

# Royal Development Company



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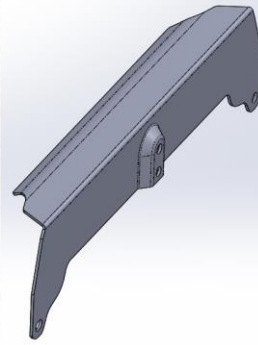
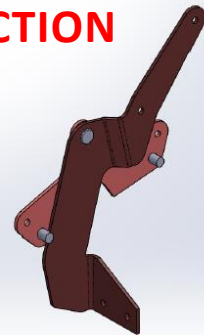
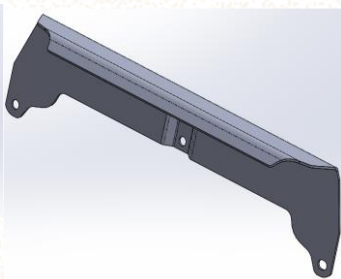
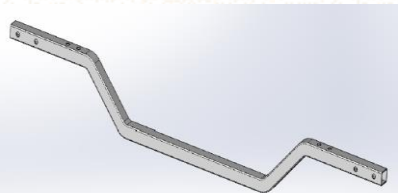
## FULL-SERVICE METAL STAMPING - Making Quality Metal Components & Assemblies Since 1965

- ✓ 22 Stamping Presses Ranging in Capacity from 50-800 Tons
- ✓ 36 Forming Presses from 30-75 Tons
- ✓ Progressive Stamping and Multi-Out Tooling
- ✓ 5 Full-Time Tool & Die Professionals
- ✓ Extensive Manufacturing Automation
- ✓ Over 100 Rivet Machines for Assembly
- ✓ Tube Mill and Tube Fabrication
- ✓ 4 Vibratory Tumblers for Deburring Parts
- ✓ Fabrication, Assembly and Welding
- ✓ Complete Cleaning, Finishing, Dip-Paint System, Plating, Anodizing



200,000 Sq. Ft. Manufacturing Facility High Point, NC

### DESIGN • DEVELOPMENT • PRODUCTION



# Royal Development Company

**Efficient and Economical High Production Stamping**

**High Precision Tolerances vs. Other Manufacturing Methods**  
 $\pm.005''$  for Linear Dimensions,  $\pm.0015''$  on Punched Hole Dimensions

**One-Time Tooling Charge for Lifetime Tooling**

**In-House Tool Room**

CAD-CAM, Wire & Small Hole EDM, and CNC machining for Tool Building and Die Maintenance

**Short Lead-Times**

Just days in some situations with existing tooling

**Wide Variety of Raw Material Options**

Carbon steel, stainless steel, aluminum, brass copper and pre-painted metals, Thickness .068" through .188", 48" max feed width

**Additional Value Added Services**

Rivet insertion, PEM insertion, tapping, machining, welding, painting, plating, anodizing and assembly



# Stamping Process Commonly Used Terms



**Blanking** – using a custom made punch and die, parts are blanked from sheared strips and/or coil to the exact size of the part in it's flat state.

**Piercing** – parts have all holes and shapes pierced in a single press stroke using a custom made piercing tool, which maintains a very high degree of accuracy and repeatability as well as much shorter cycle times with relatively low tooling costs.

**Forming** – parts may be formed in custom made, multiple bend forming tools, or in stock, single bend tooling depending on the part complexity and order volume.

**Progressive Tooling** - multiple operations, such as piercing, coining, stenciling, embossing and more can be incorporated into a single stroke tool, greatly reducing run time and part cost with minimal tooling expense.

**Secondary Operations** – parts may be processed through secondary operations such as machining, tapping, countersinking, reaming, etc. Parts may also have additional assembly such as spot welding, hardware installation, providing you with a completed part from a single supplier.

**Finishing** – a wide variety of protective finishes are available such as: zinc plating, black oxide, wet & powder painting, anodizing and more.



