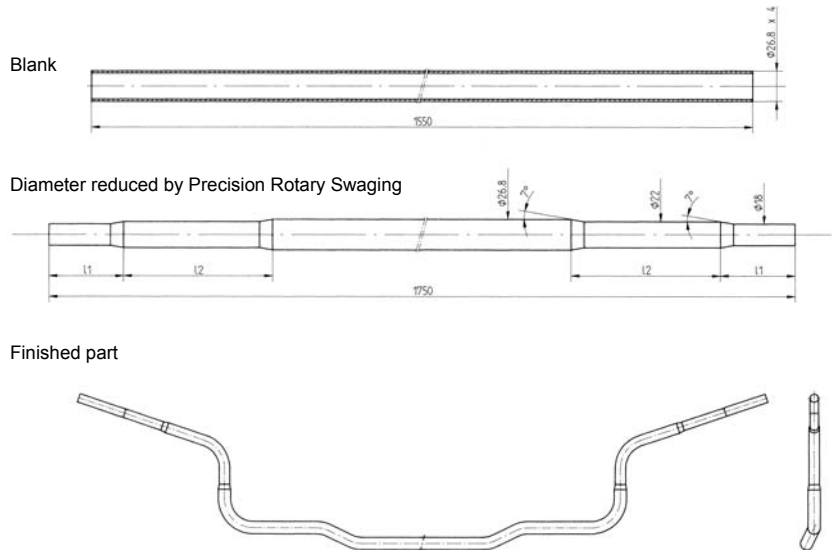


**Components produced by Precision Rotary Swaging:
Stabiliser Bar**



Workpiece:

Material: 26 Mn 5

Blank: tube section
O.D. 26.8 mm,
wall thickness 4 mm
and length 1,550 mm

Manufacturing requirement:

Complete manufacture of the workpiece in two machine passes, followed by a separate bending operation

Previous technique:

Turning from solid blanks

Operation sequence:

1. Reducing dia. 22 ±0.1 mm
2. Reducing dia. 18 ±0.1 mm
3. Facing to length

Advantages:

- Good dimensional accuracy
- Excellent surface finish
- Minimal chip production
- Favourable grain structure
- Work hardening of material
- Complete manufacture of part in only one machine pass

Machine description:

Automatic transfer line consisting of:

- 2 swaging stations
- 1 turning station

Production rate:

Cycle time: 18 sec.
(= 3 pieces/min.)

Machine:

Model: HA 40-3 V

Required floor space including sound enclosure: (L x W x H)
approx. 7700 x 5300 x 2600 mm

Weight: approx. 11,000 kg

Required power: approx. 25 kW