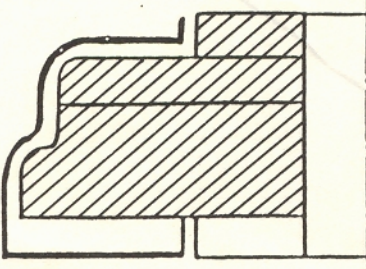
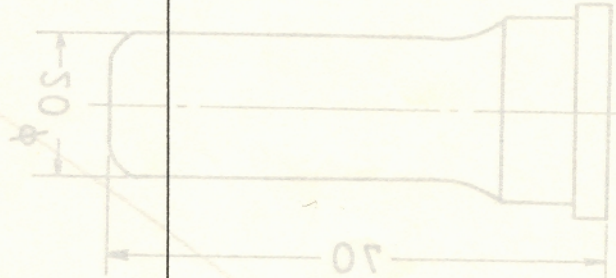


Die	Name	Forming roll					
Category	Die ((<u>stamping</u>), cold forging, hot forging, die casting, sand molding, powder compacting, rubber molding, plastic molding, glass casting) Cutting tool, Knife, Guide roller, Others ()						
Material	Steel Code	D2	VC	Coating	VC	Treating Condition	
	Heat Treatment		TD	Thickness	μ	Substrate Hardness	H _{RC}
Sketch				Work	Material	High strength steel (4.55 kg/mm ²)	
					Dimension	1.6mm	Hardness
				<p><u>Sketch of Work</u></p> <p>Bumper</p> 			
				<p><u>How It Is Worked</u></p> <p>Roll forming</p>			
<u>Evaluation</u>		<u>Effect</u>		<u>Effect</u>		<u>Working Condition</u>	
Ordinarily hardened		Increase of die life		Increase of die life		Machine	
20,000 shots, polishing		Reduction of maintenance cost		Reduction of maintenance cost		Load	
60,000 ~ 70,000 shots, life		Saving of lubricants		Saving of lubricants		Stroke	
TD 750,000 shots, Spalling		Increase of working rate		Increase of working rate		Speed	
1,000,000 shots/Re-TD		Others		Others		Temperature °C	
						Lubrication Water-soluble	