

Components produced by Axial Forming:
Drive Shaft



04-1990F

Workpiece:

Material: SCM 420 V

Previous technique:

Machining

Manufacturing requirement:

Forming of an external spline on solid shaft made of stainless steel

Spline data:

- | | |
|------------------------|-------------------------|
| • Spline type: | Diametral Pitch |
| • Number of teeth: | 13 |
| • Module: | 1.5875 |
| • Pressure angle: | 30° |
| • Minor diameter: | ø 18.606 +0.025 / -0 mm |
| • Major diameter: | ø 21.679 +0.127 / -0 mm |
| • Dimension over pins: | ø 24.963 +0.064 / -0 mm |

Advantages at a glance:

- Cycle time approx. 22 s
- Highest process reliability
- High constant spline quality
- Dimension over pins adjustable by ± 0.03 mm with the same tool
- Continuous grain structure
- Excellent surface

Production rate:

Cycle time: approx. 22 sec (incl. handling)

Machine:

Model: Aximus H02
Press force: 700 kN static
400 kN recursive

Reference: Yamaha Marine

Final customer: Yamaha Marine

Required floor space with integrated cabin:
(L x W x H)
approx. 6,000 x 2,000 x 2,500 mm

Weight: approx. 9,800 kg

Required power: approx. 60 kW

