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

- Patented 3rd generation dieholder cassette quick-change and precision forging system 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).
- 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 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)

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)

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