

**Components produced by Axial Forming:
Hollow Drive Shaft for Trucks**



07-3302F

Workpiece:

Material: 50 CrMo 4

Previous technique:

Percussion cold rolling

Manufacturing requirement:

Forming of 3 identical splines on one workpiece, two at one end, one at the other end

Spline data:

- Number of teeth: 38
- Module: 1.27
- Pressure angle: 30°
- Minor diameter: $\varnothing 45.800 +0 / -0.25$ mm
- Major diameter: $\varnothing 49.400 +0 / -0.3$ mm
- Dimension over pins: $\varnothing 51.495 -0.184 / -0.263$ mm

Advantages at a glance:

- Cycle time reduction from 300 s to approx. 40 s
- 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. 40 sec.
(for 3 splines)

Reference: confidential

Final customer: Volvo

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

