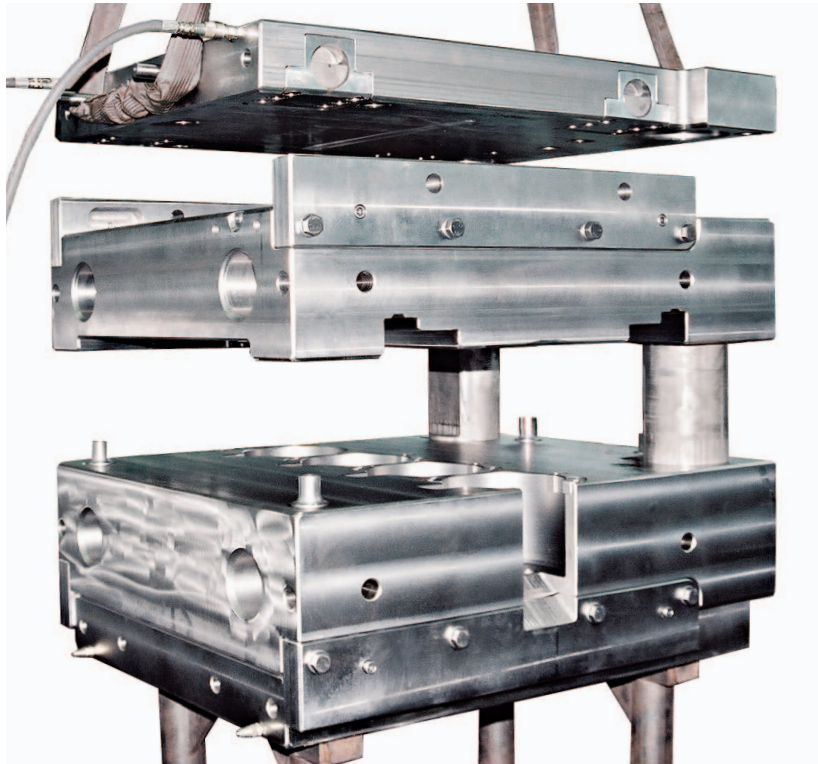


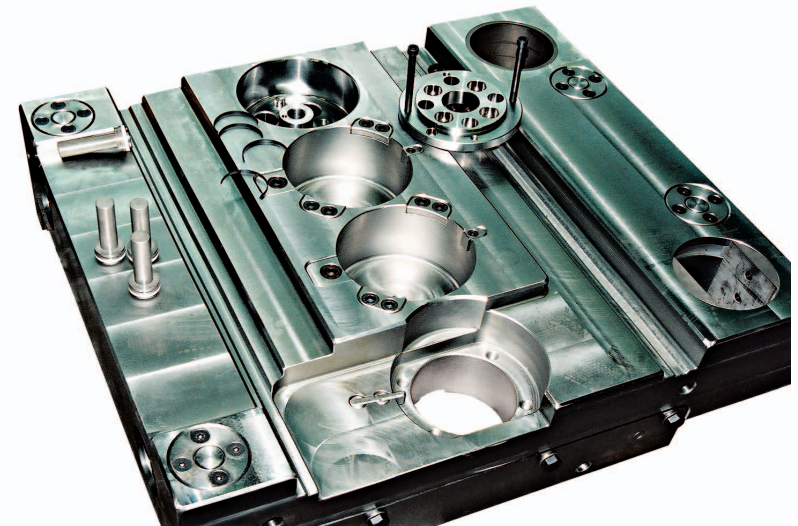
07-20 Dieholder cassette quick-change and precision forging system with cassette flat/round pillar guide and integrated punching or trimming station or combined punching/trimming station for a 20 MN drop forging eccentric press



Base holder with 4-station round forging die cassette for automatic forging with walking beam, round forging die cassette lower section clamped, upper section not clamped, base holder upper section in position "press ram at top", round forging die cassette upper section in position "press ram ¾ at top" (view from front right)

- Patented 3rd generation dieholder cassette quick-change and precision forging system with 4- and 5-station (upsetting, preforming, finish-forging, punching, trimming) round forging die cassettes and 4-station rectangular forging die cassettes for fully automatic forging with walking beam.
- Integrated punching or trimming station or combined punching/trimming station in the round forging die cassettes.

- Variation and combination options for the stations in the cassettes.
- High forging precision thanks either to forging die guides for precision forgings and forgings causing heavy transverse shear or else to a non-thermal expansion-dependent, stable, oil-lubricated, low-wear cassette flat/round pillar guide operating independently of the press guide with exchangeable, nitration-hardened steel guide elements (guide pillars, plates, bush) and in both cases a floating cassette.
- Mechanical ejectors in base holder and cassettes.
- Problem-free cassette quick changing with a forklift in a few minutes, thus maximum economic efficiency and short payback time.
- Handling of the cassette lower and upper sections each weighing 3.5 t during die tooling and servicing and cleaning work with the aid of a hydraulic/electric-motor-driven cassette handling device on the cassette change forklift.
- The full width of the die installation space of the press can be utilised thanks to the patented inside-to-outside clamping of the cassette.
- Minimal contamination of the cassette clamping equipment, of the reliable hydro-mechanical Fellner wedge-type clamping elements, thanks to complete coverage with the cassette.
- Easy to operate and very easy to clean thanks to level, smooth surfaces and the avoidance of dirt sinks.
- Easy to service and repair thanks to modular design.
- Only a few press adaptations of minimal scope are necessary.



4-station round forging die cassette upper section with guide plates, bush and removed high-temperature nitrogen gas springs of the combined punching/trimming station (view from front left bottom)