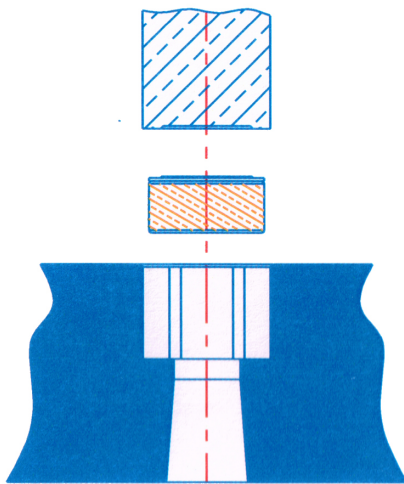




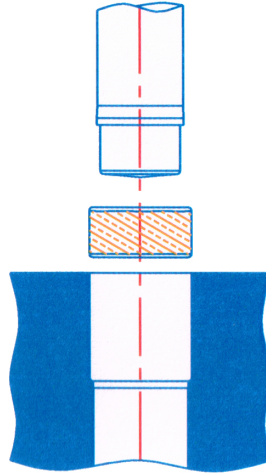
St. Clair Group

Metal Forming Industries

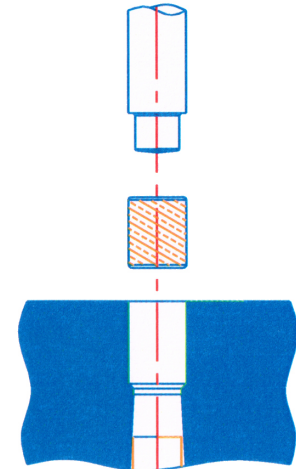
VARIOUS TYPES OF EXTRUSION



FORWARD IMPACTING FORCES THE MATERIAL TO FLOW FROM THE HEADED BILLET AHEAD OF THE PUNCH INTO THE DIE TO FORM HOLLOW OR SOLID PARTS.



REVERSE IMPACTING FORCES THE MATERIAL OF THE LUBRICATED BILLET AGAINST THE DIRECTION OF THE PUNCH BETWEEN THE PUNCH AND THE DIE WALL. THIS PRODUCES LOW COST CUPS.



COMBINATION IMPACTING FORCES THE MATERIAL OF THE BILLET TO FLOW BACK BETWEEN THE PUNCH AND DIE WALL AND FORWARD THROUGH THE DIE. THIS PERMITS HIGH SPEED PRODUCTION OF COMPLEX SHAPES.

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