

TG

TRIMMING DIES

PIONEER TRADING CO., LTD.

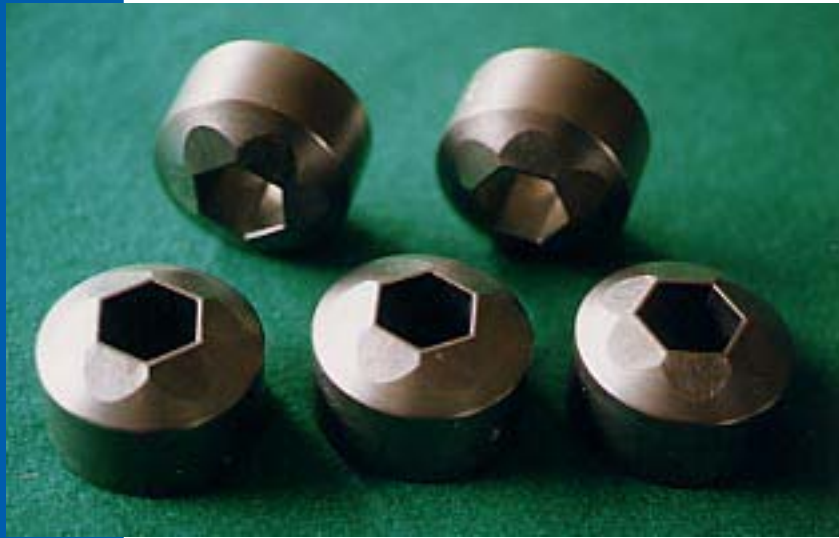
What makes TG trimming dies so special?



The answer is the
MULTILAYER
COATING

TG TRIMMING DIES

ULTRA LONG LIFE



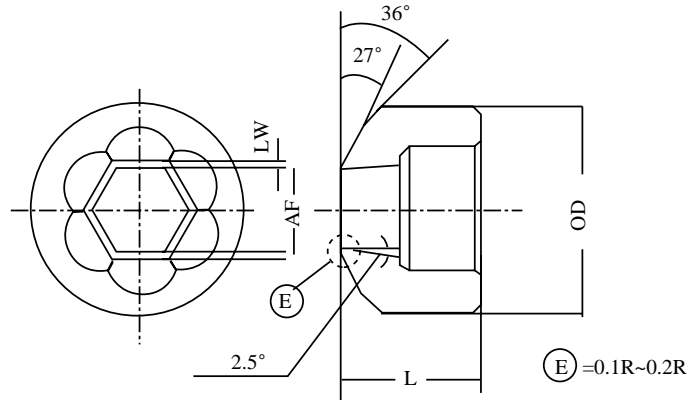
T & G Machine Tool Co., Ltd. has developed Special CVD coating (CN05) trimming dies for the longest possible life.

In order to assure excellent quality and consistent long life, T & G company has currently been employing the following systems in manufacturing:

1) Instead of broaching operation, T & G has been employing excellent quality hydraulic hobbing presses to form internal hexagon portion for regular trimming dies and slotting machines for custom made trimming dies for the reason of flexibility. The hobbing press assures excellent fiber flow and makes the dies stronger and the dies manufactured in this system are excellent for coating.

2) Blade portion has been ground by grinders and finished by lapping machine as manual operation was found to be inferior.

