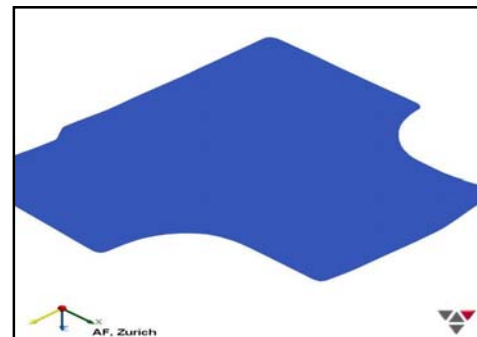
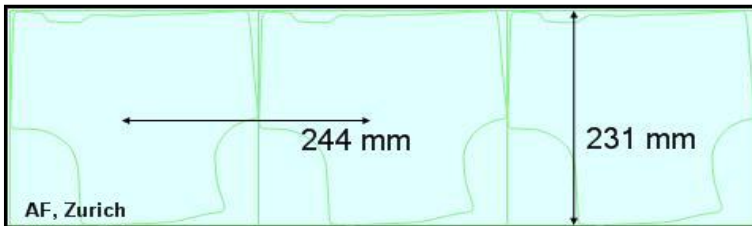
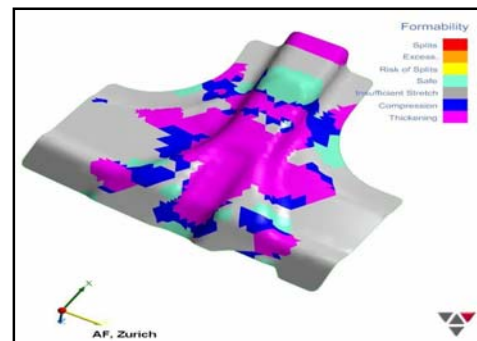
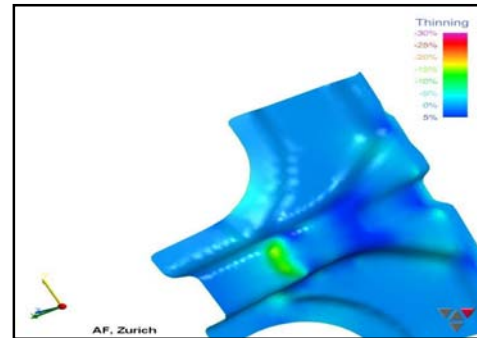


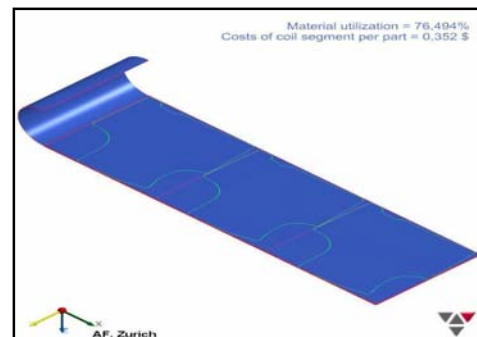
Report for AutoForm
Attn.: Stanley H.
Technopark 1
Zurich, 8005
SWITZERLAND

Friday, October 17, 2008

| | | |
|-----------------|---------------------|------------------|
| Part | Name | T-Pillar-Bracket |
| Material | Type | Mild steel |
| | Thickness | 0.80 mm |
| | Coil width | 231.00 mm |
| | Cost | 1000.00 \$/ton |
| | Scrap value | 200.00 \$/ton |
| Blank | Addendum width | 0.00 mm |
| | Perimeter | 883.99 mm |
| | Min. blanking force | 10328.71 N |
| Nesting | Edge width | 0.00 mm |
| | Bridge span | 0.00 mm |
| | Pitch | 244.00 mm |
| | Rotation angle 1 | 86.00 ° |
| | Rotation angle 2 | - |
| | Left cut angle | 0.00 ° |
| | Right cut angle | 0.00 ° |



| | | |
|--------------------|-----------------------|------------|
| Utilization | | 76.49 % |
| Production | Number of parts | 10000 |
| Weight | Part | 0.27 kg |
| | Blank | 0.27 kg |
| | Coil segment | 0.35 kg |
| | Scrap per part | 0.09 kg |
| | Total raw material | 3.52 tons |
| | Total scrap | 0.87 tons |
| Costs | Coil segment per part | 0.35 \$ |
| | Scrap value per part | 0.02 \$ |
| | Total coil cost | 3517.11 \$ |
| | Total scrap value | 173.40 \$ |



