GRIP*flow*® STAMPING

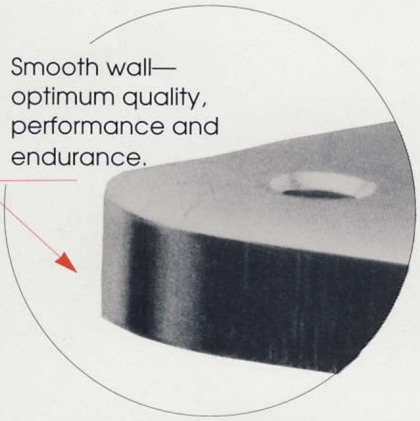
Gain a competitive advantage with the Gripflow system…

Stamp out secondary operations with Gripflow. Are you broaching, drilling, or flattening? Gripflow puts an end to these costly operations. How is this achieved? Gripflow can stamp the part to the print tolerance—the sides are smooth and straight—there is no taper or die break.

Secondary Operations
- -Drilling
- -Reaming
- -Countersinking
- -Counterboring
- -Milling
- -Broaching

COMPARE GRIPFLOW TO CONVENTIONAL STAMPING

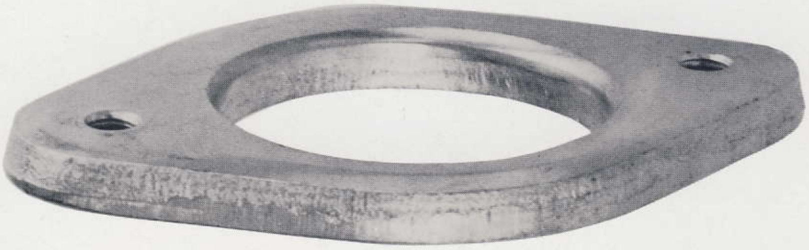
Smooth wall—optimum quality, performance and endurance.



GRIPFLOW STAMPING

Fully sheared—accurate all the way. No break.

Poor bearing surface due to tapering.

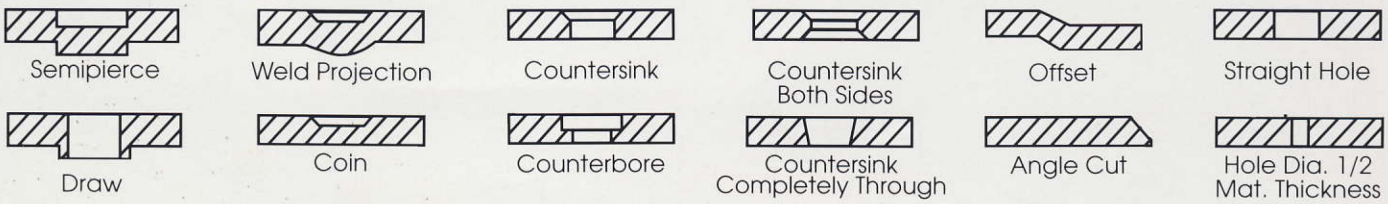


CONVENTIONAL STAMPING

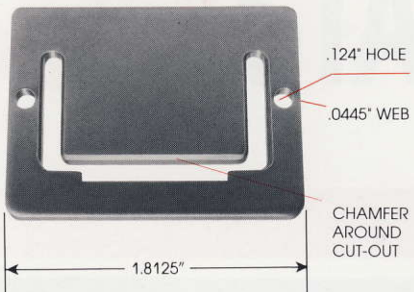
Break shows poor quality Only 1/3 shear surface.

Good looks signify quality-and today quality sells products

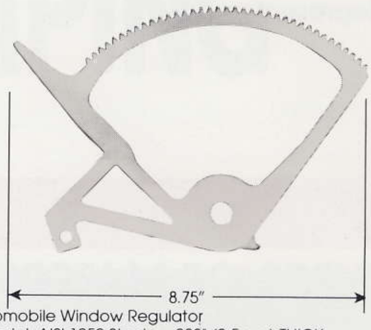
Gripflow isn't only a stamping method—in many instances it is an effective substitute for several precision machining functions, i.e. countersinking, counterboring, trepanning, chamfering, hole reaming, milling, grinding, gear tooth hobbing, etc.



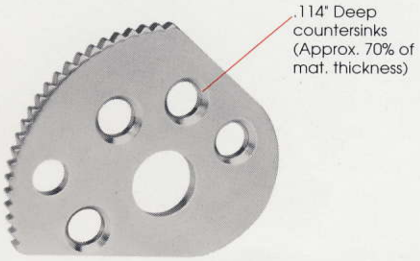
Automotive Distributor Counterweight
Material: AISI 1010 Steel --- .200" (5.08mm) THICK
Gripflow eliminates drilling holes close to the edge.



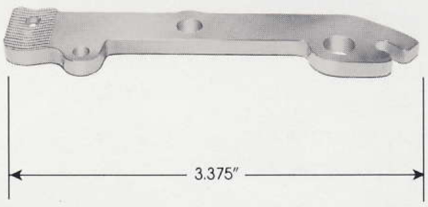
Staple Gun Wear Plate
Material: AISI 1010 Steel --- .125" (3.17 mm) THICK
Gripflow eliminates drilling of the holes and machining the chamfer.



