



FIGURE 5. COMPARISON OF PRESSURES FOR HYDROSTATIC EXTRUSION OF AISI 4340 STEEL ROUNDS AT TWO TEMPERATURES

TABLE 9. EXPERIMENTAL DATA FOR 500 F

Die Angle: 45 deg

Item	Trial	Extrusion Ratio	Stem Speed, ipm	Hydrostatic Fluid	Type of Stem Seal	Billet Lubricant
1	400	3.3	6	PPE	1t	L30
	402	3.3	6	PPE	1t	L30
2	395	3.3	6	PPE	1t	L33
	396	3.3	20	PPE	1t	L33
	419	4	6	PPE	2t	L33
	421	4	6	PPE	2t	L33
3	398	3.3	6	PPE	1t	L38
4	403	3.3	6	PPE	1t	L40
5	404	3.3	6	PPE	1t1r	L43
6	405	3.3	6	PPE	1t1r	L44
7	415	3.3	6	SE <sup>(b)</sup>	2t	L33
	416	4	6	SE	2t	L33

(a) 1t = one Teflon O ring; 2t = two Teflon O rings; 1t1r = one Teflon and one Buna N rubber O ring.

(b) Because SE fluid flashed at about 470 F, trials with this fluid were made at 400 F.