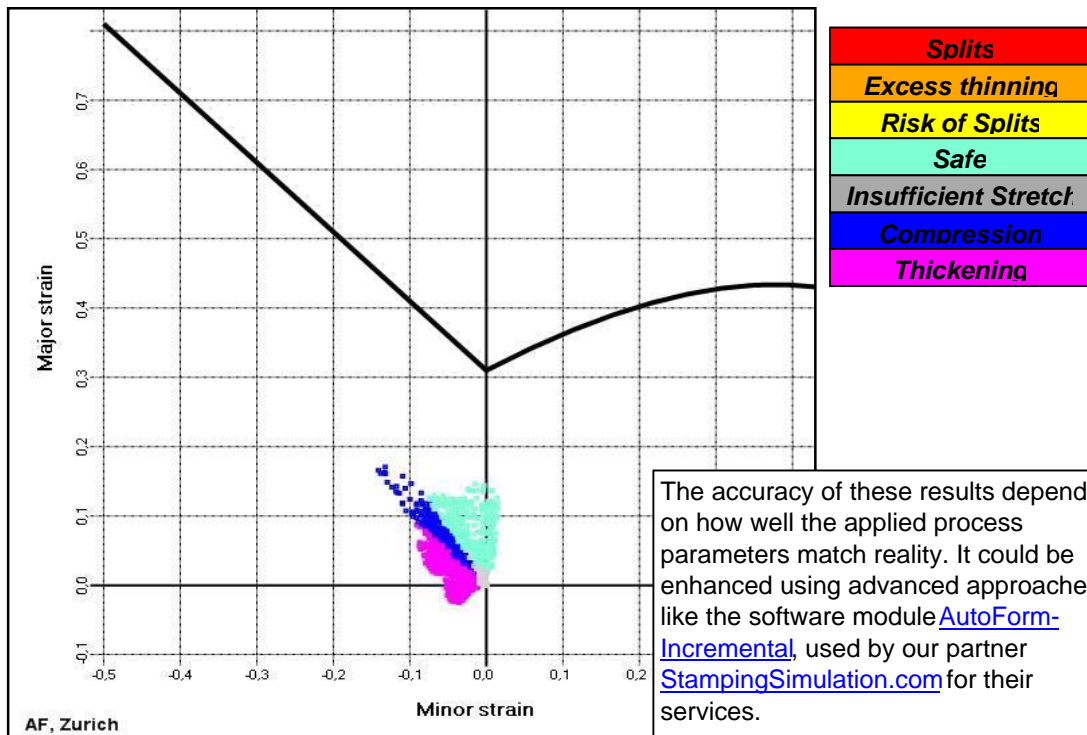
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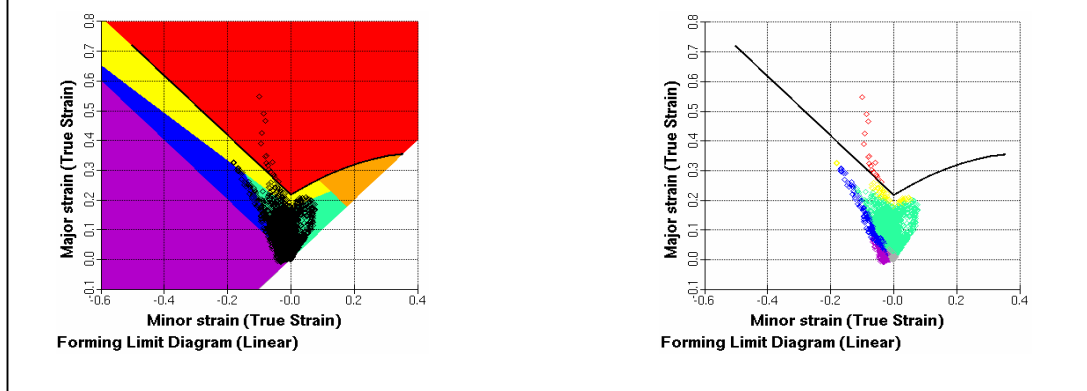
Friday, October 17, 2008

Part Name T-Pillar-Bracket

Forming Limit Diagram (Linear, True Strain)



How to interpret the FLD:
Each dot corresponds to a point on the surface. It's color indicates the formability depending on the material, thickness and process conditions. See this following example:



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