

About Metal Products

The process of making a lapel pin starts with the assessment of the artwork or design. This will identify which process to use or which process will work the best. Does the artwork demand that colors touch or run together? Are there shadows or small text and details? Will sequential numbers be required?

Traditional lapel pin manufacturing requires a metal die. A reverse image of your design is carved into stainless steel creating a die. This die is stamped into copper or brass sheets using several tons of pressure that form a detailed impression (raised and recessed metal areas) of your artwork. A special punch or cut tool (like a cookie cutter) is fabricated and literally punches the design away from the metal sheet so it can be hand-polished, colorized and plated. With a traditional pin, colors cannot touch. The colors must be separated or trapped by the raised metal walls. The measurement of a metal product is calculated by using the longest length, whether that is horizontal or vertical.

Cloisonné is also referred to as hard enamel. Colors are hand-filled with a powdered glass or a poly-resin paste mixture into struck copper. Each color is filled to the surface and baked at nearly 1600F, one color at a time! This process is repeated for each color. Once completed, these are polished to a jewelry-like finish and plated with 22k gold, nickel, silver or other plating options. The traditional nail and barb is added to the backside. **Laser-Fired Cloisonné** adds another step to finished Cloisonné. Laser or screen print colors can be applied on top of the polished surface allowing colors to touch, eliminating the need for metal walls to separate some colors. Higher levels of detailing are now achieved.

Pins struck in brass without color-fill are traditionally referred to as **Die-Struck**. When adding pantone® PMS colors, these are commonly called **Soft Enamel**. Soft Enamel pins are hand-filled with an enamel paint using a syringe and needle. This is baked at a lower temperature (200-400F) and once cured, the colors remain slightly recessed in the metal. A clear coating or epoxy can be added to the surface to protect the colors. Without colors, the recessed areas are textured while the raised surface is high polished.

Photo Etch Enamel does not utilize a traditional die. Your design is etched into a thin metal using an acid-reaction process. A recessed area remains after the acids are removed readied for enamel pantone® painting, baking and polishing. An epoxy dome is optional.

If colors must touch, run together or when colors require screening, half tones, ghosts or shadows **Screen Print** or **Four-Color Process** pins are appropriate. These are economical and an alternative to the high-end processing. Screen Printing requires each color to use a separate solid pantone® color while Four-Color processing incorporates the use of CMYK or film separated artwork, just like color photography. These process choices use an epoxy dome and usually have no plating since the metal is not viewable.

Key Tags, Coins and Medallions use all the same techniques. Coins would require two dies (for the front and back images). It is easy to imagine these as oversized lapel pins without the traditional nail and barb backing, but using other attachments and findings as shown on page 10.

As you can envision, metalwork is a time consuming and labor intense process. Individually, these are precious pieces of jewelry!



Cloisonné & Cloisonné Plus

A centuries old technique starts with die-struck copper, filled with up to four powdered glass blend colors and made to have the feel of porcelain and the endurance of jewels. Cloisonné is hand polished, plated gold, silver, bronze, nickel or black nickel and polished again. A standard military clutch or safety pin backing is included. When color matching is required, a poly-resin is utilized for PMS® colors.

DIE CHARGE: \$75.00(v). 500 pcs. or more, No Charge.

PIERCING (Inner hole cuts): \$25.00(v) plus .05(v) running charge per hole.

ANTIQUÉ FINISH: Copper or bronze add .10(v).
Silver or gold add .20(v).

SANDBLASTING: Add .10(v) to unit cost.

BACK DIE STAMPING: Add .10(v) plus an additional \$31.25(v) die charge.

ADDITIONAL COLORS: Add .10(v) per color.

GLITTER COLORS: Add .15(v) per color. Standard PMS® colors include: Red (186), White (Opal), Blue (Reflex), Yellow (116), Green (348), Orange (165), Purple (266), Pink (238), Lt Blue (312), Black, Gold and Silver. Slight color variance is normal with glitter material.

