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# MetaLife.

## DIE CAST PRICE SHEET



Photo of casting that was produced from H-13 die cast die @ 47-48Rc.  
 For more information visit [www.badgermetal.com/bmtcastg.htm](http://www.badgermetal.com/bmtcastg.htm)

surface texture  
 max to min  
 T-41H/40H  
 T-41/40  
 T-21  
 T-61/60\*  
 T-71/70\*

*Aluminum sample castings to evaluate actual surface texture, as shown above, are available upon request. (processing automatically includes the entire cast surface & runner area on each insert). Pricing per insert is calculated @ \$5.50 per sq. in. for any of the above processes.*

**Plus**

There is a component "Set-Up-Charge" per insert as listed in the table below.

### Minimum Order \$150

*T-61/60 *T-71-70 LIMITED TO FLAT SURFACES	MAX COMPRESSIVE STRESS DEPTH FOR 47Rc H-13	MAX SUB-SURFACE COMPRESSIVE STRESS VALUE
T-41H/40H	.018"	-160 KSI
T-41/40	..012"	-145 KSI
T-21/20	.007"	-140 KSI
T-61/60*	.013"	-150 KSI
T-71/70*	.017"	-125 KSI

Total Cu. In. Volume*	Set-Up Charge per Piece
.9 or less	\$40.00
1-1.9	\$60.00
2-9	\$80.00
10-19	\$100.00
20-39	\$120.00
40-99	\$140.00
100-149	\$160.00
150-199	\$170.00
200-299	\$190.00
300-399	\$200.00
400-499	\$210.00
500-699	\$220.00
700-999	\$230.00
1000-1499	\$240.00
1500-2999	\$250.00
3000-4999	\$260.00
5000-10000	\$270.00

Visit our website address to view  
 X-ray diffraction curves:  
[www.badgermetal.com/ml-curves.htm](http://www.badgermetal.com/ml-curves.htm)

Pricing does not include prior 1000 degree heat stress tempering which is recommended for used tooling with extensive shots.

Note: Prior NITRIDING or any other hardening surface treatment while allowing us to induce surface compressive stress may inhibit crack closure ability.

\*Maximum Height, Width, Length, or Diameter dimensions in inches. are used for calculation of the block or cylinder sizes. Set-up charge is on a per piece basis.

**TERMS:** Net 15 Days - F.O.B. Menomonee Falls, WI - Prices Effective 3/1/2001 (reprint 1/1/2010)