Automobile Window Regulator
Material: AISI 1050 Steel --- .098" (2.5mm) THICK
Gripflow eliminates broaching of the teeth.



Automotive Parking Brake Ratchet
Material: AISI 1020 Steel --- .164" (4.17 mm) THICK
Gripflow eliminates broaching of the teeth and machining of the countersinks.



Sunroof Liftarm
Material: AISI 1010 Steel --- .149" (3.78mm) THICK
Gripflow combines coin and form with blank and pierce operation.

Lawnmower Bracket
Material: AISI 1010 Steel --- .260" (6.60mm) THICK
Gripflow eliminates machining of large hole and broaching of the teeth.

Every Gripflow part has its own success story. This picture shows a number of Gripflow parts that have helped our customers reduce tooling and part costs and improve product quality.

Gripflow is NOT Fineblanking. The benefits are the same, but Gripflow outperforms Fineblanking in speed of production, tool life, and economy. For more details, ask for our Gripflow bulletin "Fineblanking Alternative".

GRIPFLOW FEATURES

- True square edges with full bearing area. Edges are parallel to each other.
- Edge surface finish to 32 RMS.
- Accurate dimensions: Tolerances down to .0005" flatness to .001".
- Repeatability: Part to part consistency is excellent.
- Elimination of many secondary operations such as coining, shaving, finish milling, hole reaming, drilling, broaching, etc.
- One stamping station can include: Piercing, coining, embossing, lancing, bending, and blanking.
- Small hole diameters can be pierced --- as small as 1/2 of material thickness.
- Holes can be pierced close to the edge --- with a web of 1/2 of material thickness.
- Capacity: Maximum is 3/4" thick low carbon steel.

GRIPFLOW COSTS

The cost of Gripflow parts are considerably less expensive than conventional stampings requiring secondary operations.

The most advanced machining techniques including CNC machining cannot compete with GRIPflow production rates, part accuracy, or quality.

Tooling cost for Gripflow stamping dies is 10% to 30% less than conventional stamping dies. These savings are a result of specialized die-making procedures and equipment developed by EBway Corporation.

*Represented by:

TYPES OF MATERIALS

GRIPFLOW is normally able to process any metal which has good cold working characteristics. The following is a partial list of recommended material.

MATERIAL	COMMENTS
Mild Steel No. 3,4,5 Hardness	Excellent
Mild Steel No. 1 & 2 Hardness	Good
Spring Steel to .50% Carbon	Excellent if run from annealed stock.
Spring Steel to .70% Carbon	Good
Spring Steel to .95% Carbon	Fair
Stainless Steel Annealed	Good
Copper and Brass Alloys	Excellent
Aluminum	Excellent

OUR SERVICES

We want to produce Gripflow parts for your firm. We have complete pressroom facilities with press equipment ranging to 400 ton capacity. Ferrous and nonferrous parts up to .750" thick can be Gripflowed.

Our manufacturing and supporting services are geared for both low and high volume production.

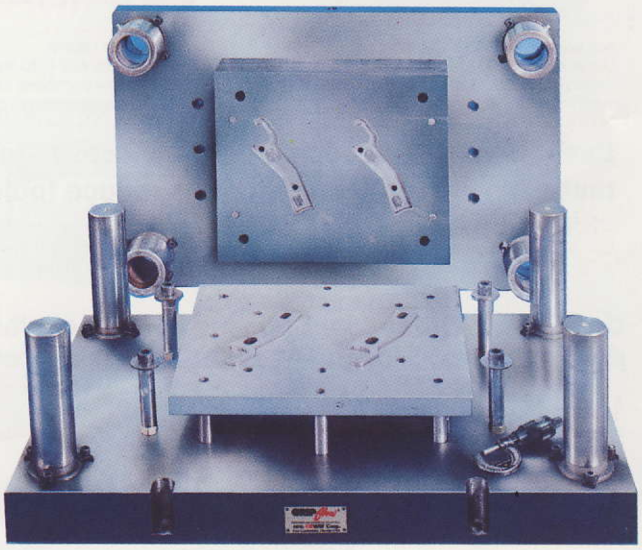
Additional services such as plating, heat treating, tapping, etc, are provided through subcontractors.

Our diemaking group is one of the most advanced in the United States. EBway die designs are used in over twenty-five countries of the world.

To take advantage of Gripflow and to enable you to buy better quality parts for less money, we suggest you send us your part prints for evaluation and quotation.

TYPICAL INDUSTRIES UTILIZING GRIPFLOW PARTS

Aerospace	Electrical	Machine Tools
Appliance	Firearms	Marine
Automotive	Furniture	Office Machines
Computer	Hand Tools	Recreational Equipment
Construction	Hardware	Surgical Instruments
Cutlery	Lawn & Garden	Textile



HOW GRIPFLOW WORKS

Gripflow is relatively simple in operation. Reduced to its essentials, it requires the use of a special die design, zero clearance between punch and die, controlled presspeed, and retention of the stamping during the Gripflow process.

Basically a Gripflow stamping is squeezed from the parent material at a press rate of 20 to 100 parts per minute. By producing more than one part per press stroke, which is a common practice, production rates can be doubled and even tripled.

Production speed is dependent on part size, material type and thickness.

CALL OR WRITE TODAY!

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