GLOW-IN-DARK: Add .15(v) per glow color. In day light, glow color appears cream on finished metal. Glows green or blue in the dark. Colors available are green or blue.

ATTACHMENTS: Other attachment options available. See page 10.

ABSOLUTE MINIMUM: 125 pieces. Add 25% to 250 piece unit cost.

PACKAGING: Bulk packed in individual polybags. Other packaging options available, please call factory.

DIMENSIONS: 3-D must be quoted, please call factory.

PRE-PRODUCTION PROOF: \$35.00(v) plus a one time die charge.

PRODUCTION TIME: 3-5 weeks.

Size	250	500	1000	2500	5000	7500+
3/4"	1.98	1.80	1.56	1.34	1.14	
7/8"	2.10	1.92	1.68	1.44	1.24	Call
1"	2.20	2.02	1.76	1.52	1.32	Factory
1 1/4"	2.56	2.38	2.14	1.94	1.64	
1 1/2"	3.58	3.02	2.88	2.48	2.04	

(5p)



3-D



Laser-fired Cloisonné

Using the same process as cloisonné with up to four colors and plated in gold, silver, bronze, nickel or black nickel, this hard enamel pin implements a laser-printing technique that includes one PMS® color match. Since there is no metal to separate the added laser coloring, a higher level of detailing will be visible. A standard military clutch or safety pin backing is included.

DIE CHARGE: \$75.00(v). 500 pcs. or more, No Charge.

PIERCING (Inner hole cuts): \$25.00(v) plus .05(v) running charge per hole.

ANTIQUÉ FINISH: Copper or bronze add .10(v). Silver or gold add .20(v).

SANDBLASTING: Add .10(v) to unit cost.

BACK DIE STAMPING: Add .10(v) plus an additional \$31.25(v) die charge.

ADDITIONAL LASER-FIRED COLORS: \$50.00(v) plus .05(v) per color running charge.

ADDITIONAL CLOISSONNÉ COLORS: Add .10(v) per color.

GLITTER COLORS: Add .15(v) per color. Standard PMS® colors include: Red (186), White (Opal), Blue (Reflex), Yellow (116), Green (348), Orange (165), Purple (266), Pink (238), Lt Blue (312), Black, Gold and Silver. Slight color variance is normal with glitter material.

GLOW-IN-DARK: Add .15(v) per glow color. In day light, glow color appears cream on finished metal. Glows green or blue in the dark. Colors available are green or blue.

ATTACHMENTS: Attachment options, see page 10.

ABSOLUTE MINIMUM: 125 pieces. Add 25% to 250 piece unit cost.

PACKAGING: Bulk packed in individual polybags. Other packaging options available, please call factory.

DIMENSIONS: 3-D must be quoted, please call factory.

PRE-PRODUCTION PROOF: \$35.00(v) plus a one time die charge.

PRODUCTION TIME: 3-5 weeks.

Size	250	500	1000	2500	5000	7500+
3/4"	2.46	2.08	1.74	1.46	1.24	
7/8"	2.58	2.20	1.86	1.56	1.34	Call
1"	2.68	2.30	1.94	1.64	1.42	Factory
1 1/4"	3.04	2.66	2.32	2.06	1.74	
1 1/2"	4.06	3.30	3.06	2.60	2.14	

(5p)



Cloisonné: White
Laser-Print: Pink,
Blue & Black



Cloisonné: White & Black
Laser-Print: Red



Soft Enamel, Die-Struck Plus+ & Economy

Soft Enamel

This process is also known as die-struck. The extra thickness created by die stamping brass is filled with up to four PMS® color matched enamels. Precious metal plating of gold, silver, bronze, nickel or black nickel and polishing provides a rich enhancement of coloring and is an economical alternative to cloisonné. Applying a clear epoxy dome will increase the finished look and feel of this procedure. A standard military clutch or safety pin backing is included.

