

08-10 Dieholder cassette quick-change and precision forging system with base holder flat/round pillar guide and forging offset correction system for a 10 MN drop forging screw press



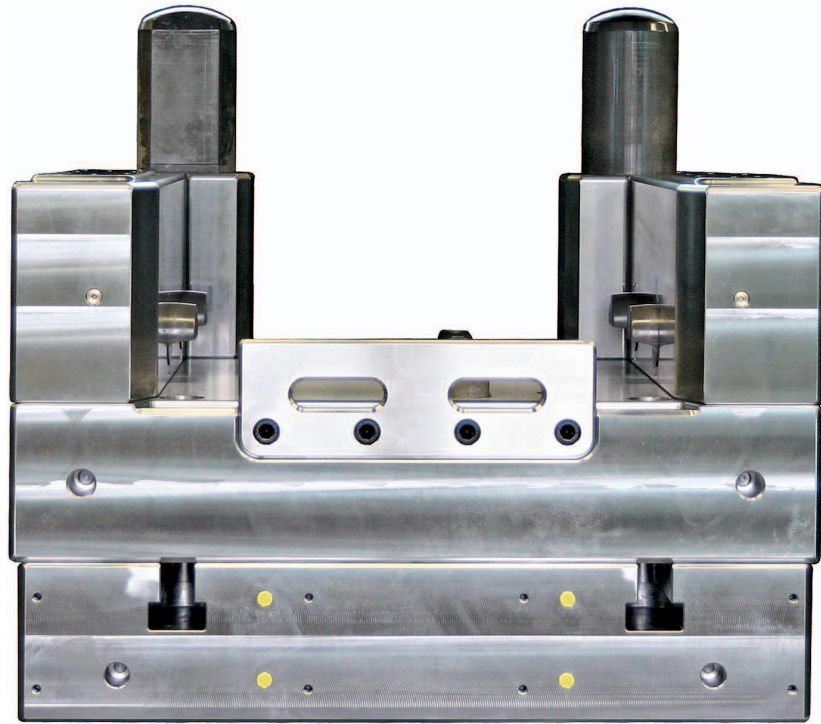
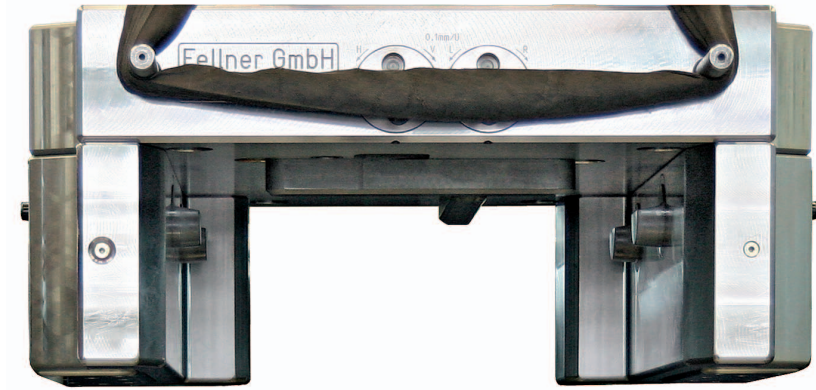
In forging use: dieholder cassette quick-change system 08-10 with 2-station dovetail forging die cassette, here equipped with one forging station

- 2nd generation dieholder cassette quick-change and precision forging system with 3-station (upsetting, preforming, finish-forging) rectangular, round and dovetail forging die cassettes for forging with and without forging die guides and with manual parts transfer.
- Double-hydraulic lifting cylinders in the intermediate plate between press bedplate and base holder lower section for carefully lifting the cassette off the fitting centring strips of the base holder lower section.
- Problem-free cassette quick changing with a forklift in a few minutes, thus maximum economic efficiency and short payback time.

- High forging precision thanks to forging die guides and a non-thermal expansion-dependent, stable, oil-lubricated, low-wear base holder flat/round pillar guide operating independently of the press guide with exchangeable, nitration-hardened steel guide elements (guide pillars, plates, bush) with a floating base holder lower section and a precisely centred cassette as well as to the Fellner forging offset correction system, with which both longitudinal and lateral offset can be corrected 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.
- Wide-area, stable base holder cushion plates for minimising press ram tilting and thus for increasing forging precision.
- Mechanical ejectors in base holder and cassettes.
- Minimal contamination of the cassette clamping equipment, of the reliable hydro-mechanical Fellner cylinder insert wedge-type clamping elements, by protected seating in locating cylinders of the cassette clamping shoulders of the base holder.
- Simple adaptability of other cassette types.
- Easy to operate and very easy to clean thanks to a base holder open to the rear, 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.



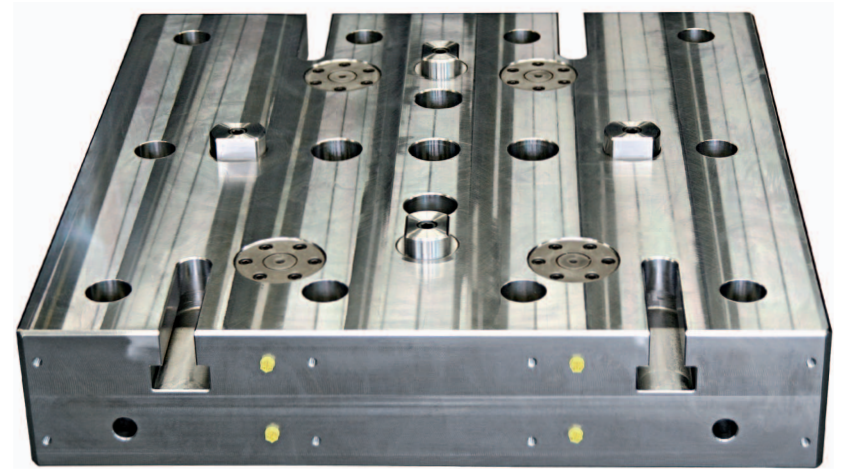
Base holder on intermediate plate and press bedplate dummy, base holder upper section in position "press ram at bottom", in front of which in each case one opened, ready-to-install, complete rectangular and round forging die cassette and two dovetail forging die cassettes (from left to right) (view from front left)



Base holder on intermediate plate, with flat/round pillar guide, hydromechanical cylinder insert wedge-type clamping elements, longitudinal and lateral centring strips of the forging offset correction system and base holder cushion plates, base holder upper section in position "press ram at top" (view from front)



Base holder with flat/round pillar guide, mechanical-digital position indicators of the forging offset correction system and installed rectangular forging die cassette, base holder upper section in position "press ram ¾ at top" (view from front right)



Intermediate plate with double-hydraulic cassette lifting cylinders and non-thermal expansion-dependent base holder lower section flat centring elements (view from front top)