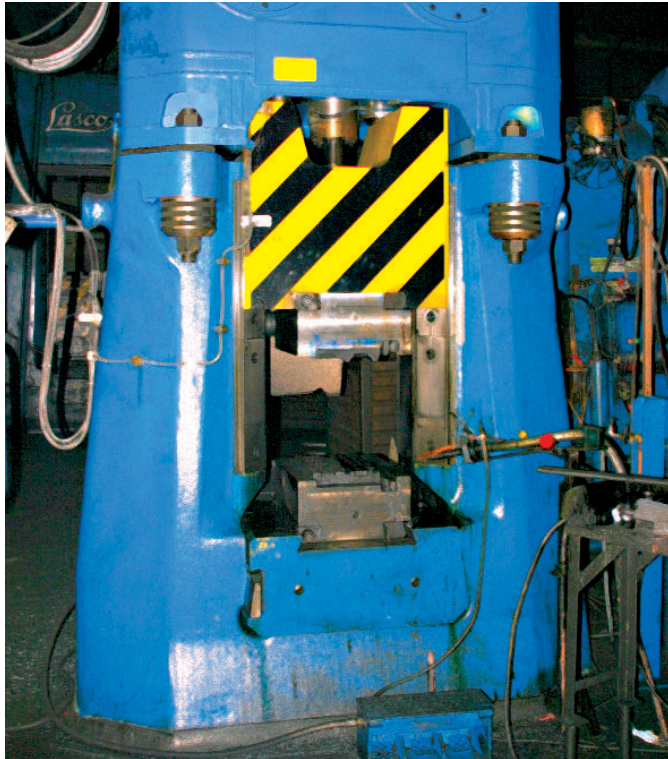


Example: Forging hammer



Hydraulic down stroking hammer

Year of construction 2007

Impact energy 25 kJ

Weight of built-in upper die approx. 350 kg

Max. permissible die weight **approx. 1200 kg**

Feuerbacher tensioning key 60.550 SB

Height 60 mm, width 94 mm, length 550 mm

Externally mounted cup spring washers

Fully supported vertical contact face

Supporting clamping screw

Thread M27

Angles 5°/15°

Application

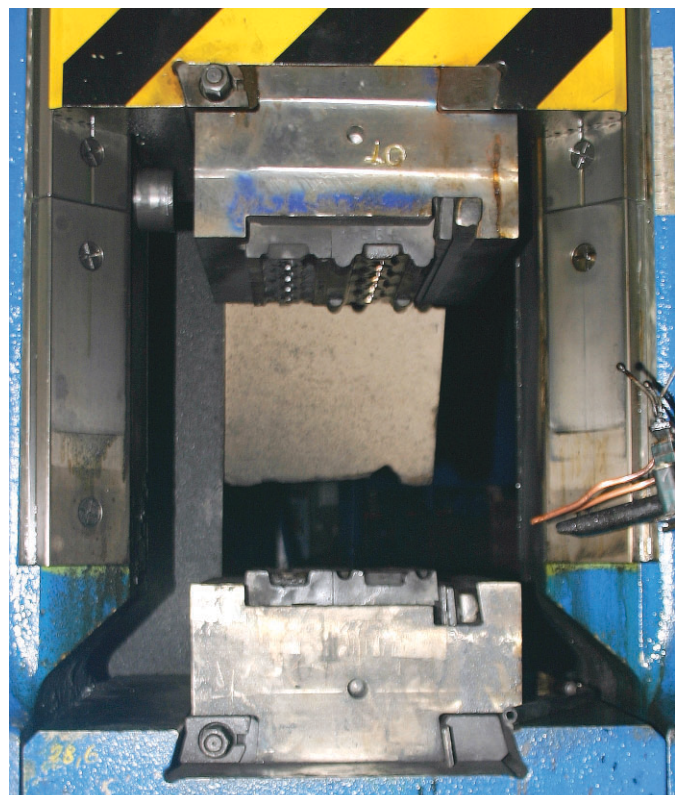
The die holder is used for single and multi-part die inserts.

