CASE STUDY 83

NEW GENERATION LUBRICANT FOR THE FORGING INDUSTRY

CUSTOMER DETAILS :

One of the leading manufactures from South India producing steel forgings parts (valves, oil and gas parts, rollers, Auto parts & hydraulic cylinders parts).

OBJECTIVES FOR CONDUCTING THE TRIAL

1. Consumption cost Reduction
2. Achieve the required Die life – ~5000 Numbers
3. No die stickiness
4. Better Surface Finish –Visual (No wrinkle marks/ cracks)

OPERATING / APPLICATION DETAILS:

1. Press : National Maxipress
2. Load :1600 Tons
3. Part : U Ring (Trial taken part-Critical part)
4. Spray type: double side spray gun, pneumatic operated tank.
5. Material : EN 11
6. Billet Spec: breadth -6.5 * length -160 CM
7. Billet weight : 6.5 kg (Deep cavity part)- 3 stages (Upsetting >blocker > finisher)
8. Billet temp : 1150 ~ 1250°C
9. Existing product : : XXX 105
10. Existing dilution ratio : 1:14 (Our trial ratio : 1:14)
11. Required die life: 5000 No's (nitride coated die)

COMPONENT VIEW

PRODUCT RECOMMENDED: HILUBRIC FW 02 M

TRIAL RESULTS

- LESS DIE CATCH UP IN CRITICAL COMPONENTS FORGING
- GOOD EJECTION AFTER FORGING.
- REQUIRED SURFACE FINISH ACHIEVED (NO WRINKLE MARKS)
- LESS SCALE FORMATION
- CONSUMPTION COST REDUCED : 2 %