

DATA SHEET

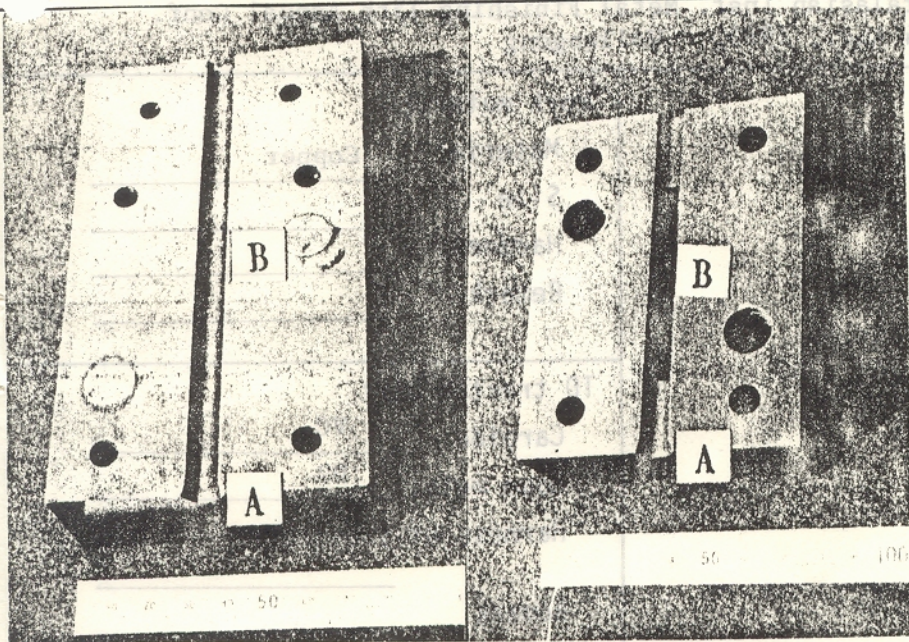
Name of die
Bending die

- An Example of profit obtained -

Year, month, day

Mode of working
Pipe forming

Name of firm
Tokairika Denki



Work material (Product)

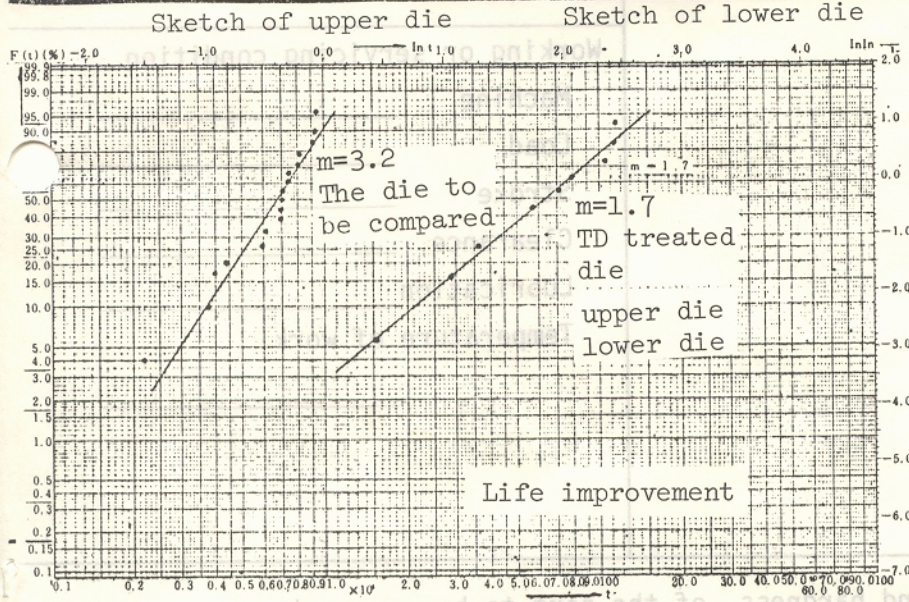
Material Mild steel pipe
Size $\phi 8 \times 175 \times 1.2$
Hardness Hv 175 - 205
Remark

TD treated die

Carbide VC
Base metal D2
Hardness of substrate $H_R C 56 - 58$
Remark

Working condition

Machine Press
Load 22 ton
Stroke
Clearance
Lubrication Oil
Temperature of work



D2, Hardened

$H_R C 62$

of the die to be compared

Life and other evidences

TD die Scoring and Chipping are decreased.
The die to be compared Scored at A and Chipped at B.
About 66,000 shots can be achieved.

Profit obtained through application of TD process

1. Reduction of cost
2. Decrease in repair work
3. Decrease in shut-down time
4. Improvement in product quality