

high speed Principles

1. Use the Maximum possible Inlays
sprayder outside inlays
2. No sharp edges!
3. Best support to the Die
multi cavity Dies best support to the Center!
4. Center mill down for lower Deflexion
can also works with steps
5. Bridge Angle 3° and than go 15° to 20°
for hihger Extrusion speed
6. Distance from Die Plate to Mandrel support - as small as possible
Deflexion Distance!
7. Bearing length standard difference Mandrel to Die Plate 0,5mm to max. 1,5mm
Mandrel outstanding
8. Undercut of the Mandrel should be all around nearly the same Area