

Flat (Solid) Die

1. Inlaid Port

1.1. outside minimum 15% bigger
Area

1.1.2 from Center to outside 10%
bigger Area (do it like a Bone)

1.1.3. If you dont use a Sprayderring
go on a Welding Area <40mm

1.1.4. spreading >6°

2. Pre Camber

2.1. 3mm high distance 2mm 5mm high distance 4mm 8mm high distance 5mm

2.1.2 at small Parts open the Area
2mm

2.1.3 If possible use multi Step pre also follow the Inlaid Port
camber Rules at the Multi Steps

2.1.4

3.Support

3.1. Garantie best support

3.1.1. 5-10mm distance each Part

3.1.2. > 2 Times the toungue high
should be the Die Plate high
after Bearing

3.1.3.

3.1.4.

5. Bearing length