

Components produced by Axial Forming:  
**Splined flange**



04-0670F

**Workpiece:**

Material: 38 MnVS6

**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:     | 32                      |
| • Module:              | 1.058                   |
| • Pressure angle:      | 30°                     |
| • Minor diameter:      | ø 31.800 +0 / -0.200 mm |
| • Major diameter:      | ø 34.925 +0 / -0.127 mm |
| • Dimension over pins: | ø 36.875 +0.064 / -0 mm |

**Advantages at a glance:**

- Cycle time approx. 20 s
- Highest process reliability
- High constant spline quality
- Dimension over pins adjustable by  $\pm 0.03$  mm
- Continuous grain structure
- Excellent surface

**Production rate:**

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

**Reference:** confidential

**Final customer:** confidential

**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

