

GSI GERHART STAMPING INC.

Providing Quality Stamping Solutions Since 1963 (818) 845-6459

Product Description: *Button Actuator for the 12C Calculator.*



At Gerhart Stamping, we specialize in precision high volume progressive die stamping for customers in a wide range of industries. The project shown here highlights our die design and building capabilities, and the flexibility of our manufacturing processes.

A high volume electronics manufacturer required the stamping of a calculator button from .003” thick, 302-stainless steel. The die was designed and fabricated in-house, and verified with first article parts which were approved by the customer. High speed production requires advanced equipment and quality control measures; this particular component was manufactured on our state of the art 30 ton Bruderer high speed press, which allowed us to meet high volume requirements and hold tolerances of $\pm .001$ ”. Quality is maintained through a vision system as well as traditional measuring devices such as an optical comparator and micrometers. Because our customer requested a soft touch button yet one that would pass their stringent endurance cycle requirements, we developed a tool that measured Gram trip and release force separately. This unique feature assured a very long lasting button all while keeping the soft touch the customer preferred. All Shipments are tracked with a batch sample retention system.

To accommodate the customers manufacturing process, we performed the stamping reel to reel. Running in this fashion also allows for the use of an automatic packaging system, and provides extremely accurate parts count. Deliveries are made on a just in time (JIT) basis to assist in customers inventory control. Shipments include all material certifications, and COC’s (certificates of compliance). For more information on this project, or to learn about our other capabilities, please see table below.

Precision Progressive Die Stamping Capabilities Applied/Processes

- Primary:
Die Design & Build
Progressive Die Stamping
Secondary:
Special Packaging
• Reel-To-Reel

	Special Process
	• Automatic Packaging for Accurate Count and Protection of Parts
Equipment Used to Manufacture Part	30 Ton Bruderer
Overall Part Dimensions	.450" x .450" (Excluding Carrier)
Tightest Tolerances	±.001"
Material Used	.003" Thick 302 Stainless Steel
In process testing/inspection performed	Vision System Optical Comparator Tool Measuring Gram Pressure Trip and Release Force 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	Electronics
Volume	12,000,000 Annually
Delivery/Turnaround Time	Just In Time (JIT)
Delivery Location	Tianjin, China
Standards Met/Directives Met	ISO 9001 REACH QMI-SAI Global ASTM ANAB MIL-SPEC RoHS Dodd-Frank DFARS (Conflict Materials Act)
Product Name	Actuator Button
File Format	AutoCad