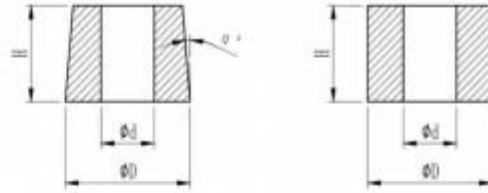


Carbide Cold Heading Dies is used on the cold forging machine, making the materials cutting, reforming, forming to the mould

冷镦模

Cold heading die



尺寸公差

Size of tolerance

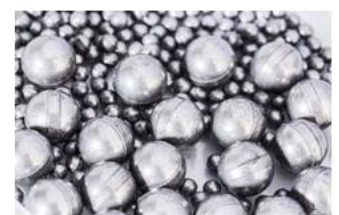
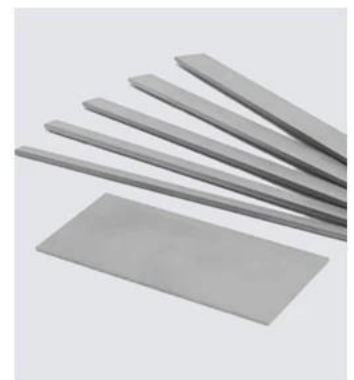
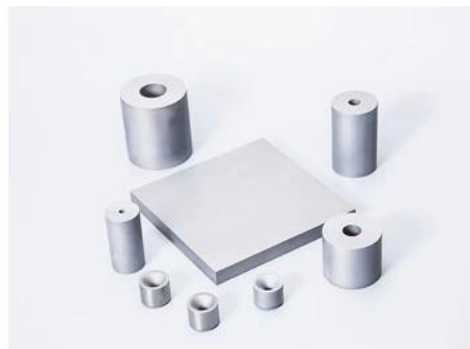
外径 Outside Diameter	牌号 Grade				Grade		
	HG6	HG7	HD7	HD8	HD9	HD11	HD12
外径极限偏差				Deviation			
Ø10~Ø30	+0.3~-+0.6				+0.3~-+0.6		
Ø30~Ø50	+0.4~-+0.7				+0.4~-+0.8		
Ø50~Ø70	+0.4~-+0.8				+0.4~-+1.0		

内径 Inner Diameter	牌号 Grade				Grade		
	HG6	HG7	HD7	HD8	HD9	HD11	HD12
内径极限偏差				Deviation			
Ø1~Ø10	-0.2~-0.4				-0.2~-0.4		
Ø10~Ø20	-0.3~-0.8				-0.3~-0.8		
Ø20~Ø30	-0.5~-1.0				-0.8~-1.2		
Ø30~Ø40	-0.8~-1.5				-1.2~-1.5		
Ø40	-1.0				-1.2		

高度 Height	牌号 Grade				Grade		
	HG6	HG7	HD7	HD8	HD9	HD11	HD12
高度极限偏差				Deviation			
10~35	+0.6~-+1.0				+0.6~-+1.0		
35~45	+0.8~-+1.2				+0.8~-+1.5		
45~55	+1.0~-+1.5				+1.0~-+1.5		
55~65	+1.2~-+1.8				+1.2~-+1.8		

Grades Recommendation :

牌号	钴含量	WC 晶粒度	硬度	密度	抗弯 强度	弹性 模量	冲击 韧性	适用范围
Grade	Co %	Grain Size of WC/um	Hardness HRA ±0.5	Density g/m ³ ±0.1	Flexural Strength Mpa	Elastic Modulus Gpa	Impact Toughness J/cm ²	Applications
HG6	15	2	86.5	13.95	3000	440	6.4	耐磨、耐冲击要求比较高的工程齿、冷 锻模具。 Suitable for Engineering Teeth, Cold Forging Die, with High Wear and Impact Resistance.
HG7	18	2	85	13.75	2800	410	7.4	
HD9	24	2	82	13.10	2800	340	10	
HD11	21	2	84.5	13.45	2800	340	8.2	具有高韧性、耐冲击性、耐热冲击性等优 点，适用于在对冲击性要求比较高的冷 间锻造领域。 Suitabale for Strict Requirement Cold Forging Area, with High Toughness, Impact Resistance and Heat Resistance.
HD12	24	2	82.5	13.15	2800	340	10.4	



PRODUCTION WORKFLOW CHART



RAW MATERIAL



MIXING & GRINDING



AIR DRY



MOLDING



INSPECTION



SINTERING



METAL PROCESSING



FQC



PACKING