Proven solutions for Forging Tooling life

IBC Coatings Technologies offers lab tested, field proven solutions for extending the life of your Forging tooling. Our Ceratough® Coatings have demonstrated performance that meets or exceeds competitor’s coatings.

DHSN- IBC Coatings’ Salt Bath Nitriding has an enhanced white layer that improves lubricant retention and has been shown to increase punch life by 50% versus other nitriding processes.

**Punches:** DHSN extends punch life.

**Hammer Dies:** DHSN is the preferred choice for extended die surface life when shank welding is less critical.

**Hammer Dies:** DHIN is preferred in dies where shank welding is expected.

<table>
<thead>
<tr>
<th>Name</th>
<th>Process Temperature (°C)</th>
<th>Thermal Stability (°C)</th>
<th>Thickness (microns)</th>
<th>Hardness (HV)</th>
<th>Friction Coefficient Dry (on Steel)</th>
</tr>
</thead>
<tbody>
<tr>
<td>DHIN</td>
<td>Ion Plasma Nitriding per AMS-2759/8</td>
<td>400-550</td>
<td>400-500</td>
<td>25-300</td>
<td>500-1200</td>
</tr>
<tr>
<td>DHSN</td>
<td>Salt Bath Nitriding For Forging Dies</td>
<td>550</td>
<td>400-500</td>
<td>25-250</td>
<td>500-1200</td>
</tr>
</tbody>
</table>

Forging Punch

Hammer Die

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