

Product Description: *This contact is used for reading light switches in an automotive application.*



The product shown here was produced utilizing our precision progressive die stamping capabilities. Designed as a contact for an automotive lighting application, this component required precision as well as high speed.

Because of our highly reputable stamping capabilities as well as our in-house Die maintenance department, a customer asked if we would take in their existing tooling. We brought the die in-house and groomed it to produce first article inspection samples which were provided to the customer for approval. Utilizing our 30 ton Bruderer punch press, we now produce 2.3 million of these parts annually. Our Customer requires the parts to be placed on a Reel-to-Reel fashion in order to support their assembly process.

Because the contact is composed of Pre-Plated .008" thick CA521 phosphor bronze, our customer was able to save money. Instead of the traditional post stamping process, we were able to have a master coil of .008 CA521 Phosphor Bronze plated to our customers specifications and then re-slit to our specified tooling material width for stamping. This process significantly cut the plating cost. Quality control is provided through a vision system which allows us to maintain a $\pm .0005$ " dimension with zero defect to the customer. We also provide a race track system for other critical dimensions.

To aid the customer's inventory needs we provide a Just-in-Time (JIT) delivery program. To learn more about this precision die stamping project, please see table.

Precision Progressive Die Stamping Capabilities Applied/Processes

- Primary:
Progressive Die Stamping
- Secondary:
Special Packaging
- Reel-to-Reel

Equipment Used to Manufacture Part	Special Process
Overall Part Dimensions	• Automatic Packaging for Accurate Count and Protection of Parts
Tightest Tolerances	30 Ton Bruderer
Material Used	.303" Diameter (Excluding Carrier)
In process testing/inspection performed	±.0005"
	.008" Thick Pre-Plated CA521 Phosphor Bronze
	Vision System
	Production Inspection Plan
	Optical Comparator
	First Article Inspection (FAI)
	Race Track for Critical Dimensions
	Batch Sample Retention
	Sensors for Die Protection
	Raw Material Certification
	Certificate of Conformance (COC)
Industry for Use	Automotive
Volume	2,300,000 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	Flex Finger Contact
File Format	SolidWorks

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