



**ROYAL
DEVELOPMENT**

METAL STAMPING

www.RoyalMetalStamping.com

MAKING QUALITY METAL COMPONENTS AND ASSEMBLIES SINCE 1965...

Chad Schmidt - Director of Sales
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- ✓ 58 Stamping Presses from 30-800 Tons
- ✓ Progressive and Multi-Out Tooling
- ✓ Full-Time Tool & Die Shop – Design, Build, Maintain
- ✓ Fiber Laser Cutting – Steel, Aluminum, Stainless, Copper Sheet
- ✓ Small Profile Steel Tube Mill and Value Added Tube Fabrication
- ✓ Hardware Insertion, Welding and Assembly with over 100 Rivet Machines
- ✓ Extensive Manufacturing Automation
- ✓ Complete Cleaning and Dip-Paint System In-House
- ✓ Outside Services Include Plating, Anodizing, Heat Treating and Powder Coating



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





Efficient and Economical High Production Stamping

High Precision Tolerances vs. Other Manufacturing Methods

$\pm.005''$ for Linear Dimensions, $\pm.0015''$ on Punched Hole Dimensions

In-House Tool Room

CAD-CAM, Wire & Small Hole EDM, and CNC machining for Tool Building and Die Maintenance, One-Time Tooling Charge for Lifetime Tooling

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





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Stamping Press Technical Information

| PRESSES | MAKE | MODEL | TYPE | TONNAGE | BED SIZE L-R x F-B (IN) | STROKE (IN) |
|---------|--------------|----------------|-----------------|---------|-------------------------------|----------------|
| 2 | VERSION | SE2-800-84-42T | SSDC | 800 | 84 X 42 | 6 |
| 1 | VERSION | SE4-600-84-72T | SSDC | 600 | 84 X 72 | 12 |
| 4 | DANLY | H2-400-84-48 | SSDC | 400 | 84 X 48 | 12 |
| 1 | MINSTER | 40E-9 SSDC | SSDC | 400 | 36 X 48 | 5 |
| 1 | NIAGARA | BP 400-60-48 | SSDC | 400 | 60 X 48 | 14 |
| 1 | NIAGARA | SC2-300-72-42P | SSDC | 300 | 72 X 42 | 8 |
| 2 | USI CLEARING | S2-200-48-42 | SSDC | 200 | 48 X 42 | 12 |
| 1 | MINSTER | OBI #7 | OBI | 175 | 36 X 24 | 4 |
| 1 | AIDA | NC2-160 (2B) | GAP FRAME DC | 175 | 80 X 30 | 8 |
| 2 | KOMATSU | OBW-150-2 | GAP FRAME DC | 150 | 79 X 30 | 8 |
| 1 | VERSION | 150-GP2-96 | GAP FRAME (OBS) | 150 | 96 X 30 | 8 |
| 1 | BLISS | C-110 | GAP FRAME (OBS) | 110 | 48 X 28 | 6 |
| 2 | AIDA | NC2-110 (1) | GAP FRAME (OBS) | 110 | 74 X 20 | 4 |
| 1 | KOMATSU | OBS-110 VS -3 | GAP FRAME (OBS) | 110 | 43 X 27 | 6 |
| 1 | KOMATSU | OBS-80-3 | GAP FRAME (OBS) | 88 | 40 X 24 | 5 |

