TD Process
Application Data
No. - /

							Source		N	0, -	Dart	Name of
Die or Jig	Name Roller for roll forming				g	H. Niwa			Rollers for roll forming			
	Category	Shee	Sheet metal stamping						8:		servi etals	Mode of Sheet m
Mate- rial	Steel Code		Cold working die steel		DC	Coating	VC		Treating Condition			
	Heat Treatment		Size Hardness			Thickness			Substrate Hardness			
Remark							Work		erial ension	Hot ro	Hard	
	vc D2 D2 Strate	14	TD treated CarbidO Base met Harness Remess Remess Load	291			Sket	ch o	f Work	1.6 mmt	ness	
	work		Stroke ClearORcl Lubricat Temperatu	<b>→</b>			How	It Is	s Worke	<u>ed</u>		
			ClearO7cl Lubricat	of th	ness	and hardi	tment	trea	netal,	Base n		Result
Evalua	ared		ClearOncol Lubricat Temperatu	of th	ness	H C 60 R Ef	tment	trea	netal,	Base W W		
-	tion	ion ure of	ClearOncol Lubricat Temperatu e part to be			H C 60 R Ef	tment hed	trea	netal, Ha	Base w		
Chromi Fr	tionium plated	ion ure of	ClearOncol Lubricat Temperatu	-plating		Ef	tment here feet one bive of lift of	treament and the second	netal,	Working		
Chromi Fr sh	tion ium plated requently sp	ure of open open open open open open open open	ClearO.cate Lubricate Temperate e part to be e	-plating some		Ef Increase Reduction maintena Saving of	ffect onebry of lift of nce cc	sent fe ost	metal.  Mandoth  indoh  baol  baol  baol  colored	Norking		
Chromi Fr sh TD upp	tion ium plated requently sp	ure of open open open open open open open open	ClearO.cate Lubricate Temperate e part to be e	-plating some		Ef Increase Reduction maintena Saving of	ffect onebry of lift of nce cc	sent fe ost	Machi Load Load Strok	Norking Norking	Condi	tion
Chromi Fr sh TD upp	tion ium plated requently sp nots. per roll	10n 200,00 100,00 100,00 100,00	ClearO.cate Lubricate Temperate e part to be e	-plating some :ill suable m	S C S	Ef Increase Reduction maintena Saving of Increase	fect one by of lift of nce cc lubri	fe ost	Machi Load Load Strok	Norking	Condi	tion
Chromi Fr sh TD upp	tion ium plated requently sp nots. per roll	10n 200,00 100,00 100,00 100,00	ClearOncate Lubricate Lubricate Lubricate Temperate e part to be e part to be errors and consistence c	-plating some :ill suable m	S C S	Ef Increase Reduction maintena Saving of	fect one by of lift of nce cc lubri	fe ost	Machi Load Load Strok Speed Tempe	Norking Norking	Condi	noit

- 7

Date Dy