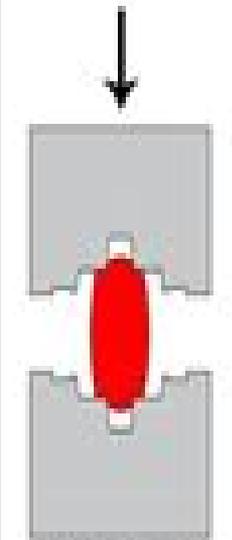


Three Methods Of Forging

Closed Die



Hot Metal Billet In Contact With Moving Die

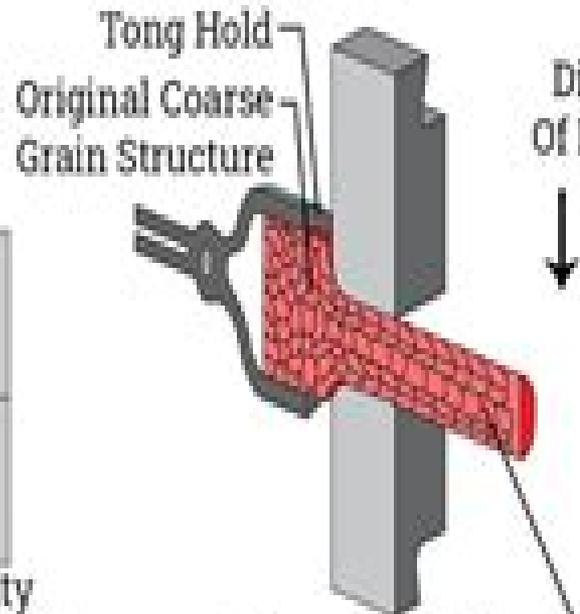


Restriction Of Lateral Flow Causing Cavity To Fill



Die Cavity Finally Filled

Open Die

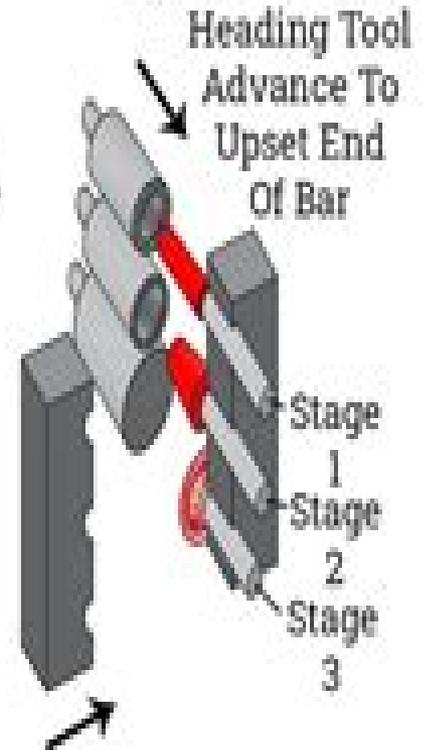


Tong Hold
Original Coarse Grain Structure

Direction Of Hammer Blow

Elongated Grains And Closer Grain Structure Improves Mechanical Properties

Upset



Heading Tool Advance To Upset End Of Bar

Stage 1
Stage 2
Stage 3

Die Closes To Grip Bar

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**Richard C. Rice, Society of Automotive
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