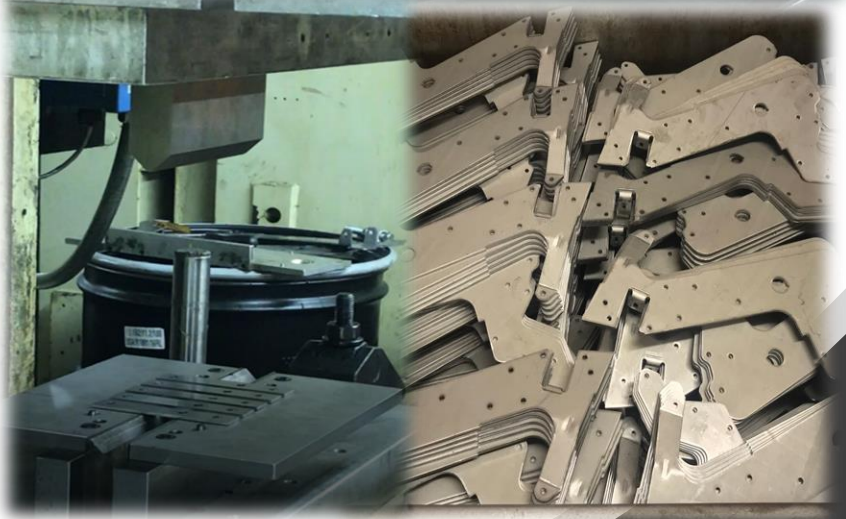
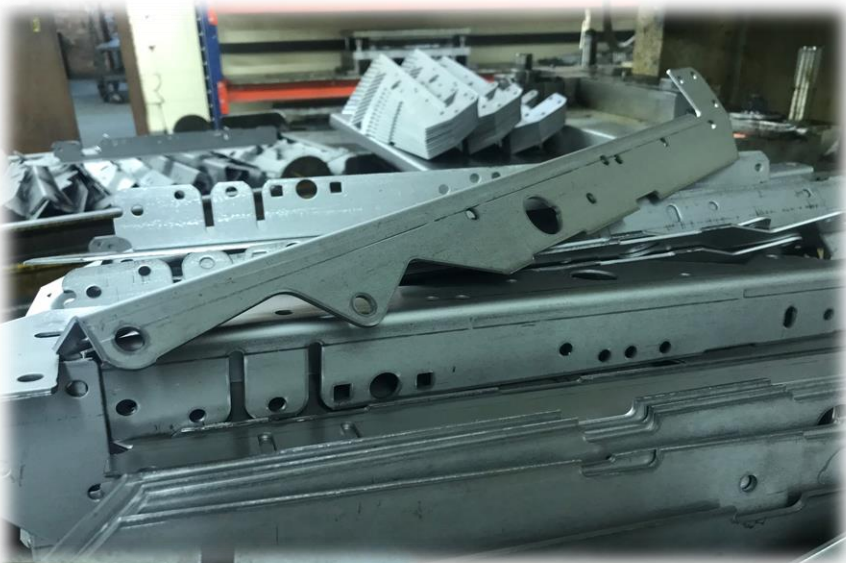


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Stamping Press Technical Information



| 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 |
| 1 | MINSTER | OBI #7 | OBI | 75 | 36 x 24 | 4 | 18 | 60 |
| 12 | NIAGARA | ES75 | OBI | 75 | 36 X 24 | 8 | 21 | 90 |
| 3 | NIAGARA | E75 | OBI | 75 | 36 X 24 | 8 | 20 | 40 |
| 6 | 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 |



Commonly Used Stamping 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.



METAL STAMPING

Fiber Laser Cutting



5' x 10' Shuttle Table



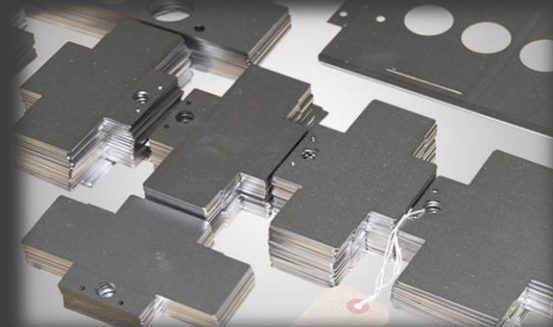
Faster – Cuts Carbon Steel up to 4x faster than CO₂ Laser; reducing your lead-time.

Improved Quality – Tighter and more consistent dimensional tolerances, sharper edges and cleaner cut edges than CO₂. Less edge prep for powder coating; saving you labor

Reflective Metals - Cuts reflective metals like stainless steel, aluminum and red metal alloys at a blazing rate. Using Nitrogen improves already excellent edge condition. CO₂ can't compare.

Cost of Operation – Cost to operate and maintenance is a fraction of the cost of traditional CO₂ Lasers; **saving you money**

Speed to Market & No Tooling Costs – With .DWG, .DXF. or .STP files, part can be quoted, programmed and cut within hours. You can launch a new product quickly and then transition to hard tool stamping to reduce your unit cost over the long-haul.





