

Contact clip is used within an automotive horn plate.

Product Description:



The component shown here was designed for use as a horn plate contact clip in an automotive application. The die was designed and built to the customer's supplied engineering drawing, upon completion of die fabrication the customer was supplied with a first article inspection report for approval.

The contact clip which is composed of .006" thick, CA172 beryllium copper, required tolerances of $\pm .001$ " to be maintained throughout the 8 million parts that are produced annually.

Maintaining quality throughout a volume run such as this requires stringent quality control measures. This run employs a quality system that includes a video measuring system, a race track for critical dimensions, as well as batch sample retention. The run was performed on our high speed 30 ton Bruderer press, which features die protection sensors. It also utilizes a system that automatically counts and bags the parts, adding a greater level of accuracy while protecting the finished parts from damage. Deliveries are made on a just-in-time (JIT) basis to support customer's inventory control. Shipments to the customer include all applicable material Certs, and COCs. For more information on this progressive die stamping project, please see table below.

Precision Progressive Die Stamping Capabilities Applied/Processes

Primary:

Progressive Die Stamping

Secondary:

Special Packaging

- Automatically Counted Into Small Bags for Shipping

Special Process

- Automatic Packaging for Accurate Count and Protection of Parts

Equipment Used to Manufacture Part	30 Ton Bruderer	
Overall Part Dimensions	.127" x .202"	
Tightest Tolerances	±.001"	
Material Used	.006" Thick CA172 Beryllium Copper	
In process testing/inspection performed	Video Measuring System Optical Comparator First Article Inspection (FAI) Race Track for Critical Dimensions Batch Sample Retention Sensored for Die Protection Raw Material Certification Certificate of Conformance (COC)	
Industry for Use	Automotive	
Volume	8,000,000 Annually	
Delivery/Turnaround Time	Just In Time (JIT)	
Delivery Location	USA	
Standards Met/Directives Met	ISO 9001	REACH
	QMI-SAI Global	ASTM
	ANAB	MIL-SPEC
	RoHS	Dodd-Frank
	DFARS	(Conflict Materials Act)
Product Name	Contact Clip	
File Format	SolidWorks	

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