

## CONTENTS

Index of the most important symbols	1
Theme and aim of the investigations	5
Methods of Extrusion	
Problems in Direct Extrusion	
Methods of Correction	
Experimental Investigations	8
Description of the Plant	
The Extrusion Press	
Billet Heating	
Cooling System	
Experimental	
Analysis	
Hardness Measurement	
Tensile Tests	
Determination of the Load Required	
Theoretical Background	37
Flow Stress	
Heat-balance in the Billet	
Thermophysical Material Constants	
Heat Transfer between the Billet and Container	
Conduction of the Heat of Deformation into the Billet	
Surface Heating in the Die Exit	
Heat-balance in the Cooling Zone	
Experimental Results	53
Results with the Billet Profiles	
Experimental Results with Cooling	
Summary	80
Literature	83