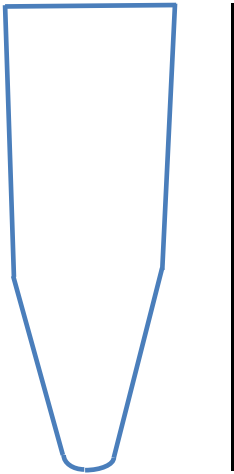


Design Rules

From "A" 1/3
= Bridge wide



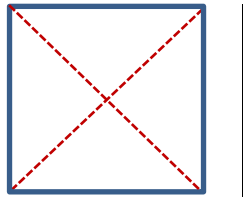
Bridge high "A"

Angle 3° and 15° or 20°

On Alloy 6060 or 6063

welding Camber

should be a cube



same high and
width

same high
and width

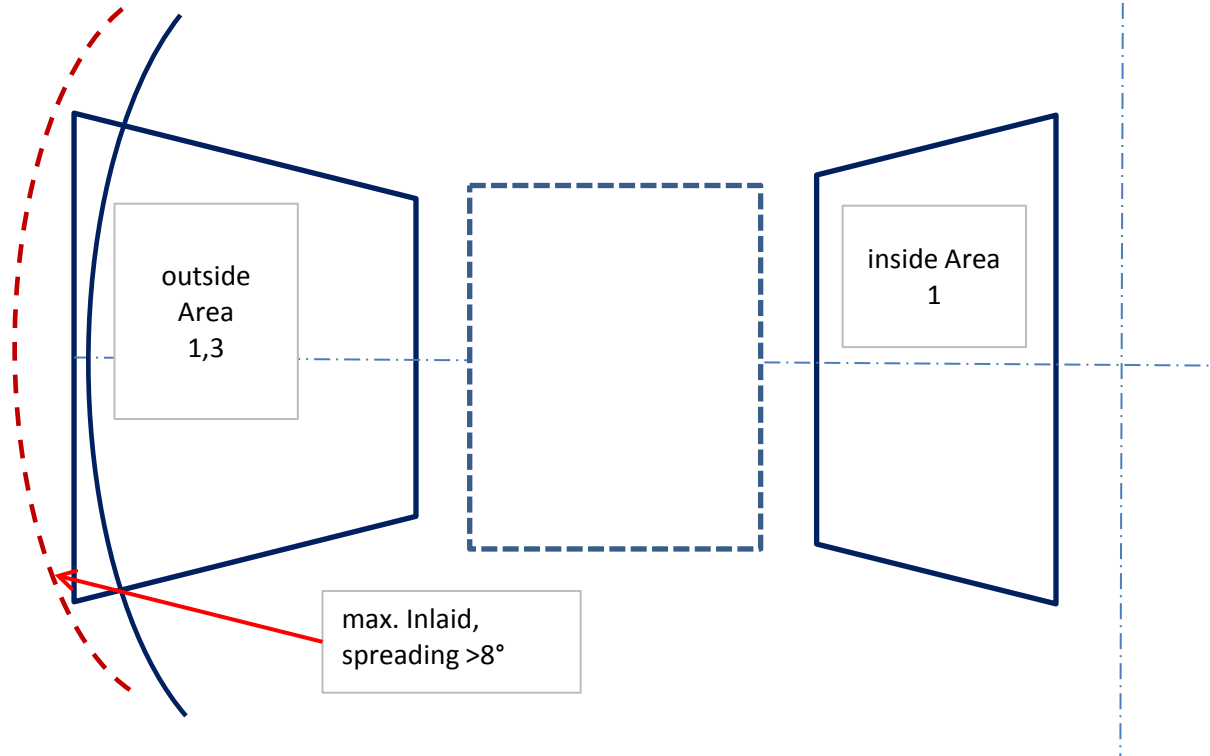
Mandrel Undercut both sides the same!

