

DATA SHEET

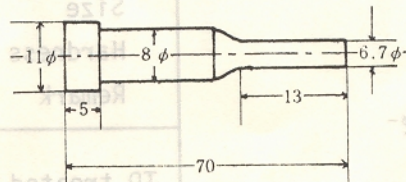
Name of die
Blanking punch (Standardized) - An Example of profit obtained -

Year, month, day

Mode of working
Stamping

Name of firm
Fuji Kinzoku

Sketch of TD treated punch



Work material (Product)

Material AISI 1050

Size 2.9t

Hardness

Remark

TD treated die

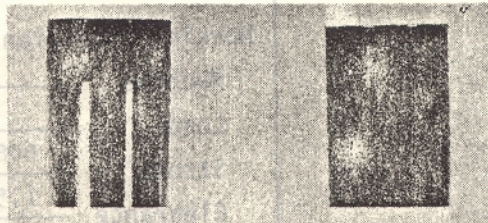
Carbide VC

Base metal D2

Hardness of substrate

H_R C 58-60

Remark



The punch to
be compared.

TD-treated
punch

Appearance of punches
after about 10,000 shots

Working condition

Machine

Load

Stroke 50S/min.

Clearance 4%

Lubrication Applied

Temperature of work

Result

Base metal, Treatment and hardness of the die to be compared
D2, Hardened

Life and other evidences

TD die 90,000 shots/reg. Still usable at 320,000 shots.

The die to be compared 10,000 shots/reg. 40,000-50,000 shots/life.

Profit obtained through application of TD process

1. Decrease in number of punches abandoned.

2. Decrease in regrinding work. (The length should be regrind off
was reduced.)