Die Struck Plus+

Die-struck brass is plated with gold, silver, bronze, nickel or black-nickel. The foreground is raised and hand polished creating a jewelry-like finish. The background can be sandblasted creating a textured look or remain shiny for an image of prestige and luster. A standard military clutch or safety pin backings included.

Economy (Iron)

Created with the same quality and detail of traditional metal, but struck in iron. Perfect for a 1-piece magnetic attachment (pinless pins). Cannot be antiqued or textured. Reduce pricing shown by 10%.

Size	250	500	1000	2500	5000	7500+
3/4"	1.72	1.48	1.24	1.08	0.90	
7/8"	1.78	1.54	1.30	1.14	0.96	Call
1"	1.84	1.60	1.42	1.22	1.00	Factory
1 1/4"	2.10	1.84	1.68	1.42	1.22	
1 1/2"	2.76	2.30	1.98	1.76	1.46	

(5p)

DIE CHARGE: \$75.00(v). 500 pcs. or more, No Charge.

PIERCING (Inner hole cuts): \$25.00(v) plus .05(v) running charge per hole.

ANTIQUÉ FINISH: Copper or bronze add .10(v). Silver or gold, add .20(v).

BACK DIE STAMPING: Add .10(v) plus an additional \$31.25(v) die charge.

ADDITIONAL COLORS: Add .10(v) per color.

GLITTER COLORS: Add .15(v) per color. PMS® colors include: Red (186), White (Opal), Blue (Reflex), Yellow (116), Green (348), Orange (165), Purple (266), Pink (238), Lt Blue (312), Black, Gold and Silver. Slight color variance is normal with glitter material. Epoxy dome required.



Glitter



Piercing

Bobble Spring
(with Glitter)



Antique Silver



Antique Gold



Antique Copper



Antique Bronze

GLOW-IN-DARK: Add .15(v) per glow color. In day light, glow color appears cream on finished metal. Glows green or blue in the dark. Colors available are green or blue.

ATTACHMENTS: Other attachment options available. See page 10.

ABSOLUTE MINIMUM: 125 pieces. Add 25% to 250 piece unit cost.

PACKAGING: Bulk packed in individual polybags. Other packaging options available, please call factory.

DIMENSIONS: 3-D must be quoted, please call factory.

PRE-PRODUCTION PROOF: \$35.00(v) plus a one time die charge.

PRODUCTION TIME: 3-5 weeks.

Photo Etched Enamel



Piercing



Black Nickel



Implementing an acid-etching process gives this metal a combination of price and quality. Metal plating of gold, silver, bronze, nickel or black nickel is an excellent way to reproduce fine details and remain an economical alternative to die-struck. This includes up to four enamel PMS® colors and is best displayed with an optional epoxy dome. A standard military clutch or safety pin backing is included.

DIE CHARGE: \$75.00(v). 500 pcs. or more, No Charge.

PIERCING (Inner hole cuts): \$25.00(v) plus .05(v) running charge per hole.

ANTIQUÉ FINISH: Copper or bronze add .10(v) Silver or gold add .20(v).

SANDBLASTING: Not available.

BACK DIE STAMPING: Add .10(v) plus an additional \$31.25(v) die charge.

ADDITIONAL COLORS: Add .10(v) per color.

GLITTER COLORS: Not available.

GLOW-IN-DARK: Add .15(v) per glow color. In day light, glow color appears cream on finished metal. Glows green or blue in the dark. Colors available are green or blue.

ATTACHMENTS: Attachment options, see page 10.

ABSOLUTE MINIMUM: 125 pieces. Add 25% to 250 piece unit cost.

PACKAGING: Bulk packed in individual polybags. Other packaging options available, please call factory.

DIMENSIONS: 3-D must be quoted, please call factory.

PRE-PRODUCTION PROOF: \$35.00(v) plus one time die charge.

PRODUCTION TIME: 3-5 weeks.

