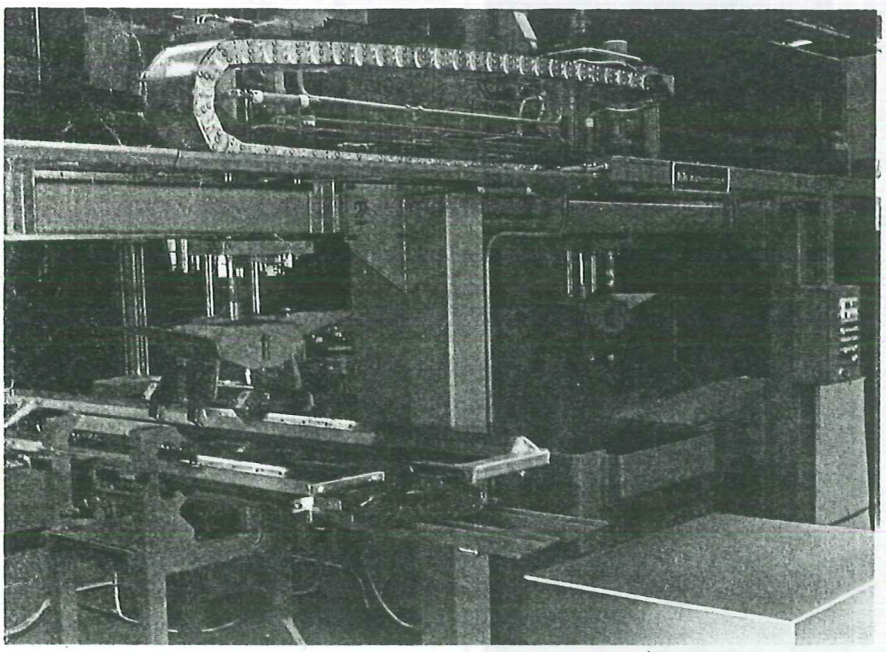
Hydraulic Quenching Presses, Models AH 400 and AH 650

Quenching presses operate to the forced flooding method. They are intented primarily for hardening spur gears and bevel gears. After having been heated to the required hardening temperature, gears are quenched between appropriately profiled dies which remain under hydraulic pressure during the quenching process and direct the flow of quenching oil around the gears. The upper die with centering ram is provided with an inner and an outer compression ring onto which different pressures are exerted. On these machines, workpieces are not only cooled at a very even rate, hardening distortions are also kept within very close tolerances. Different automatic quenching programmes with pre-cooling and quenching, as well as with or without warm straightening prior to quenching can be preselected to suit specific requirements. The generous, preselectable volume of quenching oil available and an efficient heat exchanger allow the machine to operate at a very high degree of efficiency. Quenching dies can be exchanged effortlessly and safely within a relatively short time.

Depending on the intended method of loading (directly onto the hardening dies or onto a loading carriage which moves out of and into the quenching station), the AH 400 can be supplied with an additional cooling trough to be arranged behind the quenching station.

The AH 650 is built exlusively for loading and unloading in front of the quenching station. This ensures effortless and quick loading and unloading — directly onto the lower die — of even the heaviest workpieces. Movement of workpieces to and from the quenching station is automatic and part of the programme. If requested, both machine types can be fitted with automatic loading equipment with which workpieces are removed from the furnace and transported to the quenching press.

Arbeitsbereiche Working Ranges		**AH 400**	**AH 650**
Größter Werkstückdurchmesser · Max. workpiece diameter	mm	400	650
Größter Abstand zwischen Aufspannfläche für Unter- und Obermatrize Max. distance between mounting surfaces of lower and upper die	mm	480	735
Größte Werkstückhöhe, ca. · Max. workpiece height, approx.	mm	150	200
Größter Hub der Obermatrize, ca. · Max. stroke of upper die, approx	mm	300	525
Pro Stunde möglicher Durchsatz an Härtegut, ca. Hardening capacity of machine, per hour, approx.	kg/h	250	500
Nettogewicht incl. Normalzubehör, ca. Net weight, incl. standard equipment, approx.	kg	4200	6400



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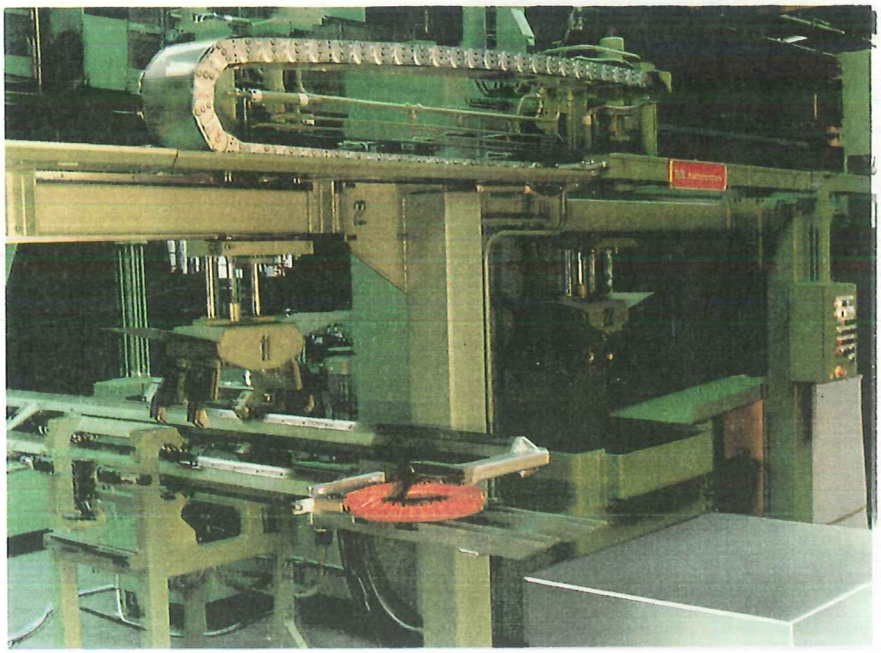

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