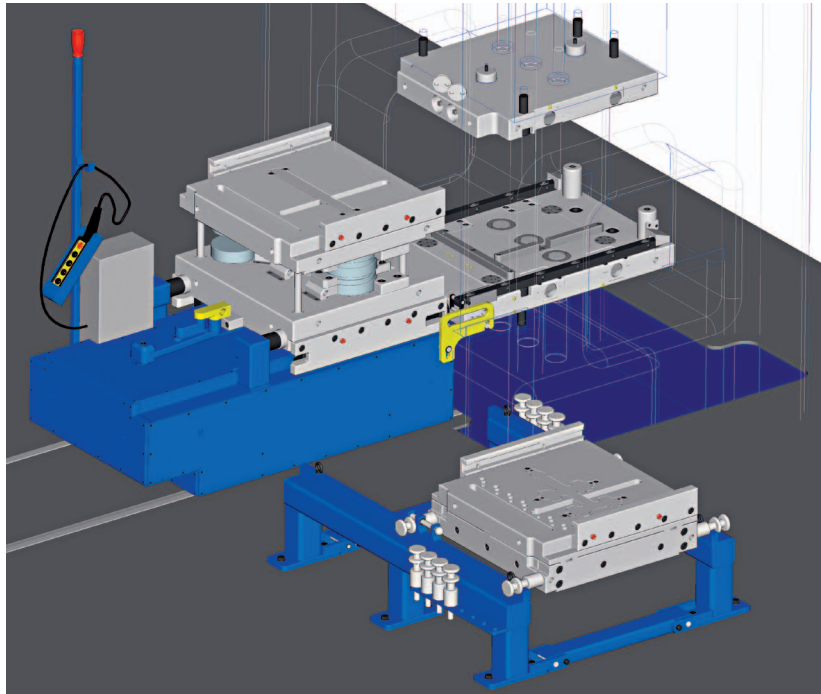


07-25 Dieholder cassette quick-change and precision forging system with forging offset correction system, cassette change carriage and cassette handling device for a 25 MN drop forging eccentric press



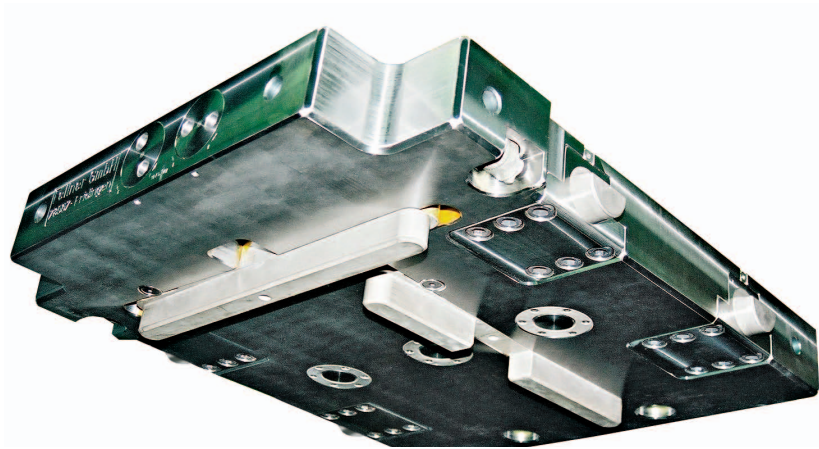
Cassette change carriage with 4-station round forging die cassette in front of the 25 MN drop forging eccentric press (press as wire model) with base holder; on the press bedplate base holder lower section with double-hydraulic cassette lifting cylinders and mobile Rollbloc roll blocks; on the press ram base holder upper section with Fellner forging offset correction system; in the foreground cassette handling device with 3-station rectangular forging die cassette upper section; press ram with base holder upper section in position "press ram at top" (view from front right top)

- Patented 3rd generation dieholder cassette quick-change and precision forging system with 3-station rectangular forging die (upsetting, preforming, finish-forging) and 3- and 4-station (upsetting, 1st preforming, 2nd preforming, finish-forging) round forging die cassettes for forging with and without forging die guides and with manual parts transfer.
- High forging precision thanks to forging die guides and the Fellner forging offset correction system.

