

Example: Open die forging hammer



Open die forging hammer

Year of construction 1979

Weight of tup 3000 kg

Weight of dies approx. 1650 kg

Feuerbacher tensioning key 78.430 SB

Height 78 mm, width 93 mm, length 430 mm

Externally mounted cup spring washers

Form fit vertical contact face

Supporting clamping screw

Thread M27

Angles 5°/20°

Details of application

Die insert holder for forging on an open die forging hammer.

The die holder is clamped on the anvil bed using a Feuerbacher tensioning key.

The die inserts are clamped into the die holder using wedges.

For changeovers the arrangement allows rapid replacement of the die insert or of the complete die holder.

To counter-act the tendency for the die to tilt the angles of the clamping key are in this case **20° on the die side and 5° on the die holder side.**



Detail of clamping configuration



Alternative arrangement

As an alternative to using a wedge system for clamping the upper die holder a Feuerbacher tensioning key could be used.

To prevent collision between the Feuerbacher tensioning key and the bridge structure of the hammer the length of the Feuerbacher tensioning key used must **be such that it does not protrude beyond the side faces of the die holder.**

