

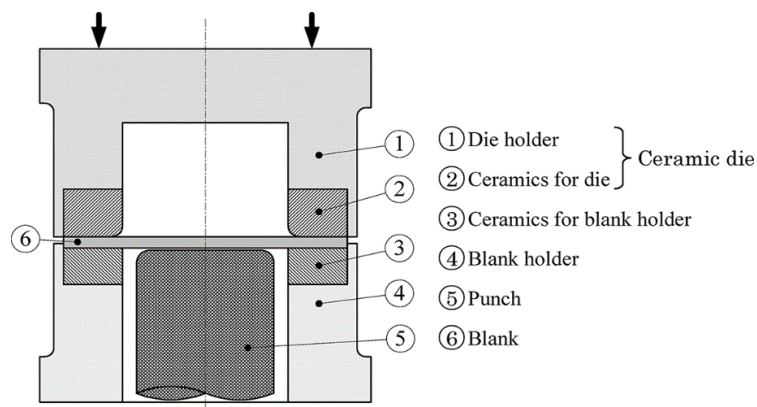
## DEEP DRAWING

**Gestión de Compras** have the means to get the parts manufactured by deep drawing. We offer the most competitive products because we work with all materials and alloys and a wide range of processes.

### PROCESS:

Deep drawing is a sheet metal manufacturing process. This operation transforms a flat sheet blank into a three-dimensional part. Usually, the depth of the drawn part exceeds its diameter it is the reason why this process is called "deep".

The way to carry out a deep drawing process is with a punch and a die. The punch has the desired shape of the base of the part. The die cavity matches the punch and is a little wider to allow for its passage, as well as clearance. Clearance must be enough to avoid cut the sheet and allow the material flow. Sheet metal piece, called blank, is hold over the die opening by pressure apply by a blank holder. The punch travels towards the blank. The punch forces the sheet metal into the die cavity, forming desired shape. Parts manufactured by deep drawing cannot be complex shapes, being necessary do the process in several phases for complex parts.



Hydraulic or mechanical presses are necessary to carry out this industrial process. Hydraulic presses can control blank holder and punch separately but the mechanical presses are usually faster.

Deep drawing has a big production rate and a very good dimensional precision, but also generates too much strain on the material may cause defects as wrinkling or fractures.

To prevent these defects is necessary to ensure an acceptable draw ratio, a proper lubricant and a correct holder force.

## **PRODUCTION:**

In **Gestión de Compras** we are professionals in a wide range of deep drawing parts. We adapt our production lines for every new customer design to make products with the best quality at lowest price.

Our factories have necessary equipment with different ranges of tonnage and dimension to manufacture any part that costumers need.

Below, some examples of our companies' equipment:



## **MATERIALS AND PRODUCTS:**

For this process, material must be ductile and malleable with a low yield stress and enough plasticity to obtain the desired part without fractures. For this reason, more suitable materials are:

- Mild steel
- Austenitic stainless steel
- Low alloy aluminium and copper.
- Brass

Deep drawing is specially used by automotive industry and for recipes manufacture as could be: crankcase, gas tanks, mudguards, suspension arms, container lids, cups, bowls, containers, tanks, fire extinguishers, back cover for spotlights, kitchenware, bearings...

We can see some of them on following pictures:



## STANDARD AND CERTIFICATES:

We have the means to ensure our products comply the general regulation and the specific certificated regulations in manufacturing products that requires them.

- ISO 9001 and ISO 14001
- TS 16949
- ASTM A1008 / A1008M
- OHSAS 18001



## CONTACT:

In **Gestión de Compras** work with a wide range of customers from different sectors but have in common the search for products that suit your needs at the best Price and the guaranteed maximum quality. Check with us about any product. We have a qualified staff who will advise you.

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