

PRECISION THAT SCALES.

From 0.1mm Micro-Stampings to Deep Drawn Housings

Z&T Metal Stamping Services

THE FULL SPECTRUM OF STAMPING.

Under One Roof.

200+

Presses

12T–630T

Tonnage Range

100M+

Annual Capacity

0.1–6.0mm

Material Thickness

Tonnage 12T – 630T

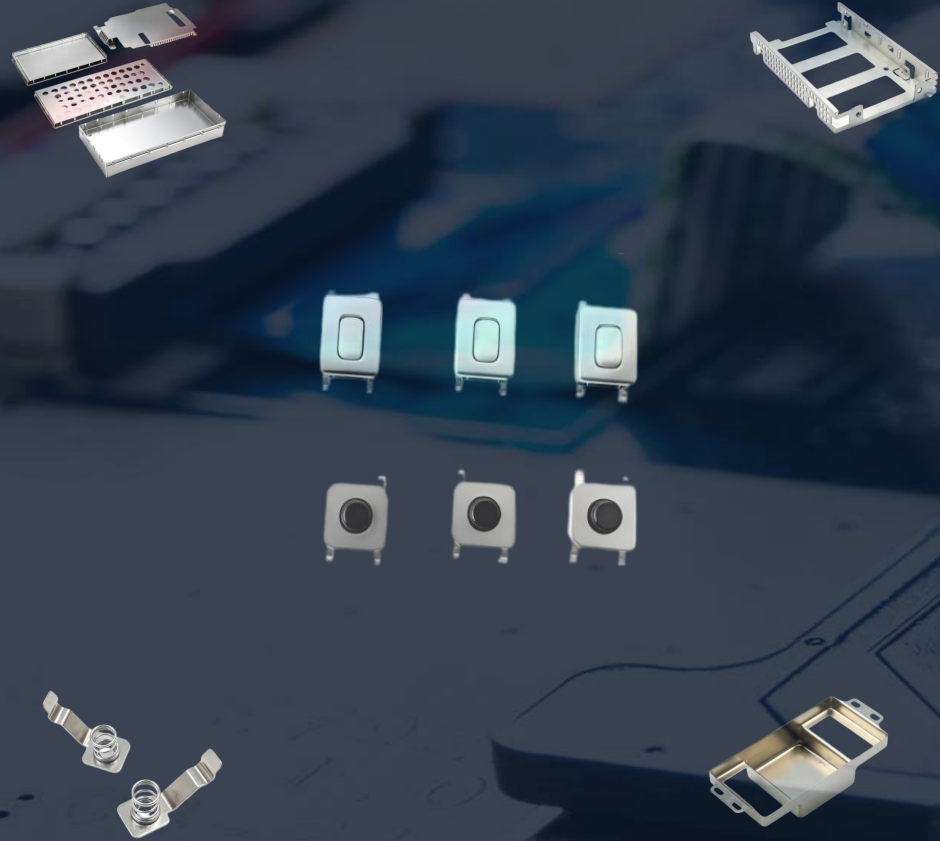
We route your part to the optimal press for cost and quality. Thickness range 0.1mm – 6.0mm. Not every shop can say that.

In-House Tooling Control

8 wire EDM machines. New dies delivered in 15–30 days. Design changes implemented in hours, not weeks.

Automotive-Grade Quality

IATF 16949 certified. Full PPAP Level 3 support as standard. Lot-level traceability on every shipment.



From 5G base stations to your smartphone, our micro-stampings are the invisible connections that make electronics work.

Precision Micro Stamping

01

EMI / RFI Shielding Cans

- Material: Nickel Silver & Tin-Plated CRS
- Flatness: ≤ 0.05 mm
- Burr direction controlled inward for SMT safety

02

Electrical Contact Springs

- Material: Phosphor Bronze, BeCu, Stainless Steel
- Force tolerance: $\pm 8\%$
- Heat-treated in-house for full fatigue life

03

Tactile Dome Switches

- Material: 301 Stainless Steel
- Actuation force: 100 g – 500 g
- Snap ratio $\geq 40\%$ for crisp tactile feedback

Progressive & Compound Die Stamping

Progressive Die Stamping (Up to 20 Stations)

- Corrugated metal gaskets with in-die coining for uniform profile
- Slotted angle brackets — slot-to-bend accuracy ± 0.1 mm
- High-volume production: 500,000th part identical to the first

Compound Die Stamping

- Precision metal washers — ID/OD concentricity ≤ 0.1 mm
- Metal caps and covers with burr-free edges
- Alignment plates — hole position accuracy ± 0.05 mm

The Z&T Tooling Difference: All dies designed, wire-cut, and assembled in-house. 8 DK7750 EDM machines. Tooling modifications in hours, not weeks.

Deep Drawn Metal Parts

Seamless Construction

Single-piece parts eliminate weld seams, leak paths & crevice corrosion. Max depth 300mm. Draw ratio up to 2.5:1.

Heavy-Gauge Capability

630T hydraulic press draws stainless steel up to 3.0mm thick. Wall thickness uniformity $\geq 80\%$ of original blank.

Sanitary & Pressure Applications

Electropolished to $Ra \leq 0.4\mu\text{m}$ for pharma & food contact. Pressure-tested filter housings available.

"A weld is a potential failure point. Our deep drawn parts eliminate the weld, the leak path, and the worry."

PRODUCTS

Max Depth 300mm · Draw Ratio 2.5:1 · Wall Uniformity $\geq 80\%$



Deep Drawn Caps



Oxygen Cylinder Covers



Stainless Steel Sinks



Filter Housings

The Heart of Stamping: **IN-HOUSE TOOLING**

8 DK7750 EDM

DESIGN

CAD / UG / SolidWorks for 3D die design and strip layout simulation

MACHINING

8 DK7750 wire EDM machines. Surface grinders and CNC mills for precision components

MATERIALS

Cr12MoV, DC53, SKD11 tool steels. Carbide inserts for 1,000,000+ hits between sharpening

LEAD TIMES

Simple dies: 15–20 days. Complex progressive dies: 30–45 days

"When your order is running late because a supplier's die needs repair, our toolmakers are already walking to the press."

Quality & Certifications

IATF 16949



Automotive quality management system — mandatory for Tier-1 supply chains worldwide.

GJB9001C



China military quality system standard — approved for defense and aerospace applications.

ISO 9001:2015



Global quality management certification covering all manufacturing and support processes.

Precision Data

$\leq 0.05\text{mm}$

Flatness tolerance
(EMI shielding cans)

$\pm 0.05\text{mm}$

Hole position accuracy
(alignment plates)

$\pm 8\%$

Force tolerance
(contact springs)

$Ra \leq 0.4\mu\text{m}$

Surface finish
(electropolished)

Ready to Discuss Your Stamping Project?

Upload your drawing for a free DFM review and budgetary quote within 24 hours.

Web: www.zntmetal.com

Email: info@zntmetal.com

Factory: Tianjin & Cangzhou, China