

Heading Die



Introduction

Cold heading is a process technology which make the work piece transformation and the shape close to the finished product to the utmost extent in few processes. It is the footstone of modern mechining and automobile industry. Toonney manufactures various heading die including drawing die, cold heading die, precision die, carbide dies, stamping die and forging die.

Under strong impact wear working conditions, tungsten carbide [cold heading die](#) is required hard alloy has good impact toughness, fracture toughness, fatigue strength, flexural strength, and good wear resistance.

1. Usually used in high cobalt and the coarse-grained alloy grades.
2. Carbide wear resistance, toughness relationship between the two are contradictory: to improve the wear resistance will lead to a decrease in toughness, and improve toughness and wear resistance inevitably lead reduction. Therefore, the choice of alloy grades, the need to work in accordance with the object and process conditions to meet specific requirements.



3. If the selected grades in use, prone to crack and damage early, should use a higher toughness grade; if the selected grade in use early wear and damage, should use high hardness, wear resistance and better grades. Toonney has below grades for stamping die options.

Grade	Density	Hardness	TRS	Impact force resistance
	(g/cm ³)	(HRA)	MPA	J/CM ²
EVA80	13.58	84	2740	0.85
RVA90	13.39	82.5	2350	0.90
RVA95	13.10	81.5	2150	0.96
XK5	31.10	83	2250	0.95
RST7	13.40	85	2640	0.80
RST8	13.30	84	2640	0.90

Samples Matters: Cold heading die and stamping die which can be available from our common regular inventory, can be offered as samples for free. For some cold heading die and [stamping die](#) with irregular customer special required, will be charged. Of course, customers need to pay for the shipping fee. Usually, the lead time of the samples will be within 7 working days

Minimum Order Quantity: There is no minimum order quantity of cold heading die and stamping die for the first trial order. But on the second order, the total amount of cold heading die or stamping die should be not less than 1000 USD.

Specification

Grade	Density	Hardness	Hardness	TRS	Compression strength	KIC
	(g/cm ³)	(HRA)	(HV)	MPA	GPA	MPA.m1/2
GA10	14.40	92.0	1865	3600	5.9	14
RKG2	14.93	90.2	1586	3200	4.1	17
RKG3	14.61	89.3	1447	3300	4	18
RKG4	14.31	89.2	1431	3400	3.9	19
RKG5	14.31	88.2	1276	3400	3.8	20
RKG6	14.12	87.2	1177	3200	3.7	22
RVA70	14.05	86.5	1076	3200	3.6	23
RVA65	13.73	85.0	900	3000	3.4	24



RVA80	13.58	84.0	832	2740	3.3	25
RVA90	13.39	82.5	756	2350	3	27
RVA95	13.10	81.5	709	2100	2.8	28
RST6	13.70	85.8	972	2740	3.5	23
RST7	13.40	84.8	886	2640	3.3	24
RST8	13.30	83.5	806	2640	3.1	27
GW60	13.95	84.5	865	3270	3.8	18
GW70	13.58	83.0	781	3050	3.6	22
KC12	14.31	85.8	972	2740	3.7	18
KC13	14.22	85.0	900	2740	3.6	20
KC18	13.73	83.5	806	2740	3.3	22
GA40	14.40	89.0	1400	3000	4.1	17
GA50	14.20	88.5	1323	3100	4	19
GA55	13.85	85.5	933	3000	3.7	21
GA60	13.65	84.5	865	2900	3.6	24

Feature

Product name: Cold heading die/ stamping die

Place of Origin: Fujian, China (Mainland)

Brand Name: Toonney

Model Number: CHD/SD

Type: Cold heading die/stamping die

Material: tungsten carbide

Tolerance: As required.

Grade: GA10 , RKG2, RKG3, RKG4, RKG5, RKG6, RVA70, RVA65, RVA80, RVA90, RVA95, RST6, RST7, RST8, GW70, KC12, KC13, KC18, A40, GA50, GA55, GA60

Size: As required

Port: Xiamen

Payment terms: FOB Xiamen

Application

1. GA10, RKG2,RKG3,RKG4(Density and hardness as above table shows)

Fit for heading dies such as tube drawing die, powder shaping die, nut and bolt die

Telephone: +86 592 7797922

Fax:+86 592 6771943

Email: sales@tncarbide.com,

Website: <http://www.tncarbide.com>

Add: No.61,Lianshang Road,Guannan Industrial District, Jimei District, Xiamen, China



2. RKG5,RKG6 (Density and hardness as above table shows)for scissor die, powder forming die, nut and bolt die.
3. RVA70(With density 14.02,harness85HRA) is specially applied for drawing the tight binding mould for screw and nuts
4. RVA65(With density 13.73, hardness 85HRA) is for small dia. bolt die, cold heading die
5. RVA80(With density 13.58, hardness 84HRA) is for big dia. bolt die, nut die, cold heading die
6. RVA90(With density 13.39, hardness 82.5HRA) is for screw head shape mould, nut die, high pressure stamping die
7. RVA95(With density 13.10, hardness 81.5HRA) is for nut die, flower shaped screw die,hot extruding die, super heavy stamping die
8. RST6(With density 13.70, hardness 85.8HRA) applied to stainless steel screw die.
9. RST7(With density 13.40, hardness 85HRA) applied to stainless steel screw die, impact resistant stamping die, screw die.
10. RST8(With density 13.30, hardness 84HRA) applied to raised head screw die, impact resistant stamping die, double horn shape screw die, screw die, rivet die.
11. KC18(With density 13.73, hardness 83.5HRA) applied to screw stamping die
12. Please contact sales for any questions in selecting material grades.

Advantage

1. Toonney [cold heading die manufacturer](#) control the quality strictly, have inspection devices such as the HV, HRA tester, TRS tester, Carbon sulfur analyser and high magnification metallurgical microscope to test the physical and chemical characteristics of tungsten carbide material. And precise demention device to control the shape tolerance.
2. Toonney stamping die manufacturer has more than 10 years production experience of stamping die and cold heading die.
3. Toonney [cold heading die plant](#) imports advanced equipment and develop their own professional team for designing and producing cold heading die and stamping die.
4. Toonney cold heading die factory can give the promise that all stamping die and cold heading die will have an inspection during producing and final inspection after producing.
5. Toonney [stamping die factory](#) can accept customized order of stamping die and cold heading die.