die making inspection

1. Be sure the Die and Die design are exactly the same

1.1 max. Difference <0.03mm at the Wall thickness
- if it is not return the die to the supplier
because you don't do this, you are not sure, are some problems from the Process, or from the die at the beginning. So you can't do a good analysis and correction.

1.2 Press Canal is exact in Angel (normally, the wire cutting-machines are working on a tolerance from
- if it is not return the die to the supplier
so you are sure, that if it is not in Angel the next time, it is a Problem in your Process

2. Go to Trial, or not?

2.1 if you don't do a Trial (80% of all Dies are running without a Correction)

2.1.1 Polished, with fine Paper >400 - 600
2.1.2 put all the oil and Polishing Pasta away! (maybe use a cleaning machine
2.1.3 don't touch the die with fingers before you nitrided

If you have a Problem with the Die after nitriding, you can also do a Correction on the die, but a little bit harder!

2.2 if you go to Trial be careful with the Die by:

2.2.1 polishing use a very fine paper >400 - 600; and polishing
2.2.2 heat it up > 4h
2.2.3 use a shorter Billet to start Extrusion
2.2.4 be sure that the Billet is warm like you
set the Temperature
2.2.5 do the die in caustic System below 100°C
2.2.6 cleaning the die use liquid Sandblastermachine because with water you