Cold Forming and Machining Comparison Quick Reference

	Cold Forming	Screw Machining
Material Yield	Excellent (approx. 100%)	Poor (40-45% typical)
Part Cost (non-precious metal)	$	$$$
Part Cost (precious metal or pm alloy)	$$ (no scrap to reclaim)	$$$$$ (reclamation of metal scrap)
Production Run Rate	30 - 250 parts per minute	2 - 10 parts per minute
Range of Materials	Wide range	More limited
Stock Material Additives	No additives required	Additives may be required to improve machinability (Pb, S, etc)
Ease of Shaping Gummy Metals	Excellent	Difficult (Tendancy to produce stringy chips)
Part Strength	Forming results in a work hardened part	Final part is no harder than feedstock material
Part Finish	Excellent Smooth finish, no burrs	Average (tool marks, deburring needed)
Commercial Feasability	Typically 3K units/year or more	Depending on part design, 0 to 3K units/year
Tooling Investment Needed	$300 to $10,000 depending on part complexity	Little to no up-front tooling cost

Contact Deringer-Ney @ 860-286-6101 or www.DeringerNey.com