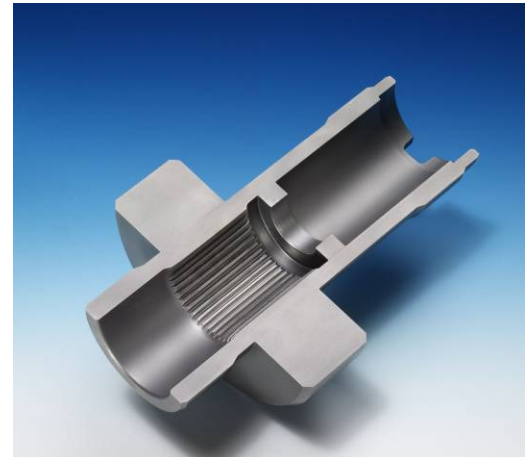


Components produced by Axial Forming:  
**Lateral Shaft**



02-2294F

**Workpiece:**

Material: 25MnCr5

**Previous technique:**

Gear shaping

**Manufacturing requirement:**

Forming of an internal spline into a blind hole

**Spline data:**

- |                        |                         |
|------------------------|-------------------------|
| • Spline type:         | Diametral Pitch         |
| • Number of teeth:     | 39                      |
| • Module:              | 0.79375                 |
| • Pressure angle:      | 30°                     |
| • Minor diameter:      | ø 30.163 ±0.040 mm      |
| • Major diameter:      | ø 32.386 +0.200 / -0 mm |
| • Dimension over pins: | ø 28.760 +0.060 / -0 mm |

**Advantages at a glance:**

- Cycle time approx. 20 s
- Highest process reliability
- High constant spline quality
- Continuous grain structure
- No chips to be removed
- Excellent surface

**Production rate:**

Cycle time: approx. 20 sec  
(incl. handling)

**Reference:** ZF

**Final customer:** ZF



**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