Three Approaches to Tooling for Metal Stampings

Scandic Springs, Inc.
by Hale Foote

EMI Shield
4" long X 2" high X 2.5" wide
material is .031" thick Martinosite

1 No Tooling: the blanks are made with waterjet or laser,
and then formed with standard press brake tooling.
Possible exceptions: coined or drawn features, or compound radii
may need dedicated form tooling.

Cost: $0 tooling, $10/each for parts in moderate volume

2 Soft tool (a/k/a stage tooling, blank & form tooling):
invest in a stamping tool to make the blank,
then form with standard brake press tooling

Cost: $8,000 tooling, $4/each for parts
(this tool cost amortizes in just 1300 pcs)

3 Hard tooling: one die makes the part complete,
with no labor or handling
Cost: $38,000 tooling, $0.95/each for parts
(this tool cost amortizes in just 4200 pcs)