

Components produced by Precision Rotary Swaging:  
**Seat Adjustment Tube**



89 1487/M

**Workpiece:**

Material: St 37 (standard steel with low carbon content)

Blank: tube O.D. 11 mm and wall thickness 1.5 mm. Expanded at both ends to dia. 12 mm.

**Manufacturing requirement:**

Complete manufacture of workpiece in two machine passes.

**Previous technique:**

none / new design

**Operation sequence:**

First pass:

1. Forming the cylindrical shape of first end by recess swaging. The workpiece is then turned round.
2. Forming the cylindrical shape of the other end by recess swaging.

Second pass:

3. Forming the square shape of first end by recess swaging.
4. Forming the square shape of the other end by recess swaging.

**Advantages:**

- Saving in weight compared with manufacture from solid
- High level of precision
- Short cycle time
- Other profiles can be manufactured at a low expenditure (low tooling costs)

**Machine description:**

Automatic transfer line consisting of:

- 1 feed magazine
- 2 swaging stations

**Production rate:**

Cycle time: approx. 7.5 sec  
(= 8 pieces/min.)

**Machine:**

Model: HA 25-2 VUE-SK

Required floor space including sound enclosure: (L x W x H)  
approx. 5,600 x 4,500 x 2,000 mm

Weight: approx. 4,500 kg

Required power: approx. 18 kW