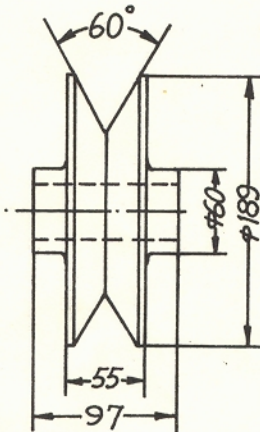


TD Process Application to Dies and Jigs

TD Process  
Application Data  
No. 8F-5 -1/1

Die or Jig	Name	Feed roller (Drive roll)					
	Category	Die (pressing, <u>cold forging</u> , hot forging, die casting, sand molding, powder compacting, rubber molding, plastic molding, glass casting) Cutting tool, Knife, Guide roller, Others ( )					
Material	Steel Code	AISI D2	TD	Coating	VC	Treating Condition	
	Heat Treatment	Hardened		Thickness	$\mu$	Substrate Hardness	H <sub>RC</sub>

Sketch of Roller



Work	Material		
	Dimension	30 $\phi$	Hardness

Sketch of Work

How It Is Worked

Roller is kept in rotating under sliding contact with bar for 12 hrs in a day. 3200 cuts is taken in a day.

Evaluation

D2 Hardened roller

Roller wear made scratch marks on bar which originated cracking in subsequent cold forging.

TD treated roller

No sign of wear after 52 months. Still in service.

Effect

- Increase of life
- Reduction of maintenance cost
- Saving of lubricants
- Increase of working rate
- Others

Working Condition

Machine	Cropping Machine
Load	
Stroke	
Speed	
Temperature	°C
Lubrication	
Clearance	

Recorded by \_\_\_\_\_

Date \_\_\_\_\_