

PRESS-FORGING FACILITIES

Automated forging complexes



The technical capacity of press-forging facilities enables to produce forgings with weight from 0,2 up to 110 t by using forging ingots weighing from 1,6 up to 170 t, out of carbon, structural, tool and high-alloyed steel grades.

Open die forging process is realized with automated forging complexes in technological interconnection with heating, heat-treating and handling equipment under control of automated process control systems (APCS).

Automated forging complexes	Hydraulic press capacity, MN	Forging manipulator capacity, t	Ingot weighing range, t	
			min	max
1 AKK10000/120	100	120	30	170
2 AKK5000/70	50	70	30	71
3 AKK3000/30	30	30	6	30

Heating furnace



Dimensions of furnace space, m	3,9 x 6,4
Charging maximum weight, t	200
Range of operating temperatures, °C	400...1250
Temperature non-uniformity of furnace operating space, °C	± 10
Burners	Impulse burners Kromschroder Germany
Lining	Ceramic fiber



Forgings

Forgings are produced for machines of own production, as also for other manufacturers of special equipment including hydrotechnic, power-generating, rolling-mill, metallurgical, ship-building, automotive and aircraft equipment production.

Main parameters of standard forgings being produced

Type	Shafts	Rolls	Shafts with flange	Cylinders with hole	Sleeves	Rings	Disks. Disks with hole	Plates	Blocks	Crankshafts
Overall dimension, m	D _{max} =0,3...1,6 L=2,5...22	D _{max} =0,1...2,2 L=1...22	D _{max} < 2 L=1...3	D=0,45...2 L=0,6...9 d > 0,23	D=0,8...2 L=1,5...5 D-d > 0,2	D=0,5...4,8 H=0,45...1,5 D-d > 0,1	D=0,5...3 H=0,12...1,4 d=0,08...0,85	L=1,5...7 B=0,8...3,5 H=0,2...1,5	L=0,25...1,8 B=0,25...1,6 H=0,25...1,5	L=2,5...22 A, B, H=0,3...1,6
Weight, t	5,2...105	5...105	5...25	0,2...105	3,2...65	3,2...65	0,2...85	3,2...110	0,4...40	3...105