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

- Patented 3rd generation dieholder cassette quick-change and precision forging system with 4- and 5-station (upsetting, preforging, 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.