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In the final design for HS110, the correction angle (f) is 1.673° and the die gap (d) is 0.868 mm at the optimum point, where springback is $1.432 \times 10^{-2}^\circ$. For AKDQ steel, the optimum values of f and die gap d are 0.912° and 0.909 mm, respectively, and the springback of final design is $4.77 \times 10^{-3}^\circ$.

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