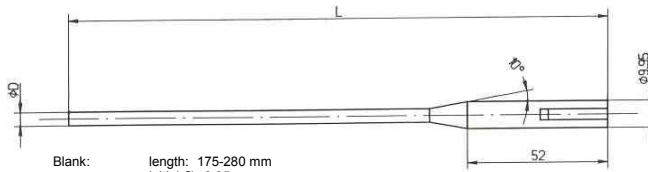
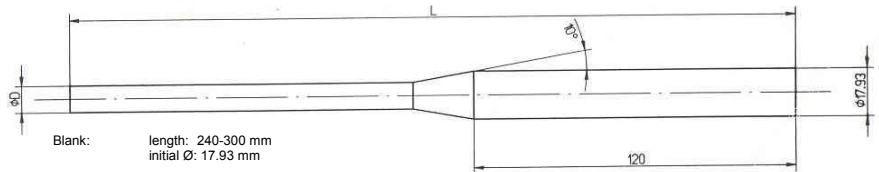


**Components produced by Precision Rotary Swaging:  
Drill Blank**



Blank: length: 175-280 mm  
initial Ø: 9.95 mm

Finished part length: 175-280 mm  
Ø: 9.95 mm



Blank: length: 240-300 mm  
initial Ø: 17.93 mm

Finished part length: 75-500 mm  
Ø: 10-13 mm

95 1896/M

**Workpiece:**

Material: 34 CrNiMo 6

Blank: Ø 9.95 or Ø 17.93 mm  
length 175-300 mm de-  
pending on the version

**Manufacturing requirement:**

Reduction of blank for subsequent  
manufacturing operation

**Previous technique:**

Turning from solid material

**Operation sequence:**

Reducing from Ø 5 mm to 13 mm  
depending on the version

**Advantages:**

- Good dimensional accuracy
- Excellent surface finish
- No chip production
- Saving in material up to 65 %
- Favourable grain structure
- Advantageous work hardening

**Machine description:**

Fully automatic Precision Rotary Swaging machine consisting of:

- 1 workpiece magazine
- 1 Rotary Swaging unit

**Production rate:**

Cycle time: approx. 12-30 sec.  
(= 2-5 pieces/min.)  
(depending on Ø and length of  
reduced section)

**Machine:**

Model: HA 40-1 V

Required floor space without  
sound enclosure: (L x W x H)  
approx. 5300 x 2500 x 2600 mm

Weight: approx. 5,500 kg

Required power: approx. 12 kW