TD Process
Application Data

## APPLICATION DATA

| Name of part    |                   | Source      |             |          |  |      |
|-----------------|-------------------|-------------|-------------|----------|--|------|
| Blanking punc   | casting, sh       |             |             |          |  |      |
| Mode of service | cing              | Annu        | al Confere  | nce in 3 | Japan Soc. for Heat Treatment                                      |      |
| Sheet metal s   | tamping           | Oct,        | , 1970      | 100 ,51  | 1111 F1003 BH133D0   |      |
|                 | Treating          | DoW         | Coating     |          | Work material 9000 [9932   |      |
|                 |                   |             |             | OT-      | Material Cold rolled mild  |      |
|                 |                   |             | Thickness   |          | Size Insteel Jase  |      |
|                 |                   |             |             |          | Hardness 3.2 mmt   |      |
|                 | # S.E noizne      | Work        |             |          | Remark   |      |
| mess            | 3 3.6   1101 8115 | MIT G       |             |          | Reilidirk  |      |
| 570             |                   | Sketching   | -1          |          | TD two told with   |      |
|                 |                   | Pun         | icn         |          | TD treated part  |      |
|                 | Mark Variation    | 10          | mm dia      |          | Carbide  |      |
|                 |                   | 3-6         | mm dia      | 1        | Base metal A2  |      |
|                 |                   | 3.0         | man GEG     |          | Harness of substrate   |      |
|                 |                   |             |             |          | Remark   |      |
|                 |                   |             |             |          | Working or servicing condition                                     |      |
|                 |                   |             |             |          | Machine  |      |
|                 |                   |             |             |          | Load 5 ton/cm <sup>2</sup>   |      |
|                 |                   | How It Is   |             |          | Stroke 22 shots/min.   |      |
|                 |                   |             |             |          | Clearance  |      |
|                 |                   |             |             |          | Lubrication  |      |
|                 |                   |             |             |          | Temperature of work  |      |
|                 |                   |             |             | 1        | remperature of work  |      |
|                 |                   |             |             |          | 04   |      |
|                 |                   |             |             |          |  |      |
|                 |                   |             |             |          |  |      |
|                 |                   |             |             |          |  | -    |
| Result          | Base metal,       | treatment   | and hardnes | s of t   | he part to be compared   |      |
|                 | Hard              |             |             |          | luation  |      |
| Dan Matagari    |                   | of dia life | Lacrosco    | (beste   | ardened : 27,000 - 41,000 s' (Rep                                  | ii - |
| 140 &           | Life and other    | er evidenc  | Reduction   | 1.       | Chipped at the corner  |      |
|                 | TD part           |             | 3.6         | mm dia   | 4,000 shots/reg. 45,600 shots/1<br>4,000 shots/reg. 48,500 shots/1 | ife  |
| mds Sh          | The part to       | be compa    | red parvs2. | strice   | 550 shots Can not be used du                                       | 110  |
| 3 m/sec         | Speed             | of working  | m Olcrease  | m dia    | 550 shots<br>520 shots   | e t  |
| 0               | Temperatur        |             | eje.        | min dra  | 520 shots severe scoring   |      |
| 3               | D. C. L. Squiss   |             |             |          | One of four punchessoorqed   |      |