Tube Manufacturing and Fabrication

TUBE MILL

ROUND

SQUARE

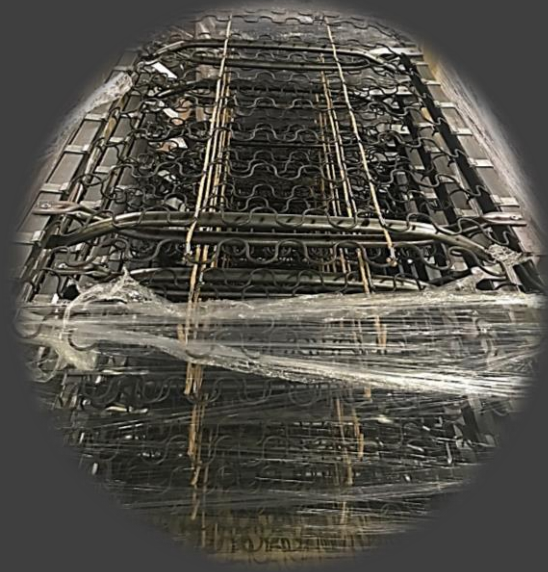
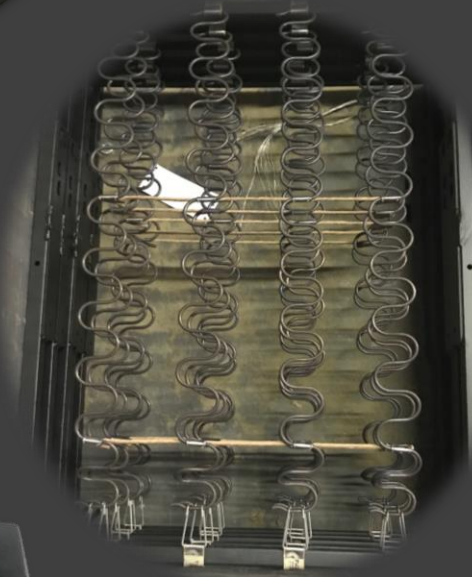
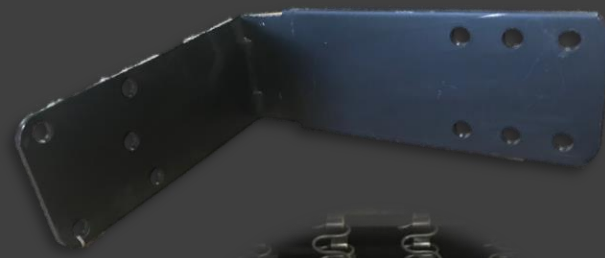
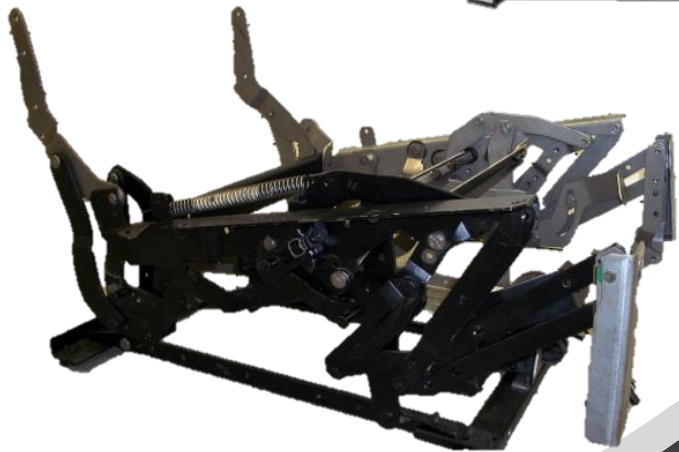
**RADIUS
CORNERS**

| Available Tube Sizes | | | | |
|--------------------------------|---------------|--------|-------------------------|-------|
| Tube Size | Decimal (in) | Square | Square (Radius Corners) | Round |
| 1.0" | 1.000 | X | - | - |
| 7/8" | 0.875 | - | - | X |
| 3/4" | 0.750 | X | X | - |
| 5/8" | 0.625 | X | X | X |
| Tube Mill Length and Tolerance | | | | |
| Minimum Length | | 31.00" | ±.0625" | |
| Maximum Length | | 96.00" | ±.0625" | |
| Tube Wall Thickness | | | | |
| Gauge | Decimal (in) | | | |
| 16ga | (.0548-.0658) | | | |
| 18ga | (.0438-.0528) | | | |





**Specializing in Manufacture of Recliner,
Glider, Motion Furniture Components,
Mechanisms and Accessories**





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How can we help achieve your goals?

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Reduce

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



Increase

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