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151 N. DELANEY RD. • OWOSSO, MI 48867

# Membrane Switch Overlay Embossing Die Prices

## The Total Package

- Quality
- Speed
- Competitive
- Friendly Service
- Community

- Brass Dies
- Custom Applications
- Debossing Dies
- Fabric Embossing Dies
- Foil Stamping Dies
- Halftone & Line Etchings
- Intaglio Printing Dies
- Letterpress Printing Dies
- Membrane Embossing Dies
- Pantograph Masters
- Plaques
- Paper Embossing Dies
- Rubber Stamp Masters
- Thermal Kiss-Cut Dies
- Make-Ready Supplies
- Flexo Plates

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America's Largest Manufacturer of Quality Brass, Copper & Magnesium

800-444-5552  
U.S. & Canada

989-725-7112  
International

989-723-5399  
Business Fax

### ORDERING INFORMATION

On-line ordering available at  
[www.owosso.com](http://www.owosso.com)

LIMIT  
SELECT

ALARMS

PULSE VOL

## Custom Services:

Accu-Pin System (holes and/or pins) .....	\$25.00 per set of 2
Bevel, per side:	
1-300" .....	\$6.00
301-900" .....	\$7.00
over 901" .....	\$8.00
Hourly Charges .....	\$75.00/hour; 15 minute min.
Rush Charge .....	\$100.00 & Up Depends on production schedule

## Production Background:

Membrane Switch Overlay Embossing Dies are mainly used to emboss a pill (pad) or rim (perimeter) key-tactile designs into polyester or polycarbonate substrates. The process usually requires a male/female die set. Membrane Switch Overlay Embossing Dies must be made with precision-calculated spread and choke to accommodate the thickness of your particular substrate. The etch rate is carefully controlled to provide the depth needed to achieve your specified embossing height.

## Cost Estimating:

Add 1/2" to each dimension of **plate** size (this allows for 1/4" all around for sawing). For fractions, round up to the next 1/4". Multiply length times width to calculate total square inches. Call us as 1-800-444-5552 or e-mail us at engraver@owosso.com for free estimates.

Prices eff. January 1, 2015

## Membrane Switch Overlay Embossing Dies:

Next Day  
Turn-around

Male  
or  
Female **11 pt.** Male  
and  
Female

Sq. In Pricing	Single	Combo
30 (minimum)	\$115.00	\$230.00
31-35	\$126.00	\$252.00
36-40	\$138.00	\$276.00
41-45	\$147.00	\$294.00
46-50	\$155.00	\$309.00
51-55	\$163.00	\$326.00
56-60	\$175.00	\$350.00
61-65	\$185.00	\$370.00
66-70	\$195.00	\$389.00
71-75	\$206.00	\$412.00
76-80	\$214.00	\$427.00
81-85	\$222.00	\$443.00
86-90	\$233.00	\$466.00
91-95	\$242.00	\$484.00
96-100	\$253.00	\$505.00
101-105	\$262.00	\$523.00
106-110	\$273.00	\$545.00
111-115	\$281.00	\$562.00
116-120	\$289.00	\$578.00
121-125	\$301.00	\$602.00
126-130	\$309.00	\$618.00
131-135	\$315.00	\$630.00
136-140	\$321.00	\$641.00
141-145	\$327.00	\$654.00
146-150	\$332.00	\$663.00
Add'l sq. in	\$1.65 ea	\$3.35 ea

Additional Pricing:

- .250" metal - Add 10% to above prices
- Combination dies may be ordered with mixed metal thicknesses
- Domed CNC dies - \$585 minimum  
Up to 100 sq. in.  
\$5.30 each add'l sq. in.

Order on-line at [www.owosso.com](http://www.owosso.com)

### Ask Us!

Our OWOSSO team members are available to answer any customer service or tech support questions.

### Give us a call at:

1-800-444-5552 or e-mail at [engraver@owosso.com](mailto:engraver@owosso.com).

### We're here to help.

OWOSSO is a Proud Member of the Following  
Organizations



## Tech Tips:

### Copy Preparation:

*Always include trim marks on your file to identify the exact die size and sawing specs.*

### Temperature & Dwell:

To produce a quality embossing, it takes the right combination of temperature and dwell. A higher temperature of 180-190° F results in a better emboss, especially on polyester.

Since polyester and polycarbonate are poor conductors of heat, at lower temperatures it is necessary to adjust dwell time to give the substrate enough time to reach a temperature at which it will form the emboss. It is possible to cold emboss and some embossers have been more successful using a double pass impression rather than a single, longer dwell time.

### Design:

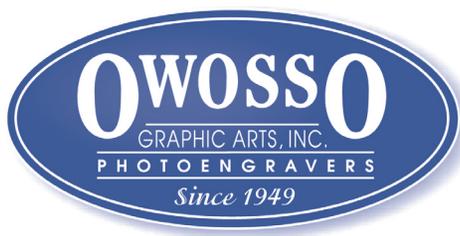
Pads spaced too closely together will tend to cause the substrate to "tug" or crack when it is embossed, particularly if temperature and dwell are not adjusted properly and the emboss is too high.

### Recommended Embossing Height:

Embossing height should not exceed 2.5 times the material thickness for functional touch pads.

### Material Memory:

Polycarbonate has approximately .005-.006" **spring-back** in embossing. Polyester has approximately .008-.010" **springback**.



### **The Total Package**

- Quality
- Speed
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More than sixty years after our company began, Owosso Graphic Arts, Inc. continues to set the industry standard for both craftsmanship and service. OWOSSO has been a leader in the development of Membrane Switch Overlay embossing dies. It takes an understanding of the substrates, the process and just the "right touch" to produce quality dies.

As America's largest brass, copper and magnesium photoengraver, our overriding goal is complete customer satisfaction no matter the size or scope of your job. To do this, we deliver new technologies, along with good old-fashioned small town values such as honesty, integrity, and hard work. We promise, our dies and our company will leave a lasting impression.

We look forward to helping you with all of your die needs.

### **Visit our Website**

At [www.owosso.com](http://www.owosso.com) for more  
in-depth information.