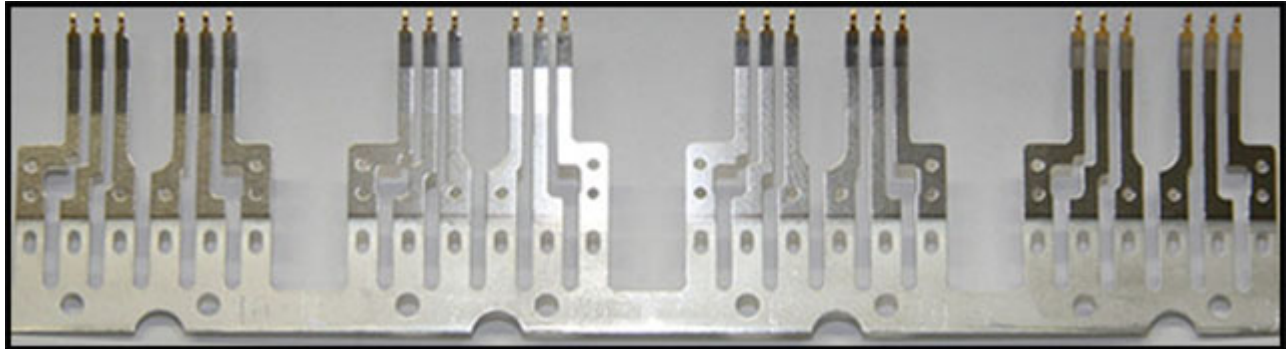


Product Description: *This leaf contact is used for a thumbwheel switch.*



A manufacturer of medical equipment asked us to develop this leaf contact that was to be used in a thumbwheel switch for a medical application. We prototyped this part using Chemical Etching and several low cost forms. We provided the customer with actual part samples, which allowed them to proof their concept at minimal cost. Once the part was approved, we designed and built a die in-house that produces 500,000 of these leaf contacts annually.

This bi-metal project was composed of .007” thick CA521 phosphor bronze with gold inlay. The contacts were manufactured on our 30 ton Bruderer press. Due to the design and precision of our tooling, we were able to meet tolerances of $\pm .001$ ”. This product also required special packaging, which utilized tool actuators that automatically cut the parts after four segments and placed them into custom trays. Quality control was maintained through a vision system as well as an optical comparator. Along with a batch sample retention system we maintained a zero defect to the customer. Shipments include all applicable Material Certification and Certificates of Conformance. For more information on this precision progressive die stamping project, please see table below or [contact us](#) directly.

Precision Progressive Die Stamping Capabilities Applied/Processes

- Primary:
 - Die Design & Build
 - Progressive Die Stamping
- Secondary:
 - Special Packaging
 - Placed into Custom Trays
 - Special Process
 - Automatically Cuts into 4 Segments Using In-Tool Actuators

Equipment Used to Manufacture Part

30 Ton Bruderer

Overall Part Dimensions	1.307”x 5.493” (4 segments on one strip)	
Tightest Tolerances	±.001”	
Material Used	Bi-Metal: .007” Thick CA521 Phosphor Bronze with Gold Inlay	
In process testing/inspection performed	Vision 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	Medical	
Volume	500,000 Annually	
Delivery/Turnaround Time	P.O. Schedule	
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	Leaf Contact	
File Format	AutoCAD	

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