

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



07-2504F

**Workpiece:**

Material: 42CrMo4

**Manufacturing requirement:**

Forming of material with a tensile strength up to 1,100 N/mm<sup>2</sup>

**Previous technique:**

machining

**Spline data:**

- Spline type: diametral pitch
- Number of teeth: 38
- Module: 1.058
- Pressure angle: 30°
- Minor diameter: ø 38.430 mm min
- Major diameter: ø 41.270 +0 / -0.130 mm
- Dimension over pins: ø 43.255 +0.057 / -0 mm
- Helix: 0° 10' (RH)

**Advantages at a glance:**

- Cycle time approx. 15 s
- Highest process reliability
- High constant spline quality
- Dimension over pins adjustable by ± 0.03 mm with the same tool
- Excellent surface
- Continuous grain structure
- No chips to be removed

**Production rate:**

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

**Reference:** confidential

**Final customer:** confidential

**Machine:**

Model: Aximus H02

Press force: 700 kN static  
400 kN recursive

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

Weight: approx. 9,800 kg

Required power: approx. 60 kW

