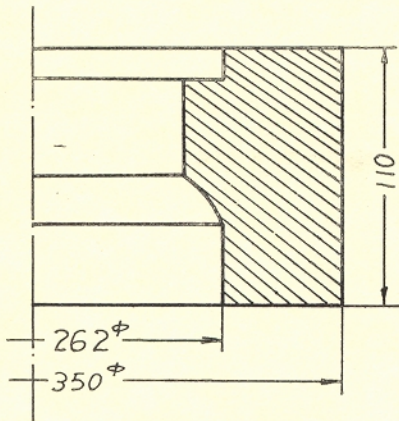


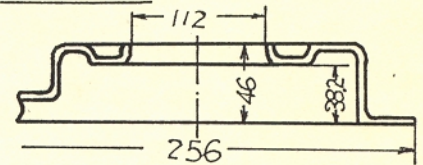
Die or g	Name	Drawing die					
	Category	Die (pressing, cold forging, hot forging, die casting, sand molding, powder compacting, rubber molding, plastic molding, glass casting) Cutting tool, Knife, Guide roller, Others ()					
Mate- rial	Steel Code	SKD11	TD	Coating	VC	Treating Condition	
	Heat Treatment	hardening		Thickness	μ	Substrate Hardness	H _{RC}

Sketch of Die

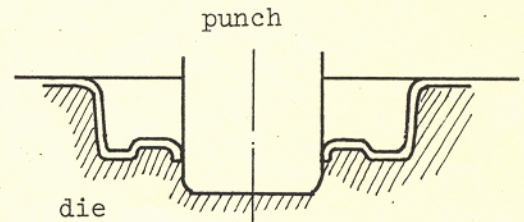


Work	Material	SPH28D		
	Dimension	3.2 t	Hard- ness	

Sketch of Work



How It Is Worked



Evaluation

SKD11 hardened : Repair cycle
min. 500 - 11,000 shots
to max. 17,000 - 18,000
shots

TD : All right after 600,000 s' and still
usable

Effect

- Increase of die life
- Reduction of maintenance cost
- Saving of lubricants
- Increase of working rate
- Others Reduction of product inspection time

Working Condition

Machine	300 t Transfer press
Load	
Stroke	
Speed	0.3 m/sec
Temperature	°C
Lubrication	Machine oil # 70
Clearance	