APPLICATION DATA

Name of par	t	Source	Source	lame of part	
Piercing p		K. Iwai, et al	l (Nippon Denso Co., Lt.		
Mode of servicing		Press Gijyutsı	Press Gijyutsul	ode of servicing	
Cold forging Vol.16, No.7 (197			(1910) b·30		
	fair	Work mater	Work materi	al	
Material Carbon steel wire for cold heading and forgi			Material	AISI 1010	
			Size		
			Hardness	Hardness	
			Remark		
TD treated part			TD treated	part	
Carbide VC			Carbide	VC	
Base metal M2			Base meta	Cemented carbide	
			Harness of	f substrate	
			Damaul		
		ATOMBA	Remark		
Working or servicing consist on			Working or s	Working or servicing condition	
Mach Q Q			Machine		
Load			Load	> 150 kg/mm ²	
			Stroke	-	
-purious significação			Clearance		
nindative advisation relatives to the second			Lubricatio	n	
23.14.14.14.14.14.14.14.14.14.14.14.14.14.		15 19 (MP)	Temperatur	e of work	
Pu	nch, blank and	d product			
Result	Base metal, treatment and hardness of the part to be compared				
	M2, Cemented carbide benebran vilitanibro .SM				
	Life and other evidences evidences				
	TD part 461,000 shots/life 000.351 trag GT				
	The part to be compared M2: 25,000 shots/life by scoring Carbide: 25,000 shots/life by scoring				
	Profit obtained through application of TD Process				
	In the case of VC coated carbide punches, 2 times of polishing and				
*	2 times of	VC coating were appl	ied.	Portelling and	