

1. Contact Data

Name: ENDURANCE TECHNOLOGIES LIMITED

Department:

Email:

Telephone Number: +91 240 2556686

SIN Number:

Sales Responsible: HARIKRISHN

Order Number:

2. Tool Type

Metal Forming

Plastics Processing

AL Die Casting

HPDC

Other:

3. Tool condition

Visible Porosity, Cracks, Welded Zones

Comment: Die having severe heat checks

4. Detailed Inspection

Customer Data:

Tool Material(target): H13

Hardness(target)HRC: 44-46

Tempering Cycle C/E: 540

Tempering Cycle C/T: 370

No.parts to send(target): 12

QA Requested: Hardness Check, Full QA* Report

Lab Analysis:	Tool 1	Tool 2	Tool 3
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Material (actual):	NA	NA	NA
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Hardness (actual):	46-47	46-47	NA
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Tempering Condition:	NA	NA	NA
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No. parts received(actual):	13	0	0
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Detailed Inspection Comment: There was a difference of 2HRc between customer measurements and o

5. Surface Solution

Coating: BALINIT LUMENA DUPLEX

Pre-polishing requested

Functional surface identified

Surface condition of tool on arrival: Technical Polish Level

Rz/Ra measured: 0.09/ 0.08/ 0.09

Pre-Polish Requirements: Technical Polish

Post coating polish requirements: Top blasting + Post polishing

Customer specific requirements: Heat checks get generated on the die profiles need to remove maximum
chosen coating for this die because to prolong further crack generation.

6. Tool Sketch

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Tool designation: Swing arm for KTM Processing material: AL(AL)

Material strength: Material thickness:

Lubrication applied:

Blank Coating: Etched structure: None

Plastic Injection:

Performance of previous solution: No previous solution provided