

ZAPP TOOLING ALLOYS, INC.

Z-TUFF PM CASE STUDY BLANKING PUNCH



TOOL TYPE

Blanking punch

WORK MATERIAL

.113" thick High Strength Low Alloy (HSLA)

PROBLEM IDENTIFICATION

D2 (Rc 60–62) was chipping at the corners after 700 hits resulting in unscheduled downtime, lower production and higher tooling costs. Most narrow point on the part is .143", so a difficult die design. Additional materials were investigated with these results:

- _ K340 (Rc 58-60) 2,150 parts
- _ Vanadis (Rc 58-60) 2,340 parts
- _ Z-Wear PM (Rc 60-62) 3,000 parts
- _ Caldie (Rc 58-60) 4,500 parts

SOLUTION

Z-Tuff PM

RESULTS

Zapp's Z-Tuff PM (Rc 58-60) successfully ran 17,500 parts before requiring resharpening. Production levels improved dramatically and tooling costs were reduced.

TOOLING ALLOYS

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Further information regarding our products and locations are available in our image brochure and under www.zapp.com

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