DeCardy Diecasting

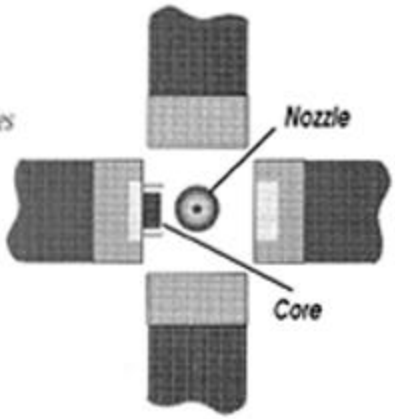
Quality Since 1907

Data Bulletin #402:

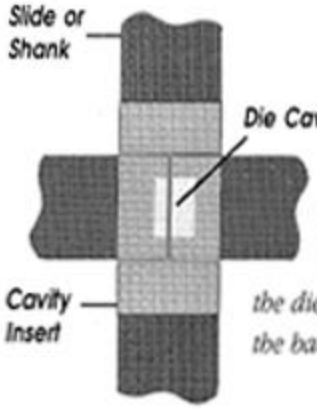
"4-Slide Tooling"

Part Two of the
Tooling for Zinc Diecastings Series

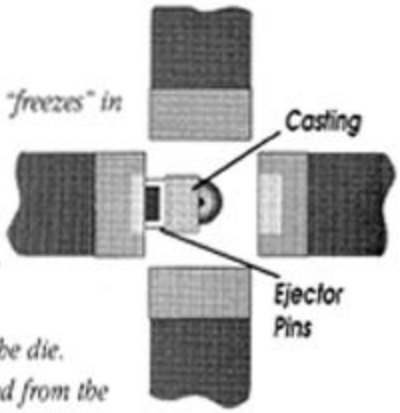
How It Works



Step 1: *The four slides of the die are about to close together to start a cycle.*



Step 2: *The die is closed and molten zinc alloy is injected into the die cavity through the nozzle from the back of the die.*



Step 3: *The molten zinc "freezes" in the die cavity. When the die opens the casting is ejected by ejector pins or a stripper plate assisted by air, from a chosen slide on the die. Here the casting is ejected from the left side, and will be blown clear of the die by a blast of air.*

The tooling you choose to manufacture your zinc diecasting is an important consideration in the successful production of your product. 4-slide tooling offers several advantages that may be beneficial to the casting designer.

4-Slide Tooling Advantages

- Single-cavity production is possible
- Tooling costs are lower ($5,000 – $10,000)
- A trim die is not required
- Die modification costs are lower.

Questions To Ask...

- Are the shanks included?
- Are the crossheads and covers included?
- Is the finish critical?
- Is the die warranteed?
- Is the die design submitted for review?

The enclosed part was produced by DeCardy Diecasting utilizing 4-slide tooling. Please examine it carefully.

Let DeCardy Diecasting recommend the best tooling to produce your product. Call or fax Will Vogel today.

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