

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

1.1 max. Difference $<0,03\text{mm}$ at the Wall thickness

- if it is not

return the die to the supplier

because you dont do this, you are not shure, are some problems from the Process, or from the die at the beginning. So you cant do a good analyse 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 shure, 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 dont 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 bevore 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

$> 4\text{h}$

2.2.3 use a shorter Billet to start Extrusion

2.2.4 be shure 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 becaus with water

you