

CASE STUDY 31

(USE OF HOT FORGING LUBRICANT TO INCREASE DIE LIFE)



CUSTOMER DETAILS :

A company manufacturing different forging components like axles, connecting rods and bell crank lever.



OBJECTIVES FOR CONDUCTING THE TRIAL

1. To increase die life and reduce overall cost.
2. To reduce the polishing frequency of die.



OPERATING / APPLICATION DETAILS:

1. Machine : NKH Hammers
2. Tonnage: 1000 Tons
3. Tank Capacity : 300 lts
4. Part : Axles (Body -130)
5. Material : Steel
6. Application : Forging
7. Spray : Manual
8. Dilution Ratio : 1: 10
9. Billet Temperature: 1100 +/- 50 Deg C
10. Die Temp: 150 to 200 deg C
11. Die Polishing Frequency: 3000 components.
12. Trial period : 15 Days



COMPONENT VIEW



PRODUCT RECOMMENDED: HILUBIRC FW 02

TRIAL RESULTS

Good Component Finish
was observed



No severe die cavity was observed
after 3000 components.



Increase Die Life by
5.4 %