The parts of the holder are each clamped by means of a **Feuerbacher tensioning key** and a shim. Both keys are provided with a block insert to prevent longitudinal displacement.

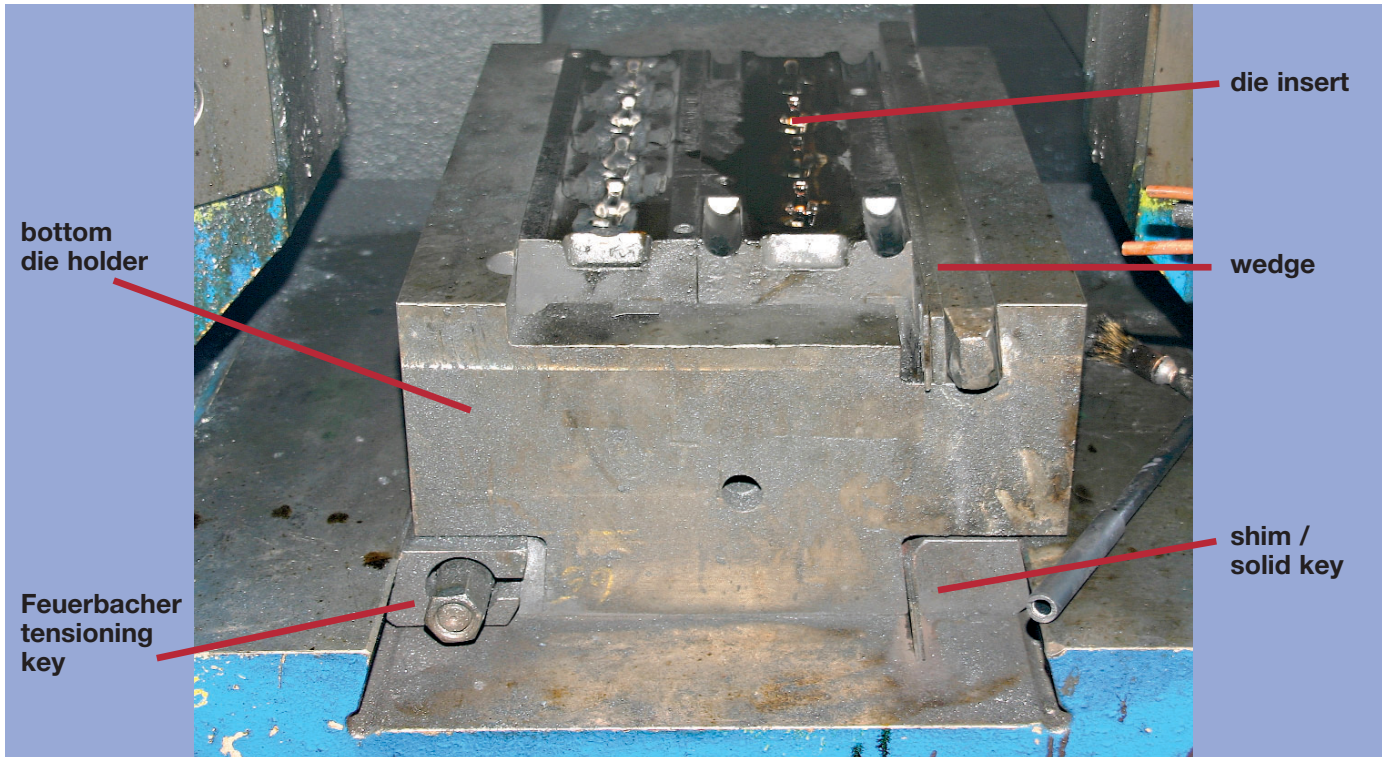
When exchanging the die **only the die inserts must be replaced**. The base holders remain in the hammer.

The offset in the die can be adjusted by using thin metal shims.

In this case the inserts themselves are clamped using conventional **wedges**.



Detail – bottom die



Alternative arrangements

As an alternative to using a shim, the holder can also, on one side, be **clamped directly against the ram** or the anvil bed.

The advantage of this possibility is the **greater contact area** of the impact faces.

Thereby the tendency for tilting is reduced considerably.