Size	250	500	1000	2500	5000	7500+
3/4"	1.56	1.32	1.14	0.98	0.80	
7/8"	1.62	1.38	1.18	1.02	0.84	Call
1"	1.66	1.44	1.26	1.08	0.90	Factory
1 1/4"	1.80	1.56	1.38	1.18	1.04	
1 1/2"	2.18	2.02	1.70	1.54	1.24	

(5p)

Screen Print & Four-Color Process

Here are two options to duplicate a color photograph or image without the need for metal walls separating the colors. An epoxy dome and a military or safety pin backing and PMS® colors are standard. The pin edge is solid brass, but can be plated with gold, silver, nickel or black nickel. Film separation may be required to the finished pin size, contact factory for more details.

BACK DIE STAMPING: Add .10(v) plus \$31.25(v) die charge.

GLITTER COLORS: Add .15(v) per color plus \$40.00(v) per screen. PMS® colors include: Red (186), White (Opal), Blue (Reflex), Yellow (116), Green (348), Orange (165), Purple (266), Pink (238), Lt Blue (312), Black, Gold and Silver. Slight color variance is normal with glitter material. Epoxy dome required.

GLOW-IN-DARK: Add .15(v) per glow color plus \$40.00(v) per screen. In day light, glow color appears cream on finished metal. Glows green or blue in the dark. Colors available are green or blue. Epoxy dome required.

ATTACHMENTS: Other attachment options available. See page 10.

ABSOLUTE MINIMUM: 500 pieces.

PACKAGING: Bulk packed in individual polybags.

PRE-PRODUCTION PROOF: \$50.00(v) plus related screen or film charges.

PRODUCTION TIME: 3-5 weeks.

Size	500	1000	2500	5000	7500+
7/8"	1.34	1.14	0.98	0.84	Call
1"	1.40	1.22	1.04	0.86	Factory
1 1/4"	1.52	1.34	1.14	1.06	

(4p)

Screen Print

Provides color reproduction using PMS® spot colors only. This process includes up to three screens with options to add more.

SCREEN CHARGES: \$125.00(v) for up to three screened colors.

ADDITIONAL COLORS: Add .10(v) plus \$35.00(v) screen per color.



Four-Color Process

Process printing allows you to blend, screendown and shadow colors. This usually requires film-separated artwork with registration markings for correct overlay. There is no limit on the colors since this process will match the color picture artwork.

FILM CHARGE: \$200.00(v).



Stock American Flag Pins

Item	Description	100 Piece Pack (p)
DSG-1	3/4" Die Struck Gold	.90
DSN-1	3/4" Die Struck Nickel	.90
SP-1	3/4" Screen Print w/Epoxy	.50

PACKAGING: Individually polybag.



DSG-1



DSN-1



SP-1

Die-Struck Metal Keytags

Each metal is die-struck copper or brass and plated in gold, silver, bronze, nickel or black nickel for more strength and durability in a 2-dimensional appearance. Hand finished and elegant, these can be produced with up to four enamel PMS® colors or without any color. A split metal keyring, loop and chain are standard along with a textured background. An epoxy dome is optional.

DIE CHARGE: \$100.00(v).

PIERCING (Inner hole cuts): \$25.00(v) plus a .05(v) running charge per hole.

ANTIQUÉ FINISH: Copper or bronze add .10(v). Silver or gold add .20(v).

BACK DIE STAMPING: Add .10(v) plus an additional \$31.25(v) die charge.

ADDITIONAL COLORS: Add .10(v) per color.

GLITTER COLORS: Add .15(v) per color. PMS® colors include: Red (186), White (Opal), Blue (Reflex), Yellow (116), Green (348), Orange (165), Purple (266), Pink (238), Lt Blue (312), Black, Gold and Silver. Slight color variance is normal with glitter material. Epoxy dome required.

