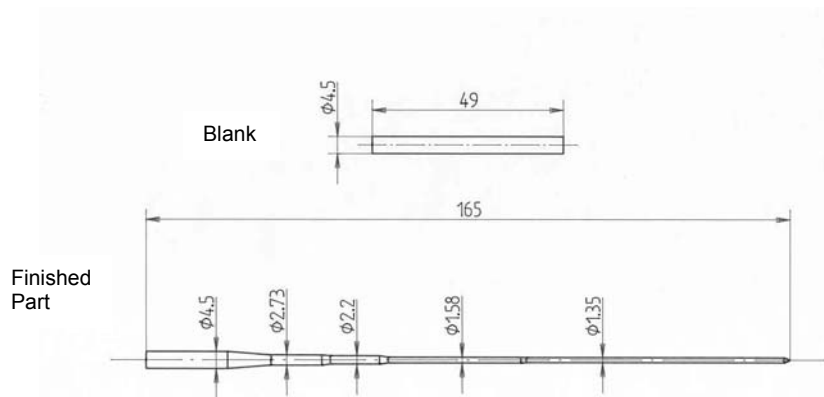


Components produced by Precision Rotary Swaging:
Eyeglass Temple



91 0960/M

Workpiece:

Material: Nickel silver
CuNi 18 Zn 20

Blank: wire section
dia. 4.5 mm and
length 49 mm

Manufacturing requirement:

Reducing blank to various diameters

Previous technique:

none

Operation sequence:

- 1.-4. Feed swaging, reducing diameters in 4 stations
5. Cutting to length and pointing

Advantages:

- Good dimensional accuracy
- Excellent surface finish
- Considerable material savings
- No chips produced
- Favourable grain structure
- Complete manufacture of part in only one machine pass
- Work hardening of material
- Further forming possible

Machine description:

Automatic transfer line consisting of:

- 1 stacking magazine
- 4 swaging stations
- 1 cutting and chipless pointing station

Production rate:

Cycle time: 6 sec.
(= 10 pieces/min.)

Machine:

Model: HA 16-A 22226X

Required floor space without sound enclosure: (L x W x H)
approx. 2800 x 1800 x 1800 mm

Weight: approx. 4,100 kg

Required power: approx. 11.5 kW