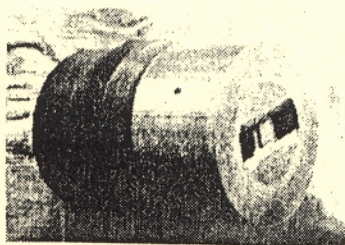


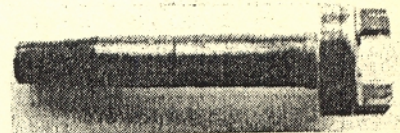
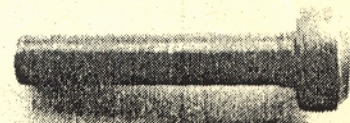
Die or Jig	Name	Upsetting die					
	Category	Die (stamping, <u>Cold forging</u> , hot forging, die casting, sand molding, powder compacting, rubber molding, plastic molding, glass casting) Cutting tool, Knife, Guide roller, Others ()					
Material	Steel Code	M2	TD	Coating	VC	Treating Condition	
	Heat Treatment			Thickness	μ	Substrate Hardness	H _{RC}

Sketch



Work	Material		
	Dimension		Hardness

Sketch of Work



How It Is Worked

<u>Evaluation</u>				<u>Effect</u>	<u>Working Condition</u>	
		M2, Hardened	M2, TD	• Increase of die life	Machine	
Life		1,500 shots	8,000 shots	• Reduction of maintenance cost	Load	260kg/mm ²
Cost	Die cost	100	32	• Saving of lubricants	Stroke	
	Personnel expenses	100	95	• Increase of working rate	Speed	
	Equipment cost	100	98	• Others	Temperature	°C
	Manufacturing cost	100	65		Lubrication	
					Clearance	