

Name of die
Bulging punch

DATA SHEET

- An Example of profit obtained -

Year, month, day

Mode of working
Pipe forming

Name of firm
Haneda Co.

Sketch of TD treated punch

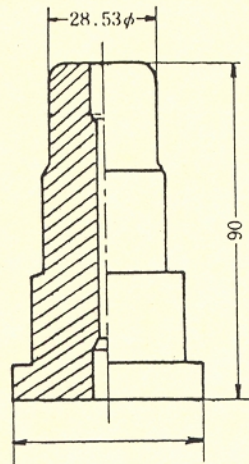
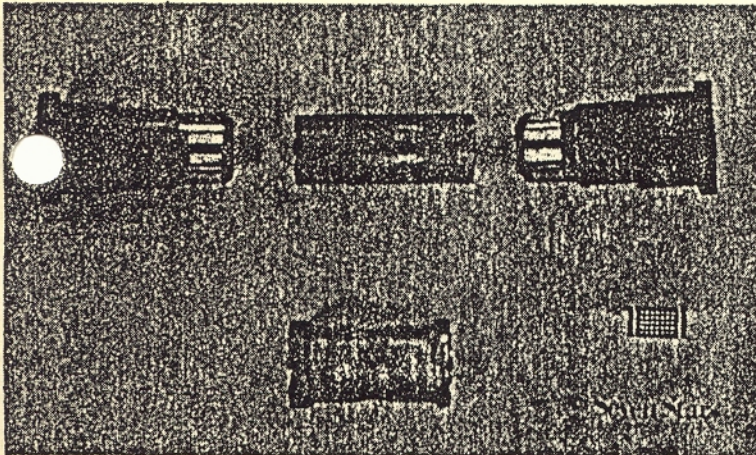


Photo of product and punch



Work material (Product)

Material AISI 304Size 1.0 mmtHardness Remark Pipe welded

TD treated die

Carbide VCBase metal D2Hardness of substrate
H_R C 59Remark

Working condition

Machine Load 150 tStroke 30S/min.Clearance Lubrication OilTemperature of work

Result

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

D2, Chromium plated

Life and other evidences

TD die Cannot be used at 80,000-120,000 shots.

The die to be compared Scored at 10 shots. Re-plating after 300-400 shots.

Profit obtained through application of TD process

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