

Components produced by Axial Forming:
CV-Joint



02-1676F

Workpiece:

Material: confidential

Previous technique:

Rolling

Manufacturing requirement:

Forming of an external spline with OPD tolerance ± 0.015 mm and tolerance class IT 5-6

Spline data:

- | | |
|------------------------|-------------------------------------|
| • Spline type: | Diametral Pitch |
| • Number of teeth: | 36 |
| • Module: | 0.75 |
| • Pressure angle: | 45° |
| • Minor diameter: | $\varnothing 25.970$ mm min |
| • Major diameter: | $\varnothing 27.450 +0.150 / -0$ mm |
| • Dimension over pins: | $\varnothing 30.556 \pm 0.020$ mm |

Advantages at a glance:

- Cycle time approx. 13-15 s
- Highest process reliability
- Tolerance class IT 5 achieved
- High constant spline quality
- Dimension over pins adjustable by ± 0.03 mm with the same tool
- Continuous grain structure
- Excellent surface

Production rate:

Cycle time: approx. 13-15 sec (incl. handling)

Reference: Visteon

Final customer: Visteon



Machine:

Model: Aximus V02

Press force: 700 kN static
400 kN recursive

Required floor space with integrated cabin:
(L x W x H)
approx. 4,200 x 1,400 x 3,600 mm

Weight: approx. 8,500 kg

Required power: approx. 55 kW