



500 Series Part 1

Cost Saving Factors**Double Unit Die Casting****. . . can cut cast & trim costs by 35 - 48%
and tooling costs by 33 - 40%**

Double Unit Die Casting is a manufacturing method which enables your part to be simultaneously cast and trimmed with another part (*not necessarily yours*), virtually halving the machine and labor cost to cast and trim the parts.

Because the parts also share tooling costs, except for the part forming cavity, tooling for a new part can be as much as **\$5,000 to \$10,000 less**.

Excluding tooling, Double Unit Die Casting can **reduce your per piece costs by 30 to 45%** for parts requiring standard alloys, inspection, packaging and finishing.

**Your part is a good candidate for
Double Unit Die Casting if**

- Its largest and smallest dimensions are between 7.5 inches and 4.5 inches, and weighs between 8 oz. and 2 oz.
- Requirements do not exceed normal die casting Q.A. parameters.
- Annual volume is 25m parts or greater.
- It is to be cast from a standard zinc alloy.
- Turn around is tighter than normal.

When selecting a die caster, consider....

- Double Unit Die Casting experience and an excellent track-record should be the first thing you look for.
- The reason there are distinct die casting tooling methods is because each one offers a unique advantage. Make certain the supplier you choose offers the range of methods needed to best meet your requirements.
- Double Unit Die Casters specializing in parts similar to your requirements can offer faster turn around due to having a larger pool of other jobs in-house to pair-up. Also, one of the two dies can be changed as needed, (A 10,000 part order may be paired with 5,000, 3,000 and 2,000 part orders allowing all four orders to take advantage of double unit casting savings).
- There is no substitute for a plant tour. The quality of machines and the people who operate them are key factors in receiving your parts on time, to spec and within budget.

Example

Quantity: 10,000

**If Produced Conventionally****Tooling \$28,750.00**

#3 Zinc Alloy	\$	80.24/M
Cast / Trim		441.42/M
Vibramill		16.06/M
Inspection		4.92/M
Packaging		8.82/M
Total	\$	551.46/M

If Produced Double Unit**Tooling \$21,500.00**

#3 Zinc Alloy	\$	80.24/M
Cast / Trim		220.71/M
Vibramill		16.06/M
Inspection		2.46/M
Packaging		8.82/M
Total	\$	328.29/M

Got Questions?**We Have Answers!**

Call, fax, or e-mail us for a free Data Bulletin 3-Ring Binder

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