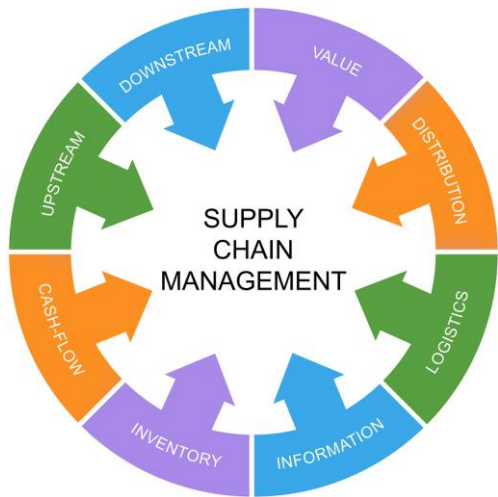
MAKE	MODEL	TYPE	TONNAGE	BED SIZE L-R x F-B (IN)	STROKE (IN )
VERSON	SE2-800-84-42T	SSDC	800	84 X 42	6
VERSON	SE2-800-84-42T	SSDC	800	84 X 42	6
VERSON	SE4-800-84-72T	SSDC	800	84 X 72	12
DANLY	H2-400-84-48	SSDC	400	84 X 48	12
MINSTER	40E-9 SSDC	SSDC	400	36 X 48	5
DANLY	H2-400-84-48	SSDC	400	84 X 48	12
NIAGARA	BP 400-60-48	SSDC	400	60 X 48	14
DANLY	H2-400-84-48	SSDC	400	84 X 48	12
DANLY	H2-400-84-48	SSDC	400	84 X 48	12
USI CLEARING	BP2-300-72-42	SSDC	300	72 X 42	8
USI CLEARING	S2-200-48-42	SSDC	200	48 X 42	12
USI CLEARING	S2-200-48-42	SSDC	200	48 X 42	12
MINSTER	OBI #7	OBI	175	36 X 24	4
AIDA	NC2-160 (2B)	GAP FRAME DC	175	80 X 30	8
KOMATSU	OBW-150-2	GAP FRAME DC	150	79 X 30	8
VERSON	150-GP2-96	GAP FRAME (OBS)	150	96 X 30	8
KOMATSU	OBW-150-2	GAP FRAME DC	150	79 X 30	8
BLISS	C-110	GAP FRAME (OBS)	110	48 X 28	6
AIDA	NC2-110 (1)	GAP FRAME (OBS)	110	74 X 20	4
AIDA	NC2-110 (1)	GAP FRAME (OBS)	110	74 X 20	4
KOMATSU	OBS-110 VS -3	GAP FRAME (OBS)	110	43 X 27	6
KOMATSU	OBS-80-3	GAP FRAME (OBS)	88	40 X 24	5
MINSTER	OBI #7	OBI	75	36 x 24	4

## Forming Press Technical Information



PRESSES	MAKE	MODEL	TYPE	TONNAGE	BED SIZE L-R x F-B (IN)	STROKE (IN)	SHUT HEIGHT (in)	SPM
1	NIAGARA	M150	OBI	150	50 x 30	6	18	35
1	FEDERAL	F8	OBI	100	36 X 28	6	20	45
1	NIAGARA	A5	OBI	100	39 X 25	6	18	40
1	CLEVELAND	10-I	OBI	90	36 X 28	8	18	40
12	NIAGARA	ES75	OBI	75	36 X 24	8	21	90
3	NIAGARA	E75	OBI	75	36 X 24	8	20	40
5	USI CLEARING	TOR PAC 60	OBI	60	32 X 21	13	17	45-90
1	SOUTH BEND	OBI-60	OBI	60	32 X 21	4	12	100
1	SOUTH BEND	60 FW-AC	OBI	60	32 X 21	4	12	100
1	NIAGARA	M-60	OBI	60	32 X 21	6	10	60
1	TOLEDO	# 5A	OBI	50	28 X 18	3	12	60
1	USI CLEARING	TOR PAC 45	OBI	45	28 X 18	3	12	60
1	NIAGARA	M-45	OBI	45	28 X 18	3	12	60-180
1	ROUSELLE	# 4F	OBI	40	26 X 16	3	36	105

# How can we help achieve your goals?



## Reduce

Cost  
Risk  
Lead-Time  
Inventory  
Waste  
Transportation and Handling  
Disruption and Distraction  
Administrative Burden



## Increase

Profits  
Inventory Turns  
Quality  
Velocity to Market  
Manufacturing Flexibility  
Capacity - Scale  
Focus on Core Competency

