



Plymouth Spring Desk Reference

A Portfolio of Fourslide Projects



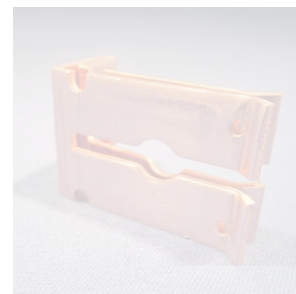
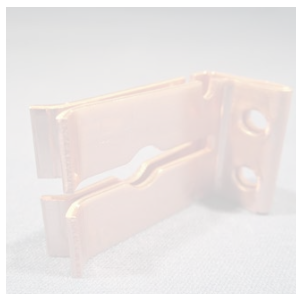
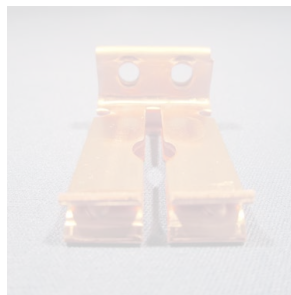
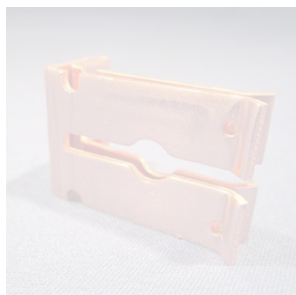


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Fourslide Stamping of Steel Terminal Boxes

A client from the electrical industry approached **Plymouth Spring Company, Inc.** to fourslide stamp a steel terminal box. This unique process involves forming, bending, folding and punching the pieces with a single machine. We fourslide stamped the 1074-5 steel, terminal block, and then case hardened the block to a Rockwell hardness of 45-55 and applied zinc electroplating.

The client's total yearly order of 30,000-50,000, .515" long and .366" wide 30 amp floating box terminals were dimensionally inspected and then delivered to the customer's Shelton, Connecticut location



For more details about this fourslide stamping project please see below.

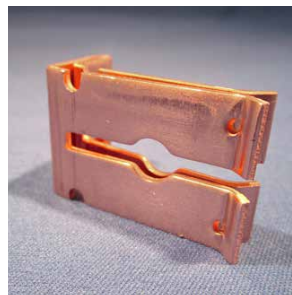
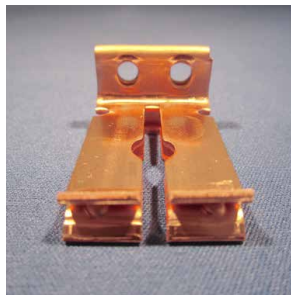
*To learn more about all of our other services please contact **Plymouth Spring**, today.*

Project Highlights of Fourslide Stamping

Product Description	These Fourslide Stamping Parts Are Used As a 30 Amp Terminal Box For An Electrical Application.	
Capabilities Applied/Processes	Primary: <ul style="list-style-type: none"> • Fourslide Stamping <ul style="list-style-type: none"> • Forming • Bending • Folding • Punching • Tapping 	Secondary: <ul style="list-style-type: none"> • Case Hardening <ul style="list-style-type: none"> • 45 to 55 Rc • Zinc Electroplating • Procurement <ul style="list-style-type: none"> • Purchase Correct Screw
Overall 30 Amp Floating Box Terminal Dimensions	<ul style="list-style-type: none"> • Length: .515" • Width: .366" 	<ul style="list-style-type: none"> • Thread: 10-32 UNF
Tightest Tolerances	• ±.005"	
Material Used	• 1074-5 Steel	
In process testing/ inspection performed	• Dimensional Inspection	
Industry for Use	• Electrical	
Volume	• 30,000-50,000 Per Year	
Turn Around Time	• 8 Weeks With Tooling	
Delivery Location	• Shelton, Connecticut	
Standards Met	• Customer Supplied Print	
Product Name	• 30 Amp Floating Box Terminal	

Fourslide Stamping of Beryllium Copper Mounting Brackets

Plymouth Spring Company, Inc. was approached by a mining industry client to fill a yearly order of 20,000 to 40,000, fourslide stamped, beryllium copper mounting brackets. We began by fourslide stamping the 1.126" long, .875" wide, .622" high and .029" thick mounting brackets. This unique process included punching, folding and cutting the beryllium copper with a single machine. We then heat treated and nickel plated the brackets. Throughout the entire process we held tightest tolerances of $\pm .005$ ". Each bracket was dimensionally inspected and then shipped to Wilkes Barre, Pennsylvania.



If you want to learn more about this fourslide stamping project, please see the details below.

*For information about the rest of our outstanding services, please contact **Plymouth Spring.***

Project Highlights of Fourslide Stamping

Product Description	These Beryllium Copper Bracket Are Used To Mount The Light On Mining Helmets.	
Capabilities Applied/Processes	Primary: <ul style="list-style-type: none"> • Fourslide Stamping • Folding • Punching • Cutting 	Secondary: <ul style="list-style-type: none"> • Heat Treatment <ul style="list-style-type: none"> • Heat Treat to 38-42 Rc • Nickel Plating
Overall Beryllium Copper Mounting Brackets Dimensions	<ul style="list-style-type: none"> • Material Thickness: .029" • Length: 1.126" 	<ul style="list-style-type: none"> • Width: .875" • Height: .622"
Tightest Tolerances	• $\pm .005$ "	
Material Used	• Beryllium Copper	
In process testing/ inspection performed	• Dimensional Inspection	
Industry for Use	• Mining	
Volume	• 20,000-40,000 Per Year	
Turn Around Time	• 6 Weeks Because Of Raw Material Lead Time	
Delivery Location	• Wilkes Barre, Pennsylvania	
Standards Met	• Customer Supplied Print	
Product Name	• Beryllium Copper Mounting Bracket	