R 0,5-1,0

≥ 7mm

Angle both
sides the same
15-25°

**Outside Area spreading every time 5-8° 1,3,
because we will get a lower pressure in the Die**



Best possible support to the Die

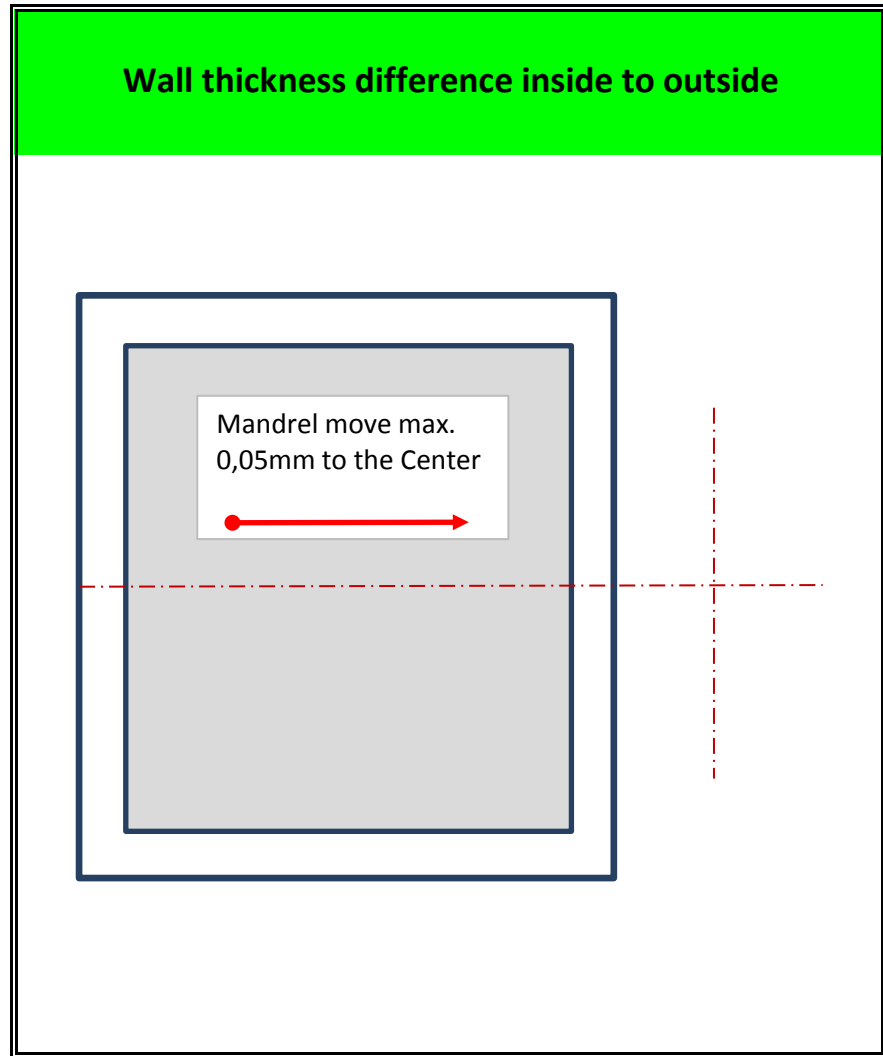
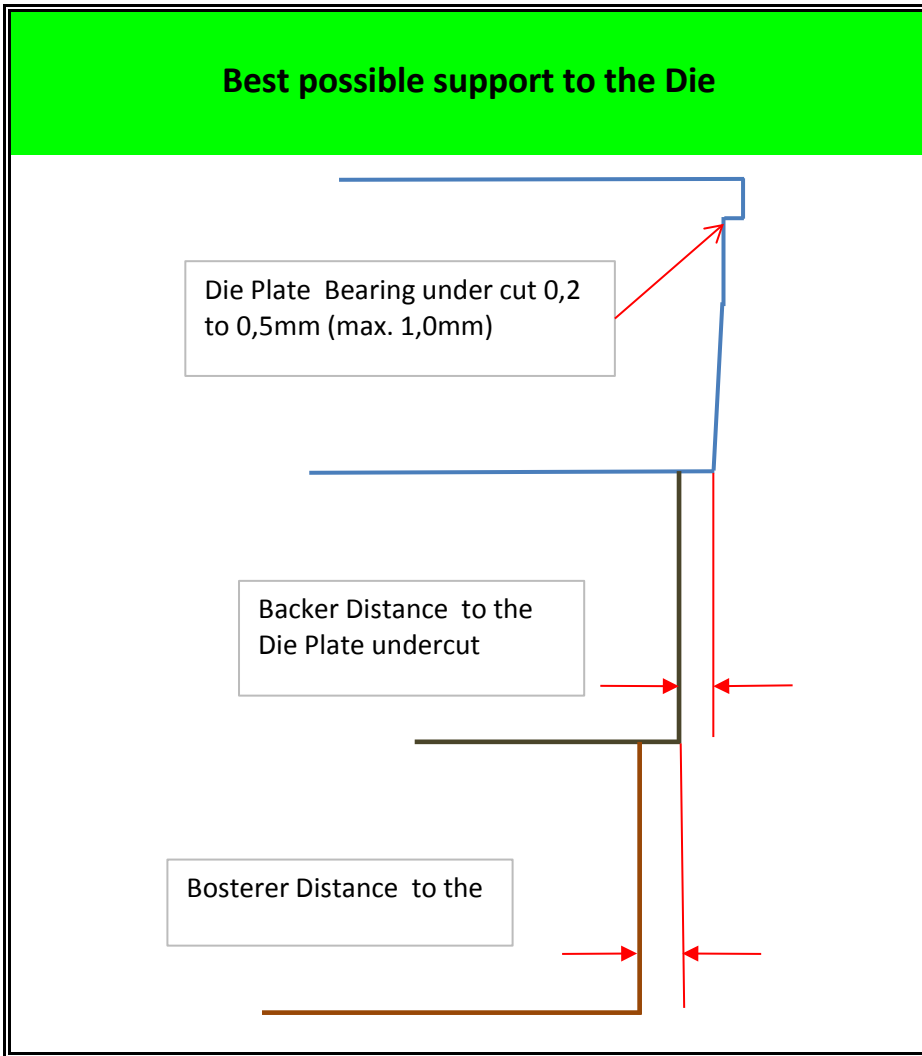
Die Plate Bearing undercut 0,2 to 0,5mm (max. 1,0mm)

