

Spotting of the Draw Die

Spotting of the draw die is initially done during the tool build process. Before spotting can commence, the punch needs to be mastered or finalized, meaning that all radii must be verified to be the correct size and shape, and all working surfaces have to be checked and polished. The opposite die surface is then cleaned up, and both halves are loaded into the press to be spotted (using the method mentioned in Section 1.0).

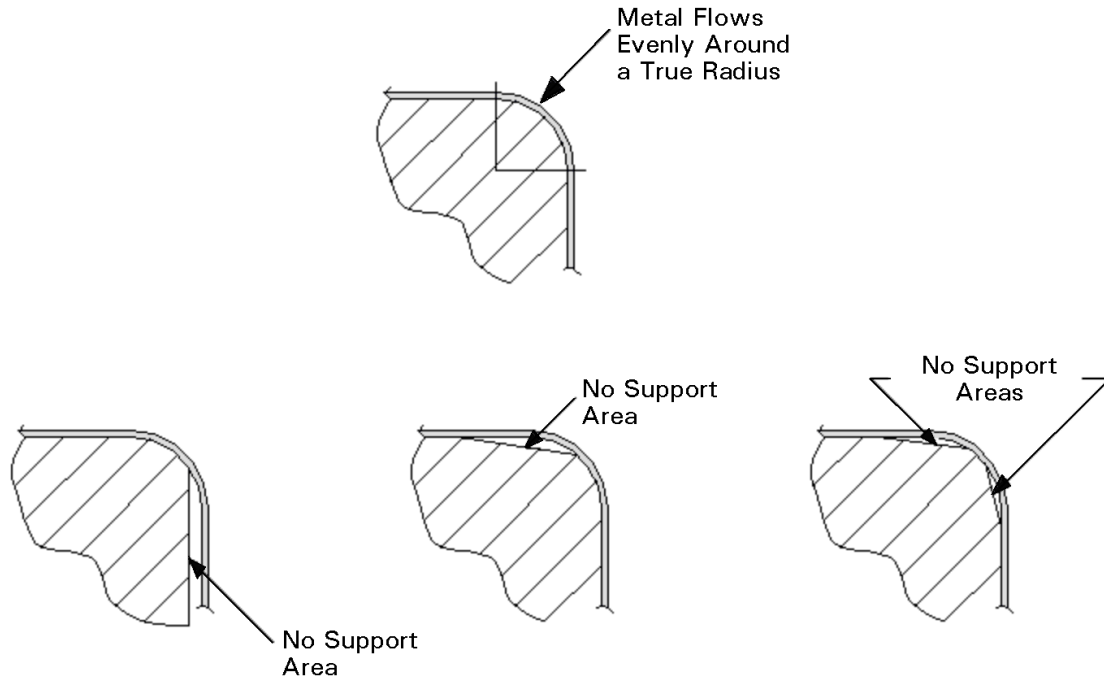


Figure 2-6. Verification of a Radius

Unsupported areas on the panel due to an uneven radius will result in galling, excessive thin-out and surface coating concerns.

During the spotting of the draw die, it is important to ensure the following:

- ▶ The upper die and post are relieved, where possible, to reduce the potential of damage to an exposed panel.

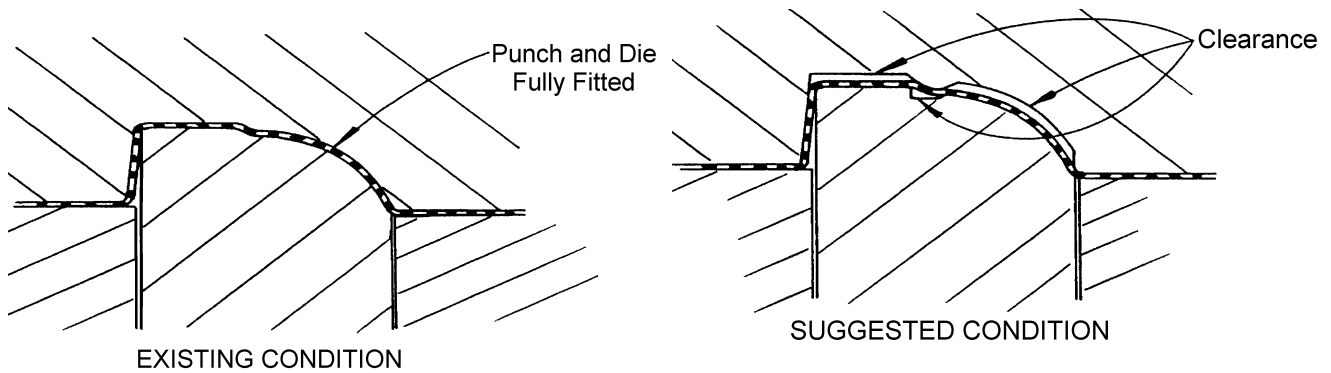


Figure 2-7. An Example of Unnecessary Contact

- ▶ The potential for sidewall bearing is eliminated. Sidewall bearing refers to the amount of contact between the upper die and the post on a sidewall. Sidewall bearing should be avoided to improve formability and to ensure unnecessary tonnage requirements are not added to an operation.

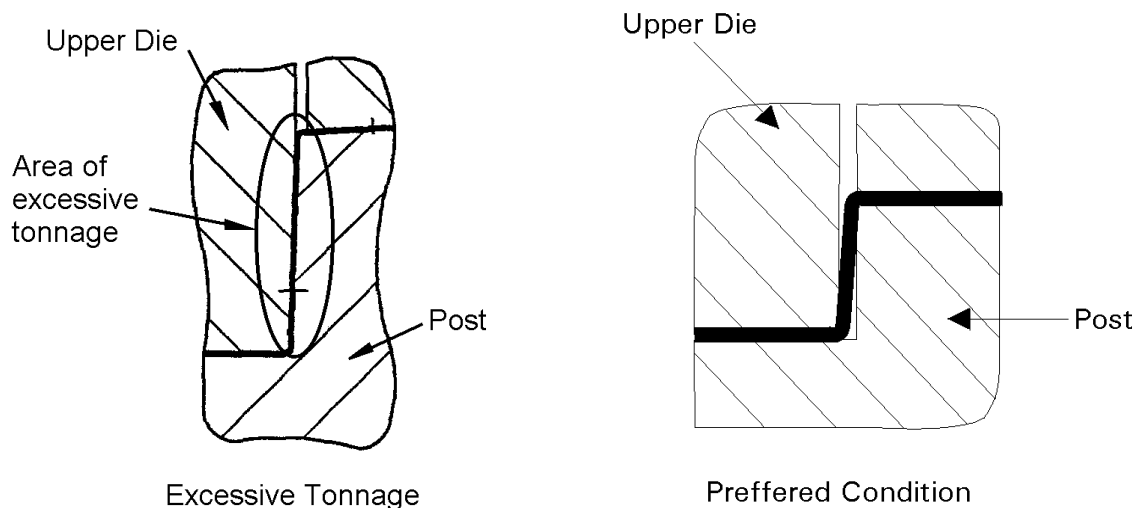


Figure 2-8. An Example of Sidewall Bearing