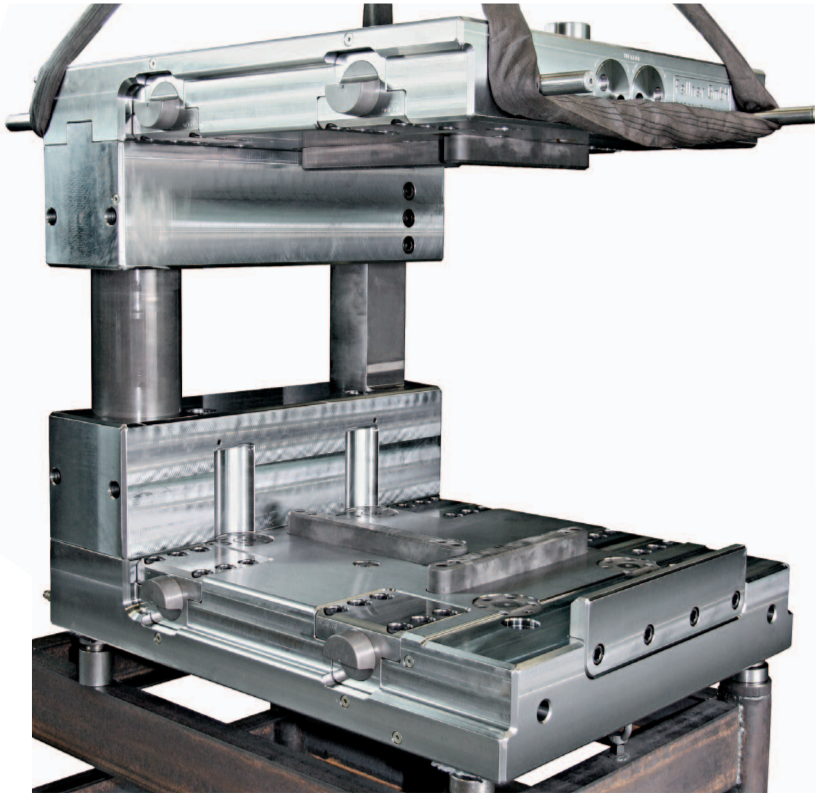
14-16 Dieholder cassette quick-change and precision forging system with base holder flat/round pillar guide and forging offset correction system for a 16 MN drop forging eccentric press

Base holder with installed, clamped rectangular / round forging die cassette on press bedplate dummy, base holder upper section in position "press ram at top" (view from front left)

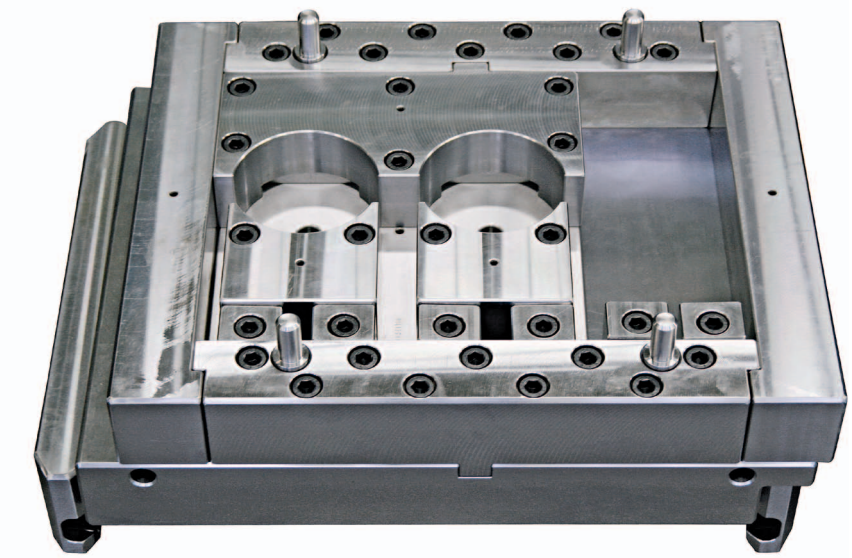
- Patented 3rd generation dieholder cassette quick-change and precision forging system with rectangular / round forging die cassettes for forging without forging die guides with up to 3 forging stations (upsetting, preforging, finish-forging) and with manual parts transfer.

- High forging precision thanks to 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.
- 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.



Base holder with flat/round pillar guide, fixed centring strips in the base holder lower section and adjustable centring strips in the base holder upper section, double-hydraulic cassette lifting cylinders in the base holder lower section and hydromechanical cassette wedge-type clamping elements in the base holder lower and upper sections (view from front left)

- Problem-free cassette quick changing with a forklift in a few minutes, thus maximum economic efficiency and short payback time.
- 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.
- Simple and quick retrofittability of rectangular forging die cassettes to round forging die cassettes with the aid of adaptation parts.
- Simple adaptability of other cassette types.
- 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.



Rectangular forging die cassette lower section with 3 forging stations (from right to left: upsetting, preforging, finish-forging) and round forging die adaptation parts (view from front top)