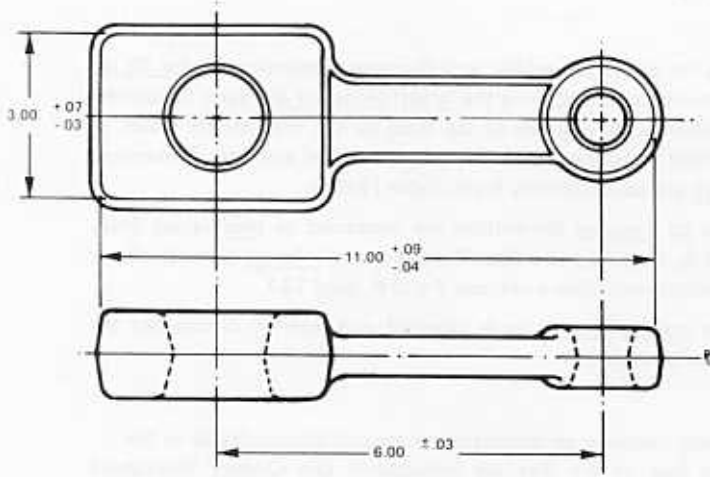


## LIMITATIONS

4. The male portions of dies may, in special situations, tend to mushroom or upset rather than wear. In such cases, the requirements of the forging should be confirmed by purchaser and producer in advance of production.

Fig. 2



LENGTH & WIDTH PLUS DIE WEAR

METRIC CONVERSION	
INCH	mm
.03	.8
.04	1.1
.07	1.8
.09	2.3
3.00	76.2
6.00	152.4
11.00	279.4

## COMPUTATION

MATERIAL: CARBON STEEL  
(DIMENSIONS UNDER 30 IN. OR 750 mm)

### EXAMPLE 1 (SEE FIGURE 2)

	Tolerance on Length Dimension	Plus	Minus
INCH	Length x Length/Width Tolerance factor	= 11 x .003 = 0.033	0.033
	Length x Die Wear Tolerance factor	= 11 x .005 = 0.055	----
	(Table 1, page 9)	+0.088	-0.033
	Raised to the next highest .01 in.	+ .09	-.04
METRIC	Length (mm) x Length/Width Tolerance factor	= 279.4 x .003 = 0.839	0.839
	Length (mm) x Die Wear Tolerance factor	= 279.4 x .005 = 1.397	----
	(Table 1, page 9)	+2.236	-0.839
	Raised to the next highest .1 mm	+2.3	-0.9*

\*Variance due to rounding