THORSTEN BROER
RÜST- UND SCHMIEDETECHNIK

FEUERBACHER
SPANNKEILE DBGM

Example: Pneumatic down stroking hammer

Pneumatic down stroking hammer

Year of construction 1979
Impact energy 63 kJ
Weight of die **approx. 1650 kg**

Fixing for die holder:
Feuerbacher tensioning key 60.500 SB
Externally mounted cup springs
Fully supporting vertical contact face
Supporting clamping screw
Thread M27
Angels 5°/15°

Fixing for die inserts:
Feuerbacher tensioning key 55.500 SB
Thread M22
Angles 0°/15°

Details of application

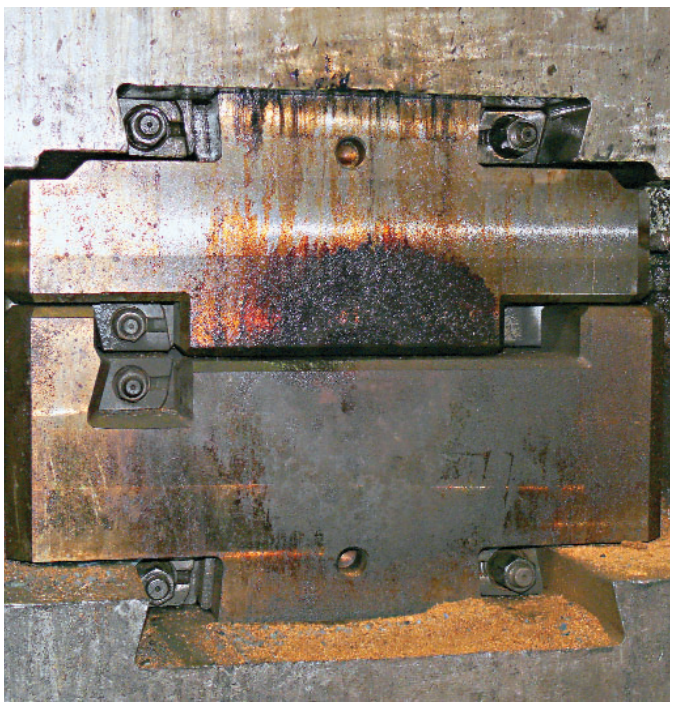
Insert holder for forging with one piece die insert (max. size 340 x 500 mm).

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

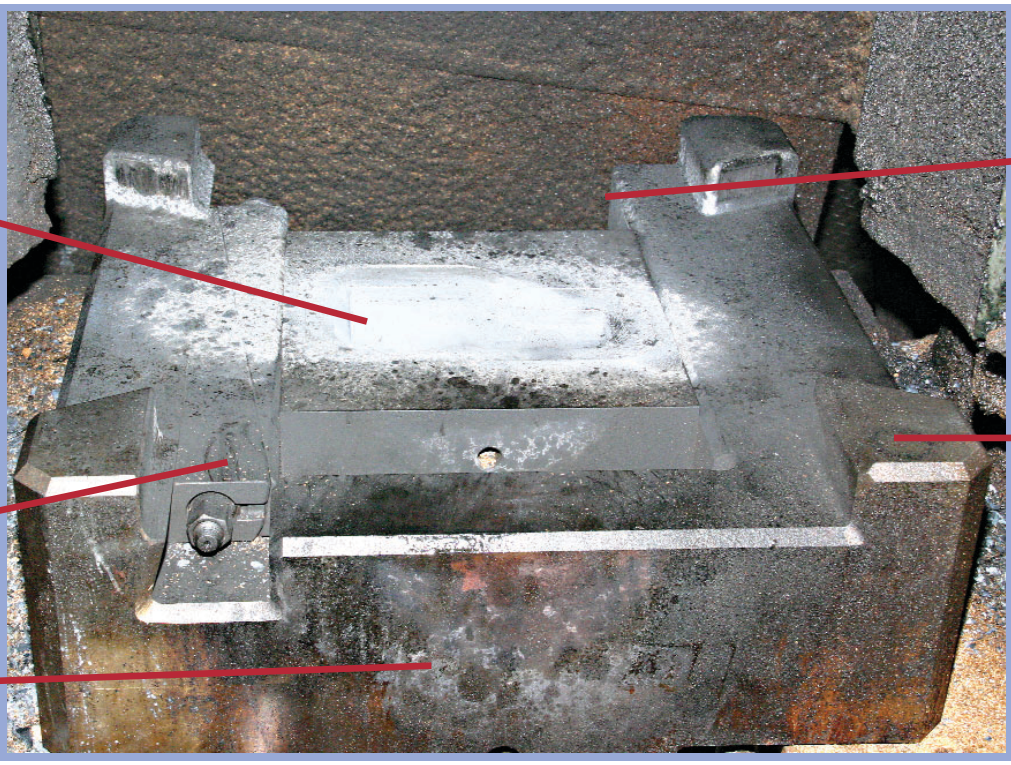
The inserts are fixed by means of two Feuerbacher tensioning keys.

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

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



General



Alternative arrangement

As an alternative to the use of a second key, on one side die holders of modified design can be located directly against the recess on one side of the tup and anvil.

This resists any forces that would attempt to cause tilting.

The die insert can be designed to be accurately located in the die holder so that sliding blocks for adjustment in this area are not required.