 80% of castings shipped by The Dotson Company use one or more cores to define internal passages and undercut areas. In our 124-year history, we have used many different processes to make these cores including oil sand cores, bench cores, shell cores, blower cores, CO₂ and isocure cores.

The varied hand tools used in the past required a long apprentice period to learn the skills needed to sculpt the cores.



With the installation of our second Laempe Isocure Core Center, we are completing a

\$1,250,000 upgrade of our core department.



Very soon, 100% of our cores will be made on these computer-controlled machines.

Benefits include:

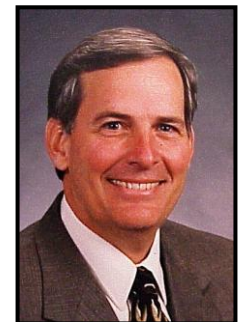
- Greatly reduced process variation, which enhances core consistency.
- Setup time is reduced 90% by replacing nuts and bolts with vacuum holding of core boxes.
- Sand mixes, pressures, and cycle times are automatically set from computer memory.
- Larger core boxes mean more cavities per box.
- Cycle times are up to 300% faster than shell cores and up to 150% faster than the old isocure machines.

- Horizontal and vertical blowing allows more intricate coring which may reduce the number of cores required

The bottom line is that when it comes to cored castings, The Dotson Company is the best of the best.

We have now completed our core department upgrade and we are midway in our five-year plan to modernize all of the foundry departments – melt, mold and finishing. In April, a new \$500,000 metal charging system will be up and running (a 20% increase in melt capacity).

Our continued thanks go out to all our strategic partners.



President, The Dotson Company
ddotson@dotson.com



PENNSYLVANIA

THE KEYSTONE STATE

Pennsylvania, a name created by England's Charles II when he granted William Penn a charter in 1680, means "Penn's woods." Authorized by the U.S. Congress, the Pennsylvania Quarter Dollar depicts America's first president, George Washington. The reverse design features the outline of the state of Pennsylvania, highlighting the keystone emblem, as well as the state motto and the statue Commonwealth. Philadelphia, Pennsylvania is home of the United States Mint, the world's largest manufacturer of coins, medals, and coin-based consumer products.

Second in a Series
of 50 from...

Dotson

COMPANY, INC.

Mankato, MN 56002-1270
Iron Castings & Machining
www.dotson.com

STATEHOOD DATE:

DECEMBER 12, 1787

Motto: Virtue, Liberty, and
Independence

Nickname: Keystone State

Flower: Mountain Laurel

Tree: Hemlock

Bird: Ruffed Grouse

Population: 11,900,000

DENVER MINT

PHILADELPHIA MINT

