

FIGURE 3. EFFECT OF EXTRUSION RATIO ON PRESSURE FOR COLD HYDROSTATIC EXTRUSION OF AISI 4340 STEEL TUBING AND ROUNDS

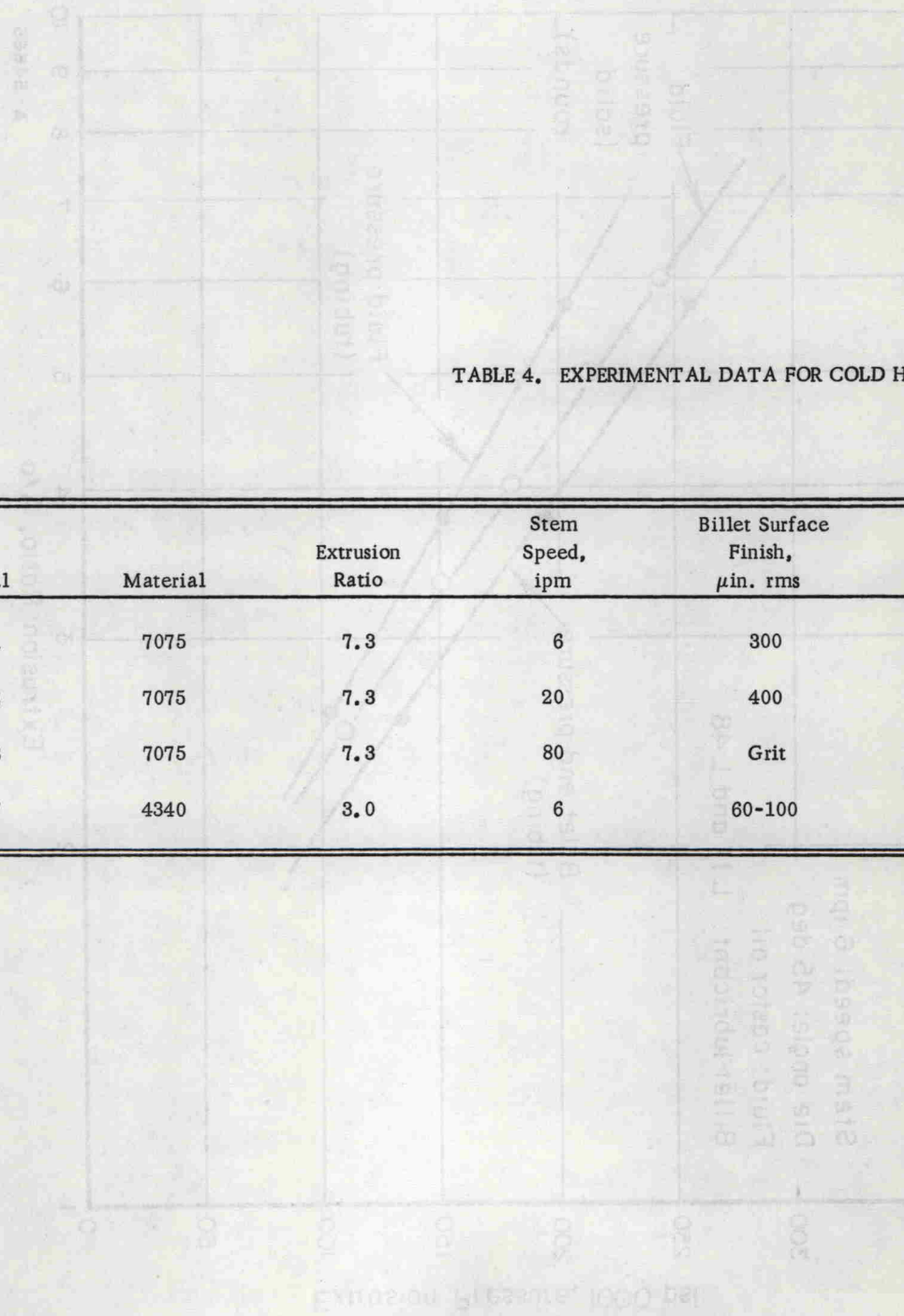


TABLE 4. EXPERIMENTAL DATA FOR COLD HYDROSTATIC

Fluid:  
Die Design:

Item	Trial	Material	Extrusion Ratio	Stem Speed, ipm	Billet Surface Finish, μin. rms	Billet Lubricant
1	381	7075	7.3	6	300	L17
2	382	7075	7.3	20	400	L17
3	383	7075	7.3	80	Grit	L17
4	387	4340	3.0	6	60-100	L48