Backer Distance to the Die Plate undercut

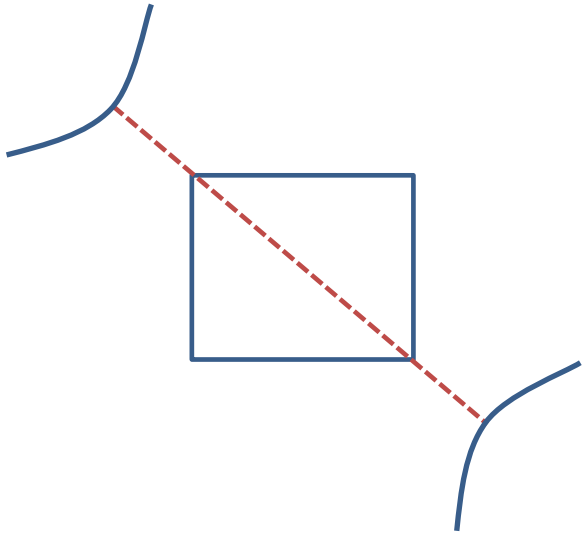
Bosterer Distance to the

Wall thickness difference inside to outside

Mandrel move max. 0,05mm to the Center



"Überspannung" x 0,60 is calculated Bridge high on 4 Bridges

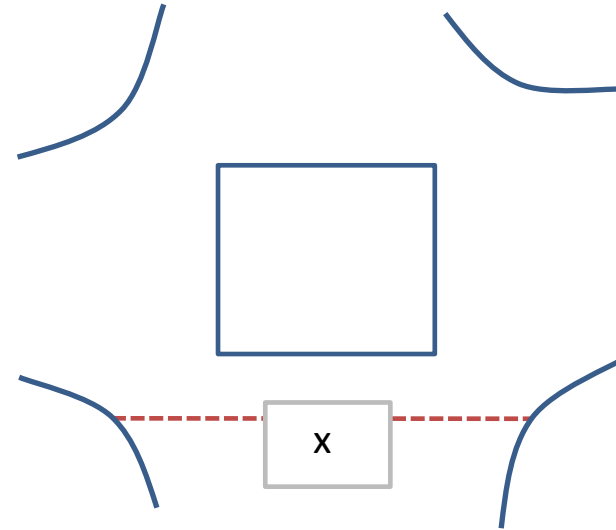


"Überspannung" x 0,65 is calculated Bridge high on 3 Bridges die design

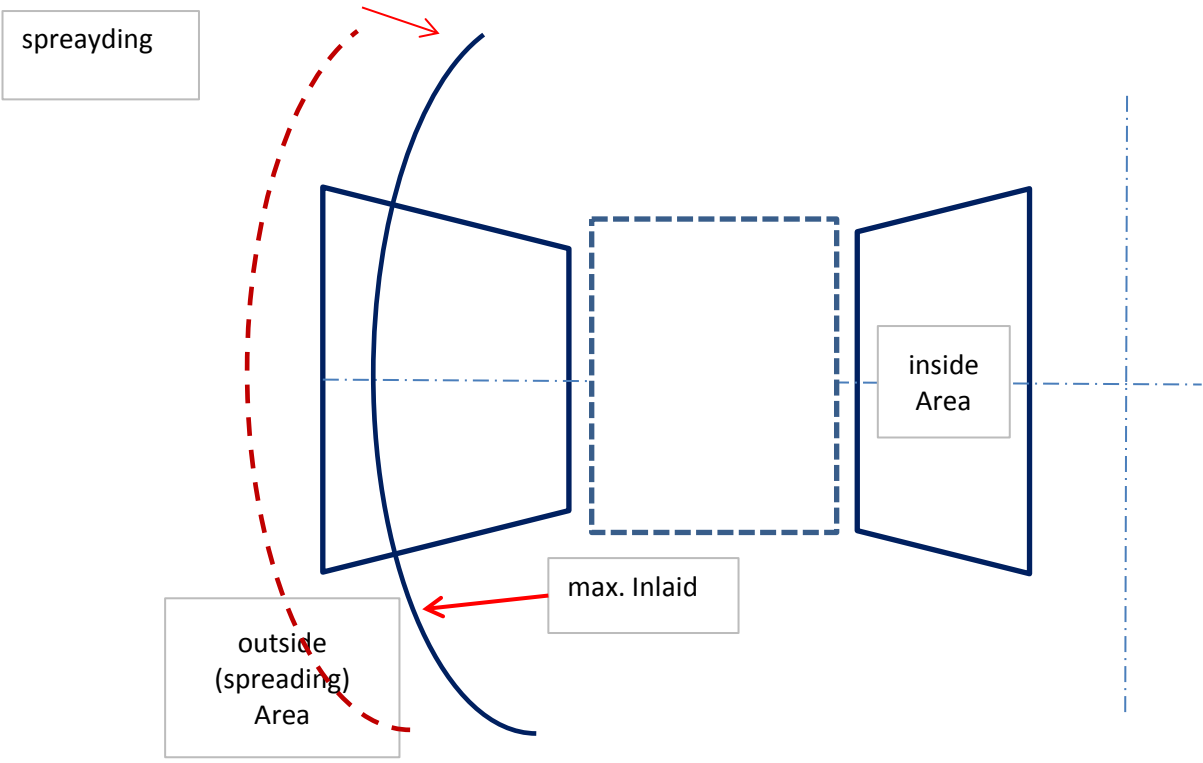
