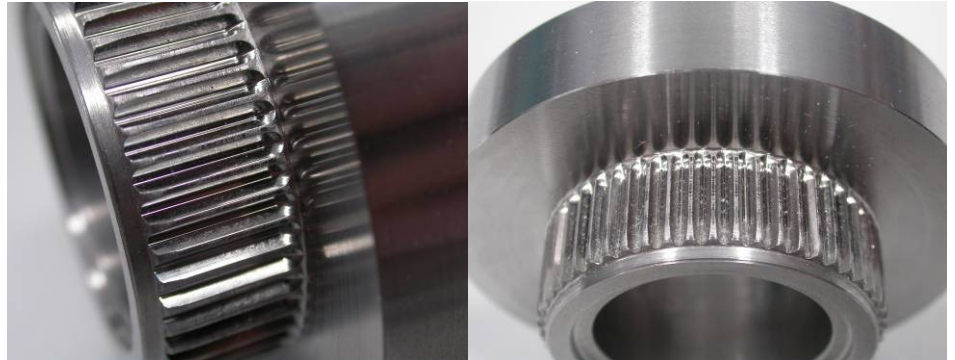


Components produced by Axial Forming:

Control gear

09-0285F



Workpiece:

Material: 16 MnCr 5

Manufacturing requirement:

Forming of a spline at a steep shoulder

Previous technique:

Gear shaping

Profile data:

- | | |
|------------------------|-------------------------|
| • Spline type: | External spline |
| • Number of teeth: | 54 |
| • Module: | 0.79 |
| • Pressure angle: | 37.3° |
| • Minor diameter: | ∅ 41.56 - 41.75 mm |
| • Major diameter: | ∅ 43.58 +0.150 / - 0 mm |
| • Dimension over pins: | ∅ 45.388 ± 0.020 mm |

Advantages at a glance:

- No recess at spline run-out required
- Cycle time 10 sec.
- Highest process reliability
- High constant spline quality
- Continuous grain structure
- Excellent surface

Production rate:

Cycle time: 10 sec.

Machine:

Model: Aximus V02

Press force: 700 kN static
400 kN recursive

Required floor space with integrated cabin:
(L x W x H)
approx. 4,200 x 1,400 x 3,600 mm

Weight: approx. 8,500 kg

Required power: approx. 55 kW