DESING AND DIMENSIONS OF T & G TRIMMING DIES



CODE No.	NOMIAL AF DIMENSIONS	+0.05 AF -0	+0 OD -0.05	L	R E	LW	CN05 CVD 5 LAYERS HRC 63 ± 0.5
TG-1010	10	9.80	30	19	0.2	0.6	
TG-2013	13	12.75	35	23	0.2	0.7	"
TG-2014	14	13.75	35	23	0.2	0.7	
TG-2017	17	16.75	35	23	0.2	0.7	
TG-3014	14	13.75	42	23	0.2	0.7	"
TG-3017	17	16.75	42	23	0.2	0.7	
TG-3019	19	18.75	42	23	0.2	0.8	
TG-4014	14	13.75	45	28	0.2	0.7	"
TG-4017	17	16.75	45	28	0.2	0.7	
TG-4019	19	18.75	45	28	0.2	0.8	
TG-4022	22	21.65	45	28	0.2	0.9	
TG-4024	24	23.65	45	28	0.2	1.0	
TG-5022	22	21.65	60	40	0.2	0.9	
TG-5024	24	23.65	60	40	0.2	1.0	
TG-5027	27	26.65	60	40	0.3	1.1	
TG-5030	30	29.65	60	40	0.3	1.3	
TG-5032	32	31.65	60	40	0.3	1.3	
TG-6030	30	29.65	70	40	0.3	1.3	"
TG-6032	32	31.65	70	40	0.3	1.3	
TG-6036	36	35.65	70	40	0.3	1.4	
TG-7041	41	40.60	80	40	0.3	1.5	"
TG-7046	46	45.60	80	40	0.3	1.6	
TG-8046	46	45.60	100	50	0.3	1.6	"
TG-8050	50	49.60	100	50	0.3	1.6	
TG-8055	55	54.60	100	50	0.3	1.7	

TECHNICAL INFORMATION FOR "T.G." TRIMMING DIES

1. MATERIAL:

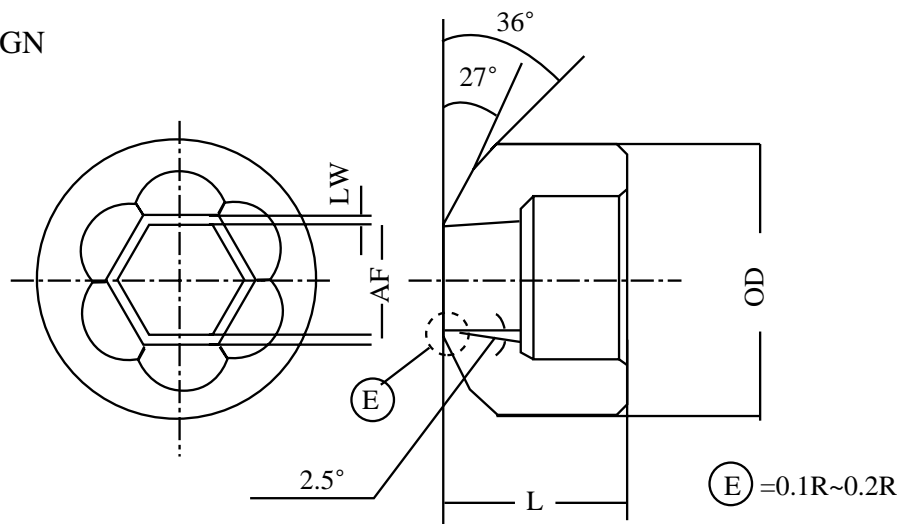
AISI M2 AND M35 EQUIVALENT TO Wnr. 1-3243, DIN S6-5-2-5 AND JIS SKH-55

2. HARDNESS:

BODY: HRC 64 ± 0.5
 BLADE FACE: VHN 3,000 - 3,500

3. THICKNESS OF TIC COATING 0.003 - 0.004 MM

4. DESIGN



5. T.G. TRIMMING DIES LIFE DATA

NOMINAL A/F DIMENSIONS	+0.05 AF-0	MACHINE	BOLT MATERIAL	AVERAGE
19	18.65	BOLT FORMER	S20C(0.2 CARBON STEEL)	600,000 UNITS
19	18.65	BOLT FORMER	SCM435(CHRO-MOLI STEEL)	150,000 UNITS
24	23.65	BOLT FORMER	S20C(0.2 CARBON STEEL)	520,000 UNITS
24	23.65	BOLT FORMER	SCM435(CHRO-MOLI STEEL)	70,000 UNITS

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