**3PC DRAW DIE ZINC PROGRAMMING REQUIREMENTS**

1. To setup a quote for a 3 pc draw tool you need 5 inches of the part to bottom of the die half for casting you will need a ring thickness of 5 inches and a punch clearance of 4” from the bottom of the ring. At this point to get total tool thickness you take the 14” tool requirement height and add the part height and round up to the nearest inch.
2. To setup a quote for a 3 pc draw tool on the length and width of the tool you will need to add 2 inches all the way around the tool plus the height of the part, so if your part is 4 inches in height you will have 6 inches all the way around the tool for the draw tool length and width.

**2 PC FORM/RS ZINC TOOL PROGRAMMING REQUIREMENTS**

1. To setup a quote for a 2pc tool out of zinc you will need to add 5 inches for the punch and die from the bottom of the part to the bottom of the tool. As far as length and width go add the height of the part all the way around the tool for a tool quote. minimum is 4” all the way around if the part is less than 4” this prevents the tool to crack in half.

**2 PC FORM/RS STEEL TOOL PROGRAMMING REQUIREMENTS**

1. To setup a quote for a 2pc tool out of steel you will need to make sure we have 2 inches minimum from the bottom of the part to the bottom of the tool for both punch and die. As far as length and width go for the tool you will need to go to 3” all the way around and round up to the nearest even number.