GLOW-IN-DARK: Add .15(v) per glow color. In day light, glow color appears cream on finished metal. Glows green or blue in the dark. Colors available are green or blue.

ABSOLUTE MINIMUM: 125 pieces add 25% to 250 piece unit cost.

DIMENSIONS: 3-D must be quoted, please call factory.

PACKAGING: Bulk packed in individual polybags. Other packaging options available, please call factory.

LEATHER FOB: Add \$1.25(v).

DOUBLE-SIDED KEYTAGS: Call factory.

PRE-PRODUCTION PROOF: \$35.00(v) plus a one time die charge.

PRODUCTION TIME: 3-5 weeks.

Size	250	500	1000	2500	5000	7500+
1"	2.64	2.40	2.22	2.02	1.80	
1 1/4"	2.90	2.64	2.48	2.22	2.02	Call
1 1/2"	3.56	3.10	2.78	2.56	2.26	Factory
1 3/4"	3.96	3.50	3.18	2.96	2.66	
2"	4.36	3.90	3.58	3.36	3.06	

(5p)

Cloisonné colorfill, please call factory.



Double-Sided Keytag

Leather Fob

Medallions & Coins

Each metal is die-struck copper or brass and plated in gold, silver, bronze, nickel or black nickel for more strength and durability in a 2-dimensional appearance. Hand finished and elegant, these can be produced with or without enamel PMS® colors.

SINGLE-SIDE METALS:

Size	250	500	1000	2500
1 1/4"	2.68	2.00	1.64	
1 1/2"	3.12	2.40	2.00	Call
1 3/4"	3.64	3.00	2.56	Factory
2"	3.98	3.36	2.94	

DIE CHARGE:

(1"-1 1/2") is \$100.00(v).

(1 3/4"-2") is \$140.00(v).

COLORFILL:

(1"-1 1/2") up to 4 enamel colors add .25(v).

up to 4 cloisonné colors add .80(v).

(1 3/4"-2") up to 4 enamel colors add .30(v).

up to 4 cloisonné colors add \$1.20(v).

DOUBLE-SIDED METALS:

Size	250	500	1000	2500
1 1/4"	3.44	2.52	2.14	
1 1/2"	4.12	3.16	2.68	Call
1 3/4"	5.18	4.14	3.54	Factory
2"	5.76	4.70	4.08	

DIE CHARGE:

(1"-1 1/2") is \$180.00(v).

(1 3/4"-2") is \$240.00(v).

COLORFILL:

(1"-1 1/2") up to 4 enamel colors add .40(v).

up to 4 cloisonné colors add .85(v).

(1 3/4"-2") up to 4 enamel colors add .60(v).

up to 4 cloisonné colors add \$1.25(v).

ATTACHMENTS: Ribbons or Drapes. See page 10.

PIERCING: (inner hole cuts): \$25.00(v) plus a .05(v) running charge per hole.

ANTIQUÉ FINISH: Copper and bronze add .20(v). Antique silver and gold add .30(v).

EDGE OPTIONS: Diamond Cut, \$110.00(v) per side; 3-D Rope, \$95.00(v) per side; Serrated, \$200.00(v)

BACK DIE STAMPING: Add .10(v) plus an additional \$31.25(v) die charge.

DIMENSIONS: 3-D and complex designs, please call factory for custom quote.

ADDITIONAL COLORS: Add .10(v) per color.

GLOW-IN-DARK and GLITTER: Call factory for details.

ABSOLUTE MINIMUM: 125 pieces. Add 50% to the 250 piece price.

PACKAGING: Bulk packed in individual polybags. Other packaging options available, please call factory.

PRE-PRODUCTION PROOF: \$50.00(v) plus a one time die charge.

PRODUCTION TIME: 3-5 weeks.



Precious Metals, Stones & Service Awards



Bars and Tabs



Synthetic Stones



Stamped Numerals

Quality metal work is plated in gold, silver, bronze, nickel or black nickel. This includes up to four enamel colors and a military clutch or safety pin backing. Genuine stones, precious 10k, 14k gold or sterling silver is available.

