

Components produced by Axial Forming:
Hub-reaction carrier



05-0618F

Workpiece:

Material: 30 Cr Mo 20 Cr

Previous technique:

New application

Manufacturing requirement:

Forming of an external spline on a very thin-walled blank

Spline data:

- Spline type: involute spline
- Number of teeth: 35
- Module: 0.75
- Pressure angle: 30°
- Minor diameter: $\varnothing 24.670 +0.230 / -0$ mm
- Major diameter: $\varnothing 26.800 +0.160 / -0$ mm
- Dimension over pins: $\varnothing 28.523 +0.078 / -0$ mm

Advantages at a glance:

- Cycle time approx. 12 s
- Splining of very thin-walled parts
- Highest process reliability
- High constant spline quality
- Dimension over pins adjustable by ± 0.03 mm
- Continuous grain structure
- Excellent surface

Production rate:

Cycle time: approx. 12 sec.

Reference: Shanghai Jiao Yun

Final customer: GM

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

