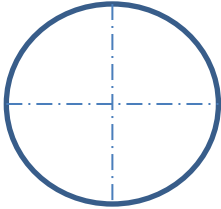
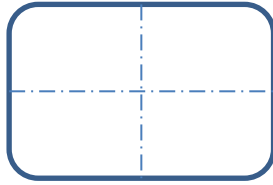


1. Inlaid - Material flow same Area but different Forms

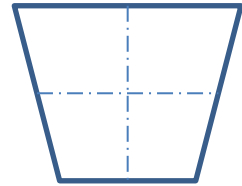
Best flow



second and third best flow



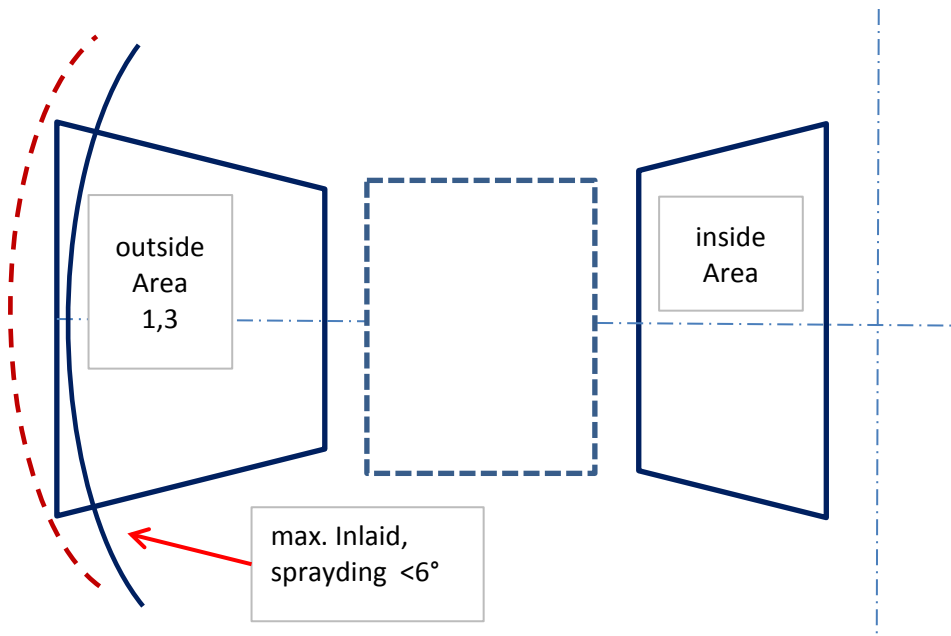
second and third best flow



worse flow



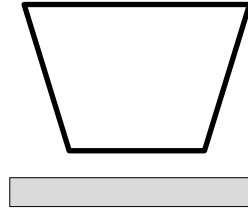
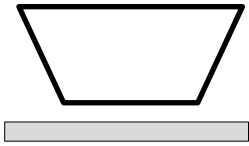
2. Inlaid Distance to the Center Close to the Center the best flow, so the Inlaid should be smaller



for better understanding

3. Relation of Inlaid and Profile Area

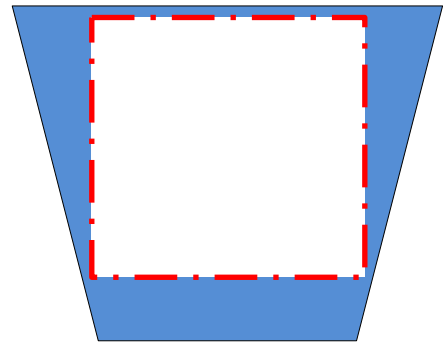
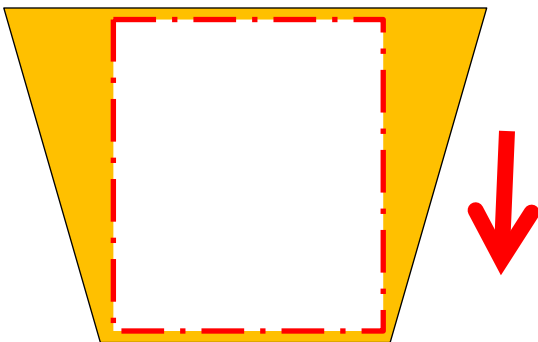
bigger Profile Area increase the Volume



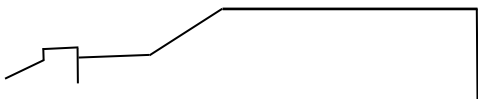
4. Relation Undercut Area

Mandrel moves this way because the undercut Area is not even

should be ok because the undercut Area should be nearly the same



5. Time and the Way the Aluminum needs to go too the Bearings should be the same all around



for better understanding

6.Distance to the supported Area the Mandrel to the Die Plate (Deflexion Area)

