

DATA SHEET

Name of die
Ironing die

- An Example of profit obtained -

Year, month, day

Mode of working
Stamping

Name of firm
Kyowa Kogyo

Sketch of product

Insert tube

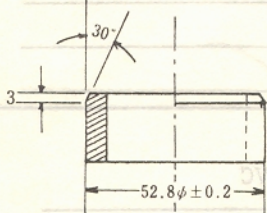
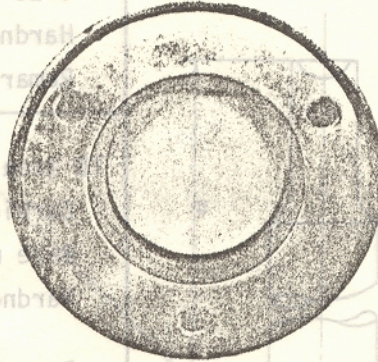


Photo of TD treated die



Work material (Product)

Material Hot rolled mild steel

Size 4 mm

Hardness

Remark

TD treated die

Carbide VC

Base metal D2

Hardness of substrate

H_R C 59

Remark

Working condition

Machine

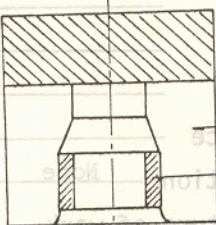
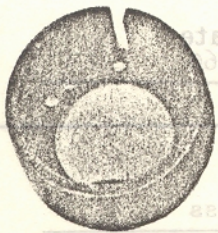
Load 50 t

Stroke 45S/min.

Clearance

Lubrication Machine oil

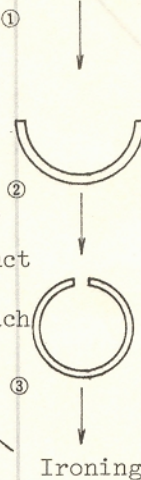
Temperature of work



TD die

product

TD punch



Ironing

Result

Base metal, Treatment and hardness of the die to be compared

D2, Chromium plated

Life and other evidences

TD die Still usable at 350,000 shots. No scoring.

The die to be compared Can not be used at 2,500-5,000 shots.

Profit obtained through application of TD process

1. Decrease in die consumption
2. Decrease in die repair work