



COMPANY:	Tier 1 Automotive Stamper – Midwest, USA
OBJECTIVE:	Improve Die Life / Reduce Lube Usage / Reduce Costs
COMPONENT:	Automotive Door Hinge
OPERATION:	Progressive Stamping Die – 10+ Stations
MATERIAL:	3/16” High Strength Low Alloy – 70Rb
APPLICATION METHOD:	Airless Spray System – On Entry – Reapply in Tooling
POST PROCESSING:	Cleaning – E-Coat
PREVIOUS LUBRICANT:	<ul style="list-style-type: none">○ Highly Chlorinated Water Soluble Oil○ Working Ratio 5:1○ Rusty Parts In-Process○ Poor Operator Acceptance
RESULTS:	<ul style="list-style-type: none">➤ Running Ratio to 13:1 with Towerpro 7725-E➤ Improved Die Performance➤ Cut Die Lube Consumption by 60%➤ Greater Emulsion Stability of Mixed Die Lube➤ Good In-Process Rust Protection➤ Cleaner Press and Shop Areas➤ Superior Operator Acceptance