

DATA SHEET

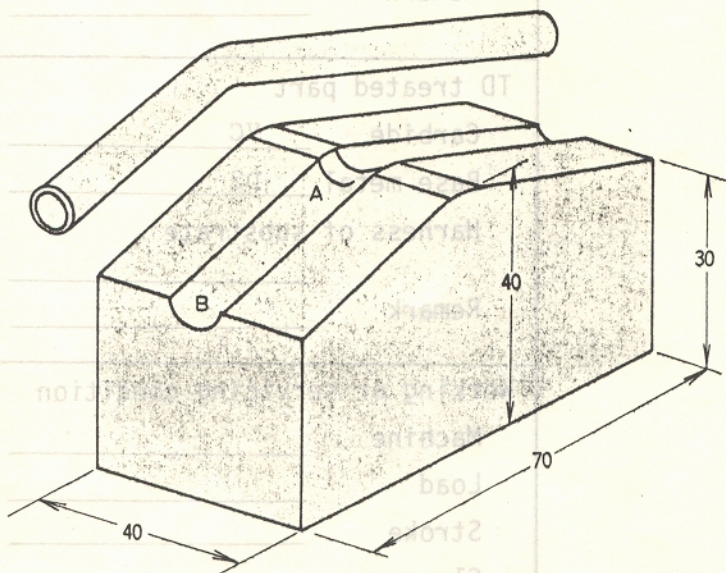
Name of die
Bending die

- An Example of profit obtained -

Year, month, day

Mode of working
Pipe bendingName of firm
Tokairika Denki

Sketch of bending punch and product



Work material (Product)

Material Mild steel pipe

Size $\phi 8 \times 175 \times 1.2t$

Hardness Hv 175 - 205

Remark

TD treated die

Carbide VC

Base metal

Hardness of substrate

 $H_R C 60$

Remark

Working condition

Machine

Load 3 ton

Stroke

Clearance

Lubrication oil

Temperature of work

Result

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

Ol,

Hardened

 $H_R C 60$

Life and other evidences

TD die 109,800 shots.

The die to be compared 47,700 shots. Worn at A and B.

Profit obtained through application of TD process

1. Reduction of cost
2. Decrease in repair work
3. Decrease in shut-down time