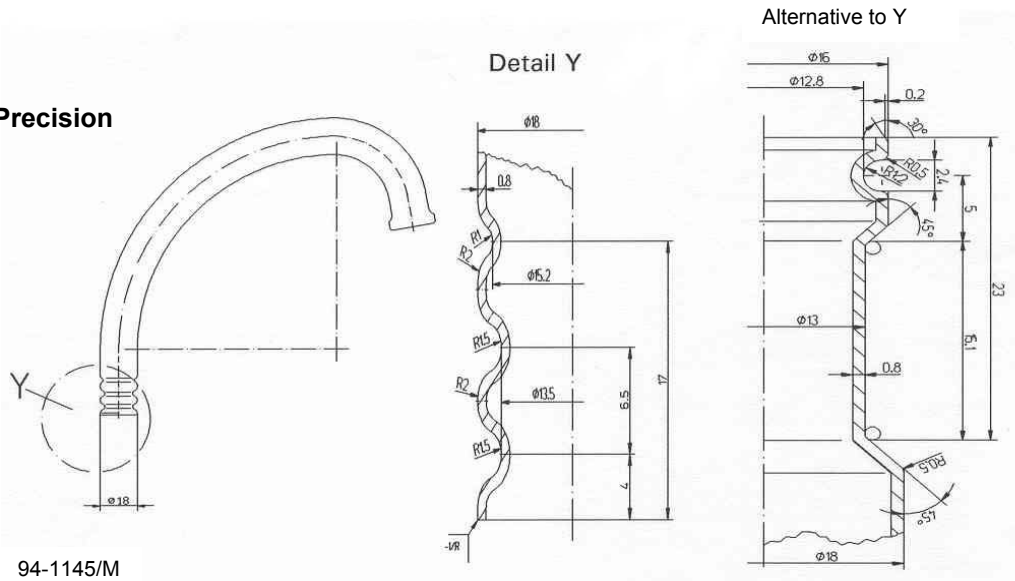


Components produced by Precision Rotary Swaging:  
**Bearing at Outlet Tube**



94-1145/M

**Workpiece:**

Material: CuZn 37 F 30

Blank: tube section, not yet bent to shape,  
 Ø 18 x 0.8 mm

**Manufacturing requirement:**

Forming of round grooves in the bearing zone

**Previous technique:**

Solder turned bearing into tube

**Operation sequence:**

1. Expanding bearing area
2. Recess swaging round grooves
3. Cutting-to-length

**Advantages:**

- Good dimensional accuracy
- Very long die life
- Minimum chip production / reduced costs for chip removal
- Part manufactured in one piece
- Favourable grain structure
- No risks of poor solder joint
- Shorter manufacturing time / reduced manufacturing costs

**Machine description:**

Automatic transfer line consisting of:

- 1 expanding station
- 1 swaging station
- 1 turning station

**Production rate:**

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

**Machine:**

Model: HA 25-2 VUE

Required floor space without sound enclosure: (L x W x H)  
 approx. 3100 x 3800 x 2600 mm

Weight: approx. 4,500 kg

Required power: approx. 10 kW