

DATA SHEET

Name of die
Bulging punch

- An Example of profit obtained -

Year, month, day

Mode of working
Pipe forming

Name of firm

Haneda

Work material (Product)

Material AISI 304Size 0.8 mm

Hardness

Remark Seamless pipe

TD treated die

Carbide VCBase metal D2

Hardness of substrate

H_R C 59

Remark

Working condition

Machine

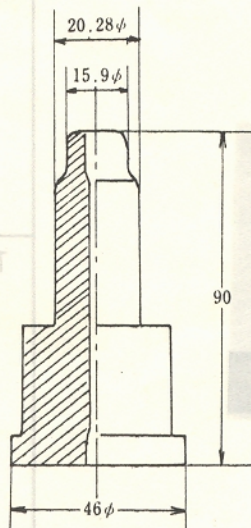
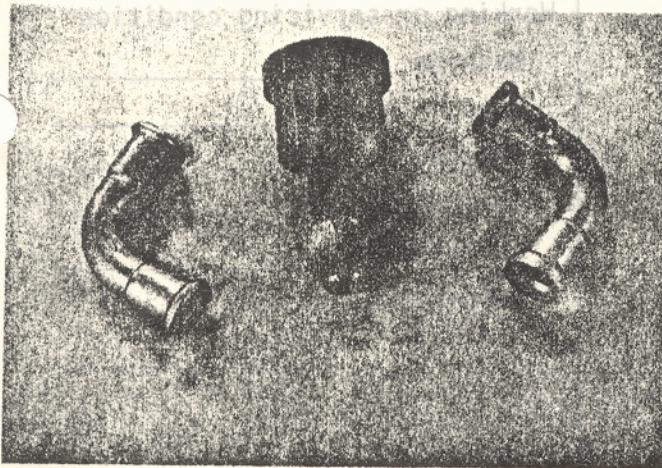
Load 150 tStroke 30S/min.

Clearance

Lubrication Oil

Temperature of work

Sketch of TD treated punch

Photo of punch
and product

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 Re-plating after 400-600 shots.
Frequently snapped.

Profit obtained through application of TD process

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