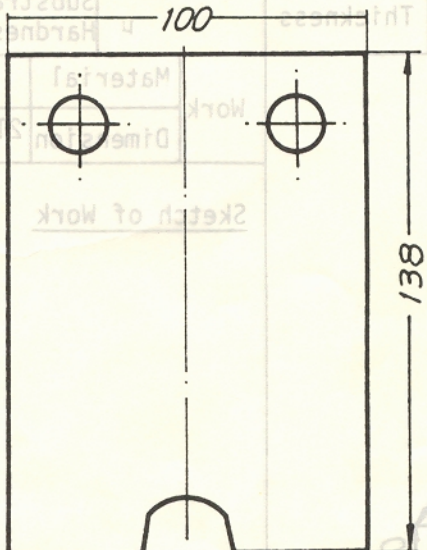
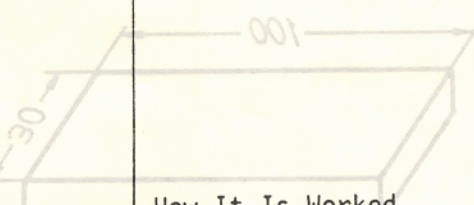
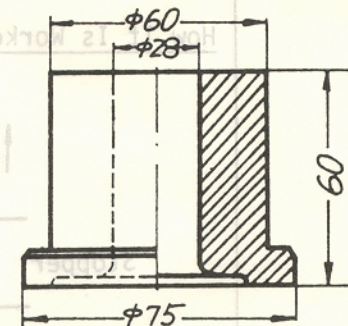
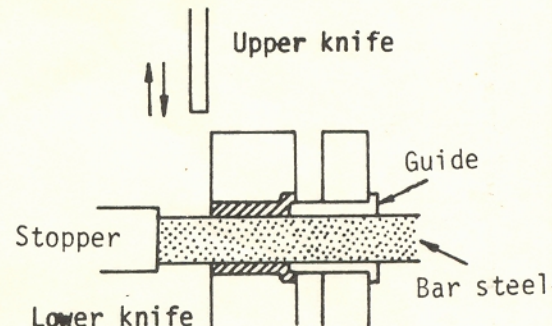


TD Process Application to Dies and Jigs

TD Process
Application Data
No. 8F-2 -1/1

Die or Jig	Name	Cropping knife																								
	Category	Die (pressing, cold forging, 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																				
	Heat Treatment	Hardened		Thickness		Substrate Hardness HRC																				
Sketch of Die			<table border="1"> <tr> <td rowspan="2">Work</td> <td>Material</td> <td colspan="2">Cr-Mo carburizing steel</td> </tr> <tr> <td>Dimension</td> <td>27.1 ϕ</td> <td>Hardness</td> </tr> </table> <p>* cold drawing 28 ϕ \rightarrow 27.1 ϕ</p>				Work	Material	Cr-Mo carburizing steel		Dimension	27.1 ϕ	Hardness													
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	Dimension	27.1 ϕ	Hardness																							
<p>Upper knife</p> 			<p>Sketch of Work</p> 																							
<p>Lower knife</p> 			<p>How It Is Worked</p> 																							
<p><u>Evaluation</u></p> <table border="1"> <tr> <td>Life of knife</td> <td></td> </tr> <tr> <td>D2 Hardened knife</td> <td>20,000</td> </tr> <tr> <td>D2 TD treated knife</td> <td>86,000 still in service</td> </tr> </table>			Life of knife		D2 Hardened knife	20,000	D2 TD treated knife	86,000 still in service	<p><u>Effect</u></p> <ul style="list-style-type: none"> Increase of life Reduction of maintenance cost Saving of lubricants Increase of working rate Others 		<p><u>Working Condition</u></p> <table border="1"> <tr> <td>Machine</td> <td>300T. Press</td> </tr> <tr> <td>Load</td> <td>30 Ton</td> </tr> <tr> <td>Stroke</td> <td></td> </tr> <tr> <td>Speed</td> <td></td> </tr> <tr> <td>Temperature</td> <td>$^{\circ}\text{C}$</td> </tr> <tr> <td>Lubrication</td> <td>Machine oil</td> </tr> <tr> <td>Clearance</td> <td>1 mm</td> </tr> </table>		Machine	300T. Press	Load	30 Ton	Stroke		Speed		Temperature	$^{\circ}\text{C}$	Lubrication	Machine oil	Clearance	1 mm
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Recorded by