"Überspannung" x 0,70 is calculated Bridge high on 2 Bridges die design

highes speed with a little Risk "Überspannung x " x 0,70 is calculated Bridge high

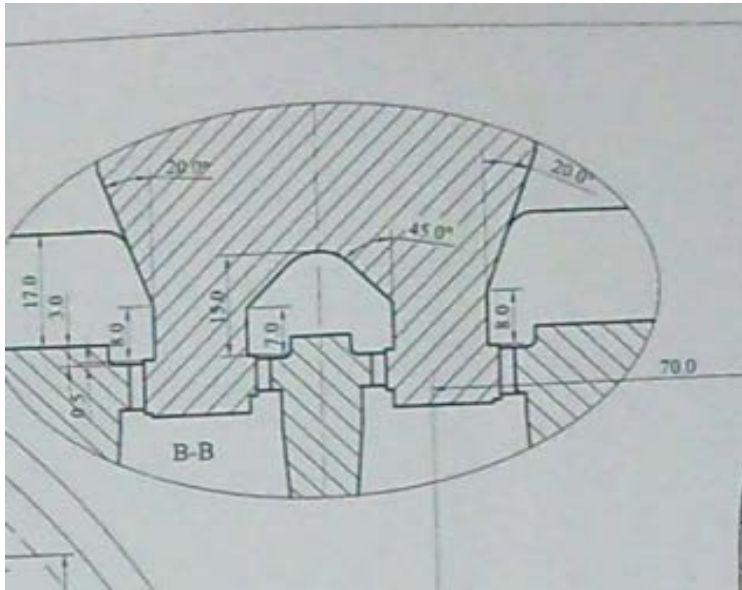
Überspannung X



**Difference inside to outside Area if you are spraydering more than 5-8°
(sprayder the inlaid on 25 or 30°)**



Between two mandrel try to do give support to them with an Angle like this so they cannot easy move outside



Bearing length on Mandrel and Die Plate