DIE CHARGE: \$75.00(v).

PIERCING (Inner hole cuts): \$25.00(v) plus .05(v) running charge per hole.

GENUINE STONES: Diamond, ruby, sapphire, and emerald, please contact factory for custom quote.

PRECIOUS METALS: 1/10th 10k gold filled, 10k gold, 14k gold and sterling silver, please call factory for custom quote.

SYNTHETIC STONE COLORS: Red, blue, green, pink and white, add .25(v) per stone.

BACK DIE STAMPING: Add .10(v) plus an additional \$31.25(v) die charge.

ADDITIONAL COLORS: Add .10(v) per color.

GLOW-IN-DARK and GLITTER: Call factory for details.

STAMPED NUMERALS: Stamped one or two digit numeral with or without color add .25(v). (Numerals must be 3.5mm in height).

NUMERAL CHANGE: \$5.00(v) per numeral change.

ANTIQUE FINISH: Copper or bronze add .10(v). Silver or gold add .20(v).

ATTACHMENTS: Attachment options, see page 10.

DIMENSIONS: 3-D must be quoted, please call factory.

ABSOLUTE MINIMUM: 125 pieces. Add 25% to 250 piece unit price.

PACKAGING: Bulk packed in individual polybags. Other packaging options available, please call factory.

PRE-PRODUCTION PROOF: \$35.00(v) plus a one time die charge.

PRODUCTION TIME: 3-5 weeks.

Size	250	500	1000	2500	5000	7500+
3/4"	1.72	1.48	1.24	1.08	0.90	
7/8"	1.78	1.54	1.30	1.14	0.96	Call
1"	1.84	1.60	1.42	1.22	1.00	Factory
1 1/4"	2.10	1.84	1.68	1.42	1.22	
1 1/2"	2.76	2.30	1.98	1.76	1.46	

(5p)

Pricing reflects die-struck process.

Please call factory for other fabrication options.

Attachments, Findings & Accessories

Turn your metal lapel pin (and most PVC) designs into a zipper pull, cufflinks, earrings or even a money clip. Replace or substitute the traditional nail and barb backing of your lapel pin with another attachment or finding. A larger version of your design can also be fabricated into a key tag. This is a perfect way to create companion pieces and enhance your events!

Adhesive Back*	A	.30
Bobble Spring	B	.70
Cuff Links (pair)	C	2.20
Deluxe Tie Tac w/Chain	D	.50
Deluxe Tie Tac w/Safety Loop	E	.50
Earring Clasp (pair)*	F	1.40
Earring Hook (pair)*	G	.70
Earring Post (pair)	H	.70
Jump Ring*	I	.10
Key Lock (dog leash)*	K	.48
Leather Keytags*	L	2.00
Lobster Claw (Small)*	M	.30
Magnet (strong 1 part)	N	1.00
Magnet (strong 2 part)*	O	2.00
Medallion Ribbon (red, white, and blue striped)*	P	.60
Medallion Ribbon (solid)*	Q	.60
Medallion Drapes*	R	.50
Military/Butterfly Clutch (additional piece)	S	.12
Money Clip	T	1.60
Plastic Box (1" square)	U	.50
Plastic Box (1 5/8" square)	V	.60
Plastic Cuff Link Box*	W	.80
Safety Pin (1")	X	n/c
Safety Pin (1 1/2")*	Y	.16
Screw-On Backs*	Z	1.20
Split Metal Heavy Ring w/Chain, add .08	AA	.48
Stick Pin*	BB	.30
Tie Bar (2")	CC	1.20
Tie Bar (3")*	DD	1.30
Tie Tack Flat Back	EE	.38
Tie Tack Round Back	FF	.38
Zipper Pull	GG	.16
	(P)	

*Not pictured. Please call factory for additional findings not listed or shown.