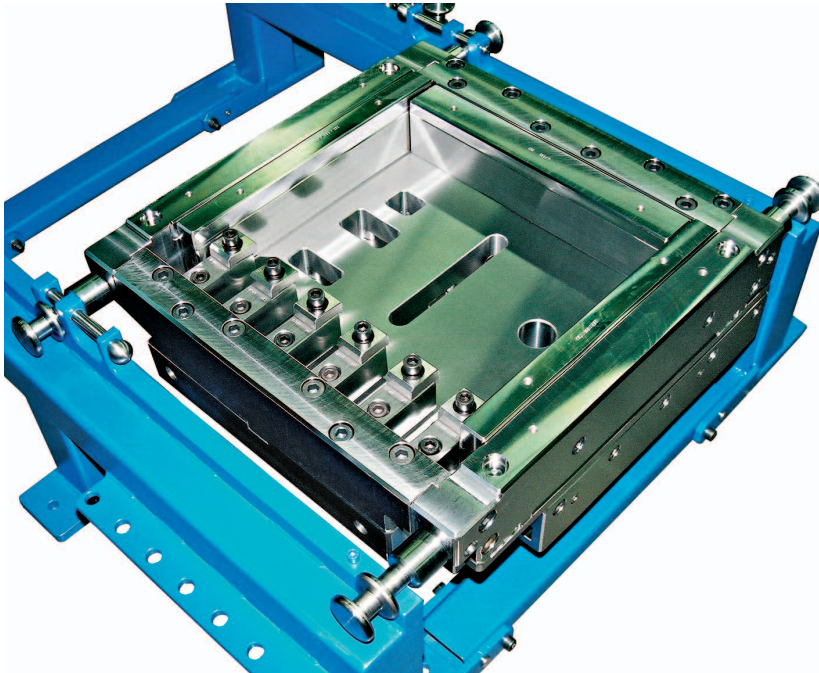
- Fellner forging offset correction system: correction of both longitudinal and lateral offset to the amount of max. ± 2 mm in each case (setting accuracy: 0.1 mm) through horizontal displacement of the cassette upper section with a base holder upper section spindle setting block centring strip mechanism and mechanical-digital position indicators with a precisely centred cassette.
- Mechanical ejectors in base holder and cassettes.
- Double-hydraulic lifting cylinders for carefully lifting the cassette off the fitting centring strips of the base holder lower section.
- Problem-free cassette quick changing with a change carriage (for description, see page 73-74) and mobile Rollbloc roll blocks 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 factory hall gantry crane and a cassette handling device (for description, see page 71-72) .
- 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, 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.



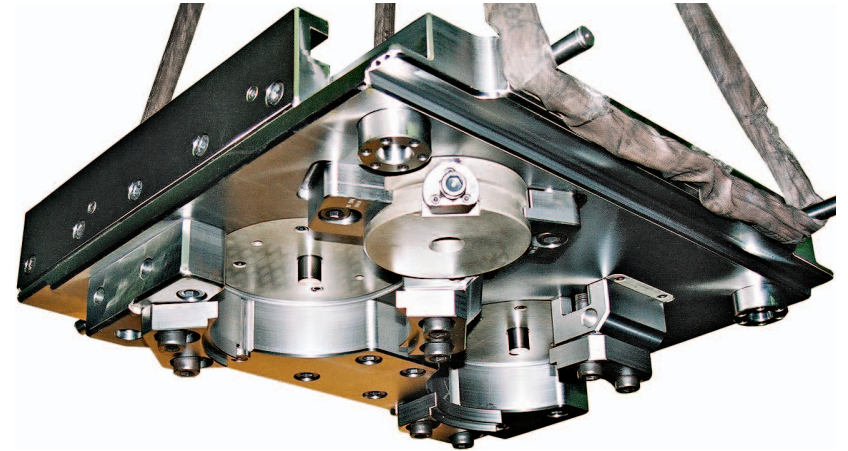
Cassette change carriage in cassette change position in front of the "press" (press bedplate dummy), ready-to-change rectangular forging die cassette on mobile Rollbloc roll blocks on the base holder lower section and coupled to the cassette coupler arm of the change carriage (view from front left top)



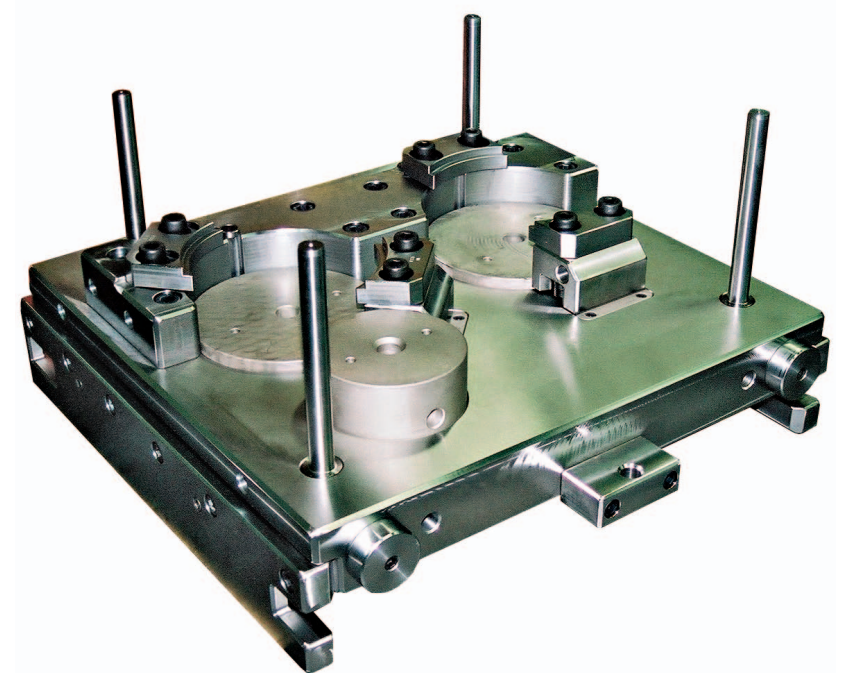
Base holder upper section with hydromechanical cassette wedge-type clamping elements, adjustable cassette centring strips of the forging offset correction system and mechanical base holder upper section ejectors removable downwards (view from front right bottom)



Cassette handling device with turned 3-station rectangular forging die cassette upper section with ejector windows and rectangular forging die adaptation parts (view from front left bottom)



3-station round forging die cassette upper section with upsetting plate quick-clamping mechanism (view from front left bottom)



3-station round forging die cassette lower section with quick-change upsetting saddle (view from front left top)