

Components produced by Axial Forming:
Stub Shaft



03-2313F

Workpiece:

Material: CF 53 (SAE 1050)

Previous technique:

Rolling

Manufacturing requirement:

Forming of an external spline with a high repeatability and constant high quality

Spline data:

- | | |
|------------------------|-------------------------|
| • Spline type: | Diametral Pitch |
| • Number of teeth: | 28 |
| • Module: | 0.79375 |
| • Pressure angle: | 37.5° |
| • Minor diameter: | ∅ 20.993 +0.200 / -0 mm |
| • Major diameter: | ∅ 22.620 +0.250 / -0 mm |
| • Dimension over pins: | ∅ 24.559 +0.041 / -0 mm |
| • Helix: | 0° 10' ±2.5' |

Advantages at a glance:

- Cycle time approx. 14 s
- Highest process reliability
- 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. 14 sec (incl. handling)

Machine:

Model: Aximus H02

Press force: 700 kN static
400 kN recursive

Reference: confidential

Required floor space with integrated cabin:
(L x W x H)
approx. 6,000 x 2,000 x 2,500 mm

Final customer: Delphi

Weight: approx. 9,800 kg

Required power: approx. 60 kW

