DESIGN OF DIES FOR BASE CUP LAMP TYPE E-27
(FORMING PROCESS)

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Abstract

At this time, many manufacturing industries that compete in producing quality products in order to win the market, The in this role is very large machines in the business. To produce a product base cup lamp type E-27 for instance can be done with some kind of production process, but in the process industry frequently encountered lack of a technical nature, For that in this final project we are planning a machine dies for a Cup Base E-27 type lamp

After calculation and analyse done, that to form workpiece with tne subsance mild steel 0.25 mm thickness, used dies with the compound dies type and process blanking, deep drawing, redrawing and pierching processes.

From this planning is got the number of forming force is 736.549 kgf (for first process ), 148.97 Kgf (for second process), 110.128 Kgf (for third process),clearence to shearing process equal to 0,0024 mm/sisi and 0,3 mm/sis for deep drawing. Die thickness is 54 mm, stripper thickness 21.20mm, and maximal long of punch is 80 mm.

Key words : press tool, compound dies, total force