



LOW TO HIGH VOLUME PRECISION METAL STAMPING

TOOL & DIE DIVISION:

- LOW TO HIGH VOLUME METAL STAMPING
- 1,000 - 1,000,000 PIECES/YEAR
- WE DESIGN, BUILD, RUN AND MAINTAIN SIMPLE TO COMPLEX DIES
- FULL TOOL ROOM
- PROGRESSIVE, COMPOUND, BLANKING, FORMING, EXTRUSION, LOUVRE, SHEARING AND PUNCHING DIES
- WE SPECIALIZE IN LIGHT GAUGE (0.005" - 0.090") STAMPING
- PRESSES: 5 TONS TO 100 TONS (KOMATSU, BROWN BOGGS)
- AIR FEEDERS (12" WIDTH, 0.090" THICKNESS)
- **APPLICATIONS:** BRACKETS, TOOLS, ELECTRICAL CONNECTORS, FUSES, BUILDING AND ROOFING COMPONENTS, EMI SHIELDS, FACEPLATES, LIGHTING SYSTEMS, DECORATIVE PIECES
- **INDUSTRIES:** MEDICAL, DENTAL, FURNITURE, ELECTRICAL, ELECTRONICS, CONSTRUCTION, WINDOWS & DOORS, FISHING, MARINE, ARCHITECTURAL

HANSEN INDUSTRIES LTD. designs, builds, runs and maintains cost-effective custom dies for producing high quality, repeatable sheet metal stamped parts.

Before the development of Numerically Controlled (NC) and Computer Numerically Controlled (CNC) fabricating equipment, most precision metal parts were produced using templates or dedicated hard tooling. Although modern CNC lasers, punch presses and brakes offer quick changes and versatility, for higher volume metal parts, parts that repeat or have a long production life, stamping parts with traditional Hard Dies and mechanical punch presses can still be the best method of producing parts. Stamped parts typically have a higher repeatable accuracy and lower part cost.

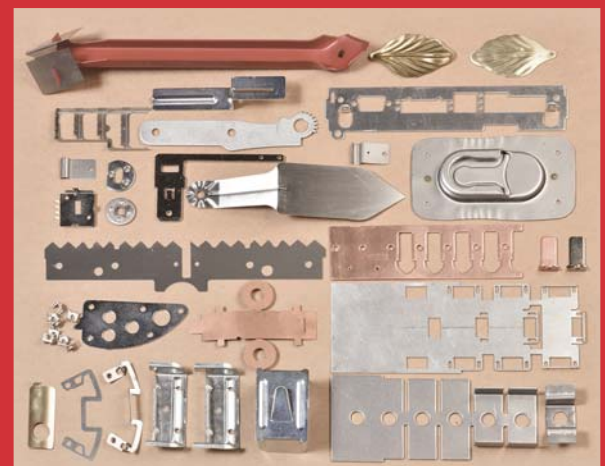
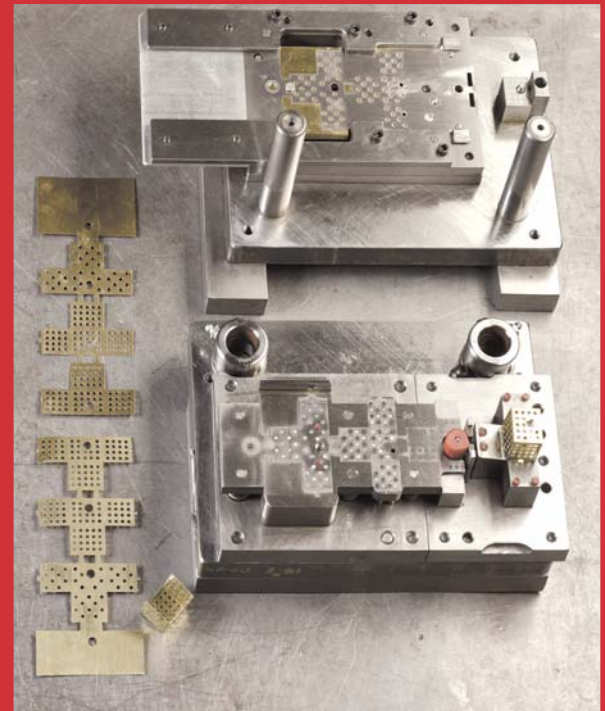
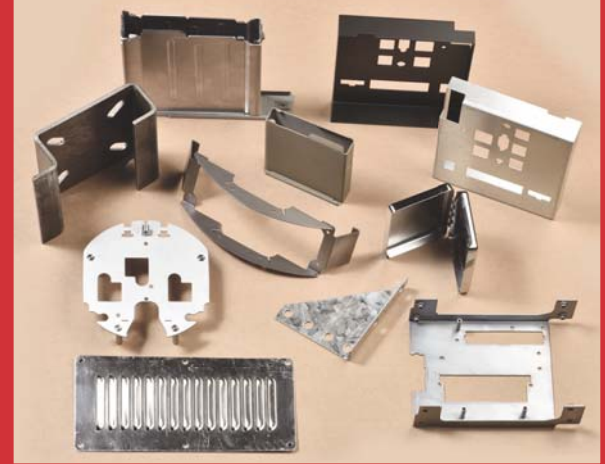
Hansen Industries Ltd. manufactures components for a variety of industries. These include electrical, electronics, construction, windows, doors, fishing, marine, medical, dental and architectural markets. We make progressive, compound, blanking, forming, extrusion, louvre, shearing and punching dies. The Estimated Annual Usage (EAU) greatly affects tooling cost. For low volume runs of 1,000 pieces per year, we can build simple single station dies. High volume dies of say 1,000,000 EAU need more complex progressive tools (Multi stages in one die). This type of tooling is more expensive to build but greatly reduces the piece part cost because you can run it at high speed. Typically, we prefer to run the dies that we make.

We build all our dies in-house from 3D models. Sections are generated from the models to create flat blanks or strip layouts for the die design. In the die building process, we use CNC machining to shape forms and Laser cutter to develop the parts. The dies are built of hardened tool steels and Electrical Discharge Machine (EDM) wire cutting is used to cut the final development of geometry in die steels and punches. The die steels and punches, are fully detailed for future remaking of each component should the die fail or wear out.

Once the die is assembled on a die set, it is mounted in a suitable punch press. The size and type of punch press is determined by the physical size, height, width and length of die and the desired punch speed. The tonnage required to cut, form and strip the part is calculated to ensure that press tonnage over exceeds the tonnage needed to make the part.

Most materials are produced from coils. The coil is placed on a de-coiler which is fed through a straightener into a feeder which controls the progression of the strip through the die. The punch press is timed with the feeder, so the strip is fed on every opening cycle of the press.

Once a first-off is approved, we continue to inspect parts during the production run. We take care of all the finishing requirements for our customers. A final inspection is then performed, after which the parts are packed and shipped to the customer.



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