

Components produced by Axial Forming:
Intermediate Shaft



06-0608F

Workpiece:

Material: 34 MnB 5

Previous technique:

New application

Manufacturing requirement:

Axial forming of internal spline

Spline data:

- Number of teeth: 33
- Module: 1
- Pressure angle: 30°
- Minor diameter: $\varnothing 31.5 + 0.05$ mm
- Major diameter: $\varnothing 33.65 + 0.2$ mm
- Dimension over pins: $\varnothing 30.230 +0.02/-0.01$

Advantages at a glance:

- Cycle time approx. 20 s
- Highest process reliability
- High constant spline quality
- Continuous grain structure
- Excellent surface

Production rate:

Cycle time: approx. 20 sec.

Reference: confidential

Final customer: VW

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

