PRODUCT STORY

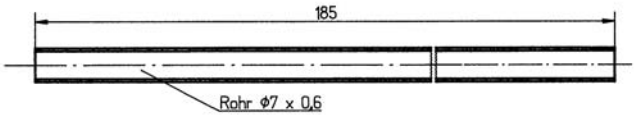
FELSS

No. 025-351 E

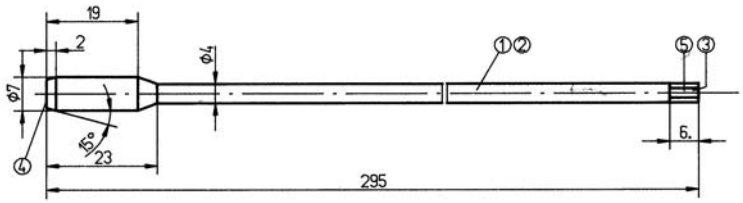
Components produced by Precision Rotary Swaging:

Injection Pipe

Blank



Finished part



91 1746/M

Workpiece:

Material: AlMgSi 0.5 F 13

Blank: tube O.D. 7 mm and wall thickness 0.6 mm

Manufacturing requirement:

Complete manufacture of part in only one machine pass

Previous technique:

none / new design

Operation sequence:

1. Pre-reduction from dia. 7 mm to 4 mm with ◁ 7°
2. Finishing reduction to dia. 4 mm with ◁ 14°
3. Sawing off to length of right workpiece side and chamfering of I.D. .
4. Sawing off to length of left workpiece side and chamfering 2 mm x 15°
5. Forming hexagon on right workpiece side

Advantages:

- Good dimensional accuracy
- Excellent surface finish
- Minimal chip production/ reduced costs for chip removal
- Favourable grain structure
- Work hardening of material
- Finishing of part in only one machine pass

Machine description:

Automatic transfer line consisting of:

2 swaging stations
2 sawing stations
1 forming station

Production rate:

Cycle time: 6 pieces/min.)

Machine:

Model: HA 16-5 V

Required floor space including sound enclosure: (L x W x H) approx. 4650 x 4150 x 2600 mm

Weight: approx. 4,900 kg

Required power: approx. 12 kW

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