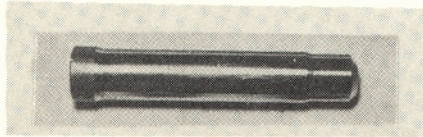


TD Process Application to Dies and Jigs

TD Process
Application Data
No. 8B-4 -1/1

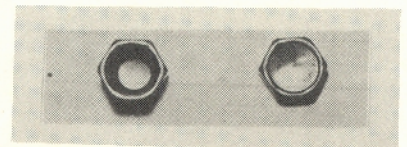
Die or Jig	Name	Backward extrusion punch					
	Category	Die (pressing, <u>cold forging</u> , hot forging, die casting, sand molding, powder compacting, rubber molding, plastic molding, glass casting) Cutting tool, Knife, Guide roller, Others ()					
Material	Steel Code	AISI D2	TD	Coating	VC	Treating Condition	HRC
	Heat Treatment	Hardened		Thickness	μ	Substrate Hardness	

Sketch of Die



Work	Material	ASTM Fe 33
	Dimension	Hardness

Sketch of Work



How It Is Worked

<u>Evaluation</u>	<u>Effect</u>	<u>Working Condition</u>	
Life of punches (Shots)	<ul style="list-style-type: none"> • <u>Increase of die life</u> • <u>Reduction of maintenance cost</u> • Saving of lubricants • Increase of working rate • Others 	Machine	
M2 Hardened punches		Load	
8,000		Stroke	
D2 TD treated punches		Speed	
43,000		Temperature	°C
		Lubrication	
		Clearance	