

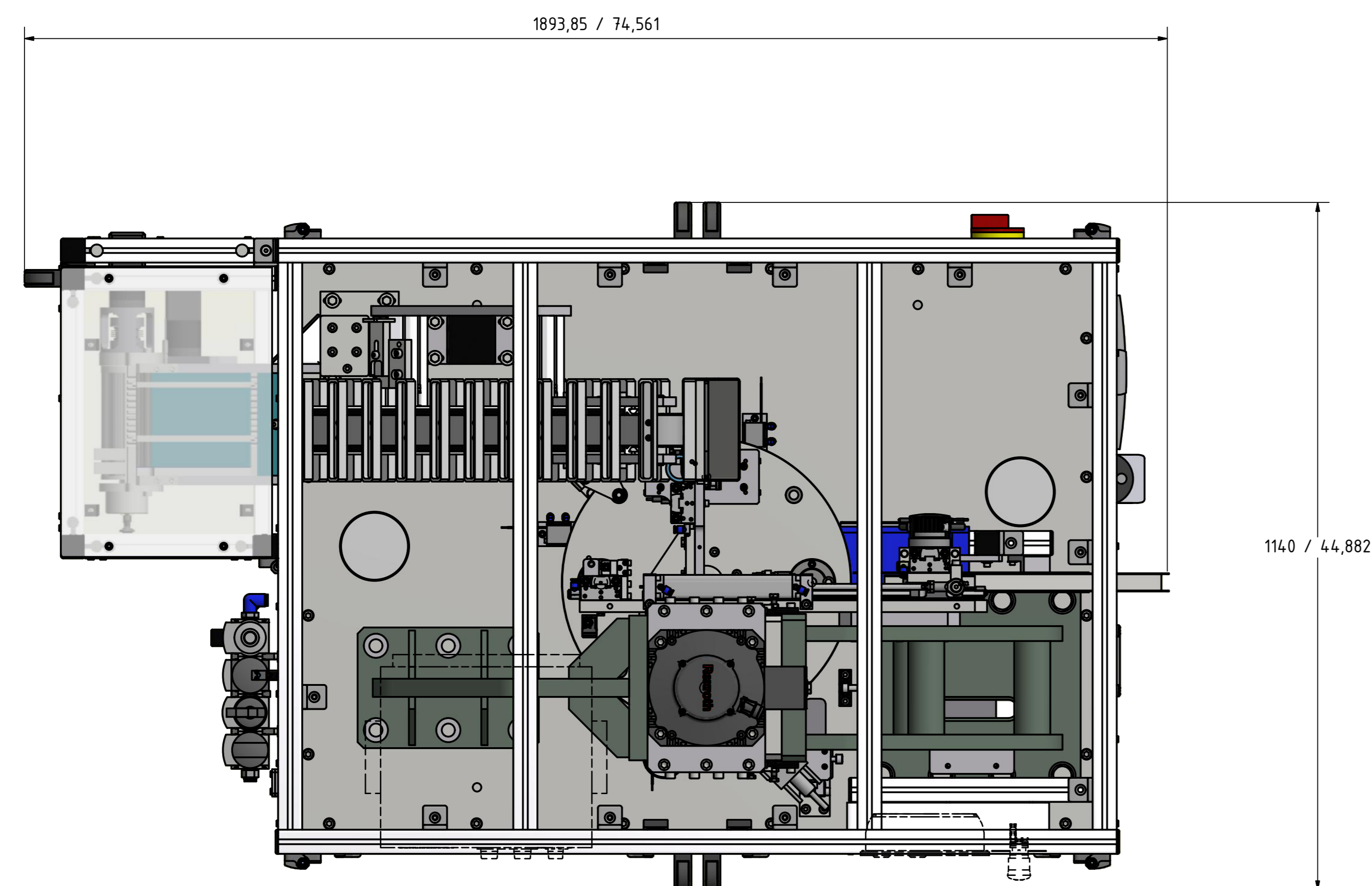
WEIGHT APPROX. 4.400 LBS

**Setup**

- Pin diameters 0.04" - 0.12" (1-3 mm)
- Pin length 1.5" - 5" (40-125 mm)
- Using servo drives means no need for hydraulic unit
- Cycle time: heating + 1 s
- Upsetting force 28.000 N
- Product length tolerance  $\pm 0.002$ " ( $\pm 0.05$  mm)
- Controlling System: Siemens S7
- Operator panel with 15" touch panel
- 90 psi dry compressed air
- average power consumption 2 kW/h

**Workflow**

- Magazine stores products for half an hour production time
- Pins are singularized by a roller in our feeding unit
- Upset allowance is defined by fixed stop
- Length measurement before heading avoids machine crash
- Heating time and target temperature value are freely programmable btw. 1470°F and 2550°F
- 360 degree circulating process with 4 stations:
  1. Feeding position
  2. Referencing and measuring position
  3. Heating and heading position
  4. Workoff position



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