



Purpose:

To rectify bend & distortion in CDF arts which distort in trimming or to control thickness in close tolerance if required as per drawings.

Scope:

A. Hot Coining:

- Pre heat dies to 100⁰ C to 150⁰ C.
- Parts to hot coin after trimming/Piercing.
- Heat forgings to about 800⁰ C to 850⁰ C and descale parts before coining.
- Ensure that hot coining dies are relieved in the area of stamping to avoid the damage to the stampings also relieved on parting line to avoid kissing of dies and jamming of press.

Method:

- Load the dies on coining trim press.
- Match center line properly and clamp.
- Set the shut height such that designed gap is maintained between the die faces.
- Locate hot forgings on the bottom die impression.
- Hot coin by giving one or more strokes to rectify the Bend and maintain thickness (if necessary).
- Check first sample and adjust shut height if required to obtain the desired result.
- Clean the dies at regular interval to remove the scale from die cavity.

B. Cold Coining:

- Parts to cold coin after inspection & sorting of defective parts
- Parts must be shot blasted before coining.
- Ensure that Coining dies should be relieved in the area of stamping to avoid the damage to the stampings also relieved on parting line to avoid kissing of dies and jamming of Hammer.

Method:

- Load the dies on hammer.
- Match center line properly and dies key tight.
- Set the Dies such that designed gap is maintained between the die faces.
- Locate cold forgings on the bottom die impression.
- Cold coin parts by giving one or more strokes to eliminate the Bend and maintain thickness (if necessary).
- Check first sample and adjust shut height if required to obtain the desired result.
- Clean the dies at regular interval to remove the scale from die cavity.

PREPARED BY.
Supervisor Production

APPROVED BY.
Head Production