

Conventional method

- Nut former
- Forging + Cutting



Customer challenges

【Nut former】
Fulfill the quality standard requirement.

- 【Forging + Cutting】**
- Cost saving
 - Lower the defect ratio

Cold forging progressive stamping using coiled material

Achieved **15%** cost reduction and increase in productivity. We have also secured **90%** Shear plane rate for the Cylinder shape parts!



KIYA's Technology / Advantages

- Successfully managed to **cut 15% of cost** from the conventional method of forging +cutting.
- **Able to manage difficult form variations with precision where conventional nut former had difficulty.**
- **Ⓐ 90% Shear plane rate** for the Cylinder shape parts, **Shear face roughness is below Ra0.5μm.**

Component information

Material: N22CB
 Thickness: t8.0mm
 Purpose: Clinching nuts part
 Process / Number of cavities: Progressive processing / 2 cavities