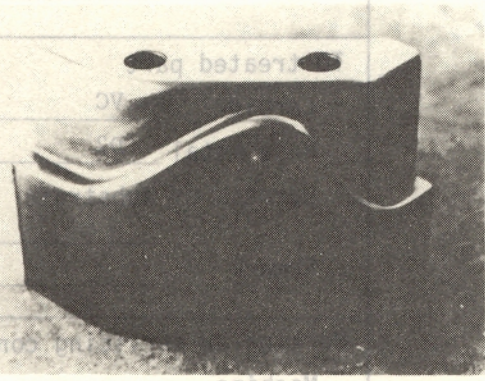


APPLICATION DATA

Name of part Drawing die	Source N. Kuwayama, et al Annual Conference in Japan Soc. for Heat Treatment Oct, 1970	
Mode of servicing Sheet metal stamping		

Work material Material <u>High strength steel</u> Size _____ Hardness _____ Remark _____ Product _____	
Machine _____ Load _____ Stroke _____ Clearance _____ Lubrication _____ Temperature of work _____	

Work material	
Material	Hot rolled mild steel
Size	2.6 mmt
Hardness	_____
Remark	_____

TD treated part	
Carbide	VC
Base metal	D2
Harness of substrate	_____
Remark	_____

Working or servicing condition	
Machine	400 ton Transfer
Load	_____
Stroke	15 shots/min.
Clearance	_____
Lubrication	_____
Temperature of work	_____

Result	Base metal, treatment and hardness of the part to be compared D2 Nitrided
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		Lubricant	Number of shots per one coating treatment		Total number of shots	
			Right die	Left die	right die	Left die
Nitriding		High performance drawing oil	250 ~ 300		_____	
TD process	1st treatment	Water soluble	49,000	36,000		
	2nd		36,000	34,000	85,000	70,000
	3rd		38,000	40,000	123,000	110,000
	4th		50,000	58,000	173,000	168,000
	10th		Now being in use			