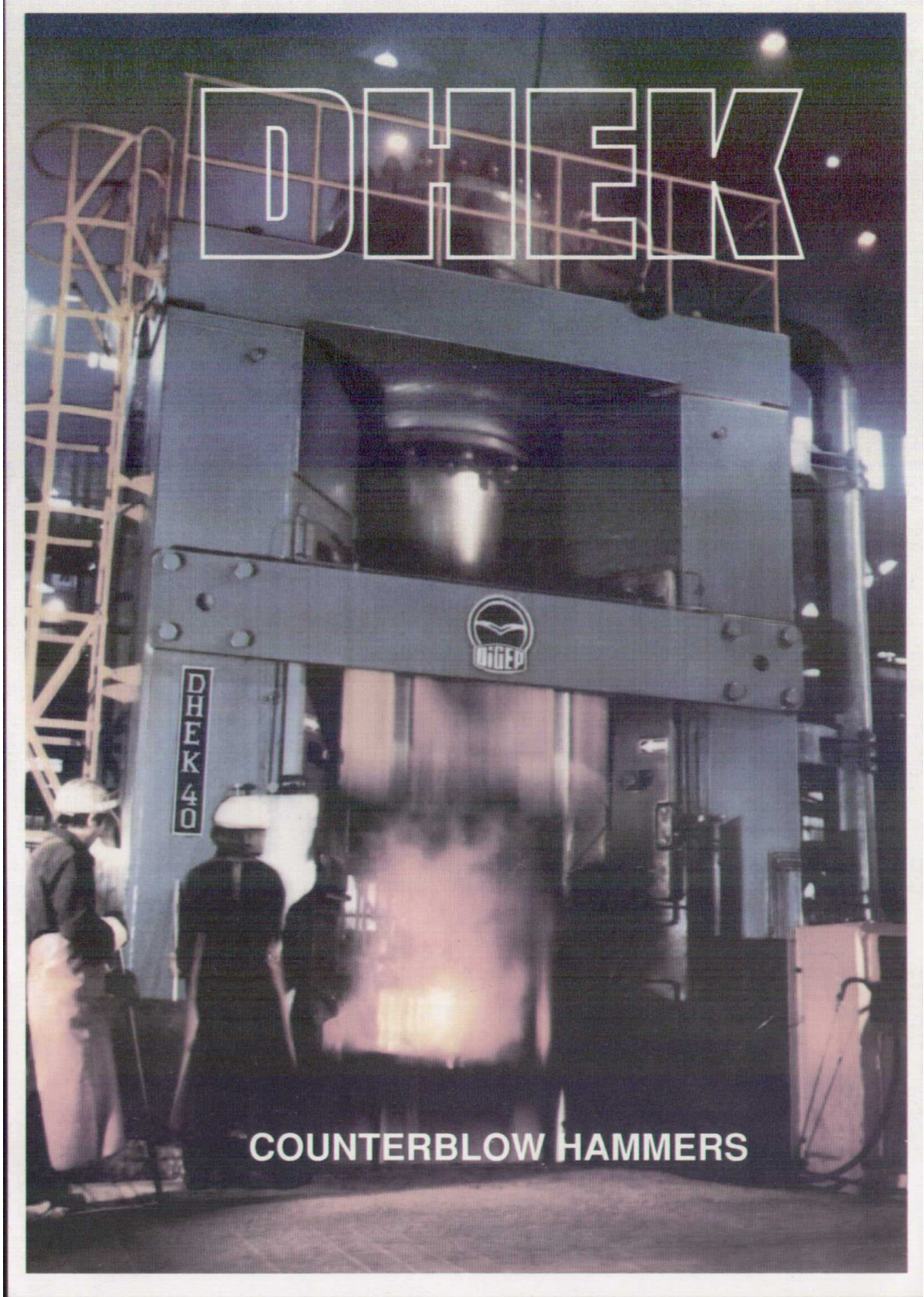


DHEK



DHEK
40

COUNTERBLOW HAMMERS



Counterblow hammers model DHEK are forming machines used in the die-forging technology. They are applied for producing – by hot forming – steel and light-metal forgings of various configurations, e.g. crankshafts, automotive front axles and rear axles, axle shafts, tube flanges etc. Forming on the hammer is made by multi-blow operation between two dies fixed into the two rams moving one against the other. The two rams moving one against the other are connected (coupled) by a hydraulic coupling – a solution reducing frequency and costs of maintenance and giving long time, reliable operation. The hammer is operated and controlled pneumatically.

The quick operation of the control system ensures

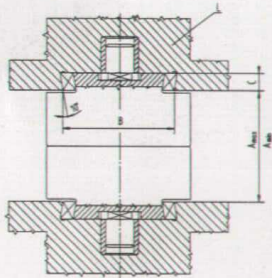
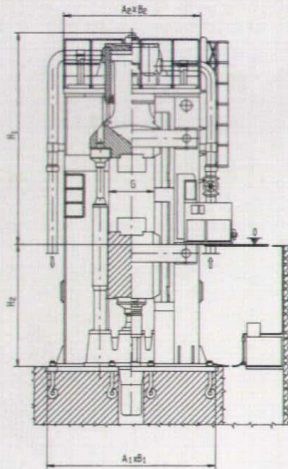
- high number of blows
- high productivity

The servo-control system installed into the hammer facilitates

- adjustment of impact energy in a wide range
- save of energy
- operation with only minimum of physical effort

Thanks to the application of counterblow principle and favourable machine frame design, vibration transmitted to surrounding is only of acceptable minimum design and, in addition, it can even be further reduced by using springs for the foundation work of the hammer.

LOCATION FOR FIXING
THE DIES INTO THE RAM



TYPE		DHEK-13A	DHEK-25A	DHEK-32A	DHEK-40A
Impact energy	(kJ)	130	250	320	400
Mass of forgings to be manufactured economically	(kg)	13-50	40-180	40-240	100-400
Practical number of blows	(1/min)	8-16	8-12	6-12	6-10
Full stroke of the rams	min. (mm)	1200	1260	1300	1500
	max. (mm)	1400	1500	1500	1800
Pressure of actuating	air (bar)	7	7	7	7
Air consumption per blow	(Nm ³ /blow)	2,6	5,0	7,0	8,8
Mass of machine abl.	(t)	85	182	238	290
Connection area	A1xB1 (mm)	3590x1920	4650x2700	4750x3100	5050x3300
Machine cross section on ground level	A2xB2 (mm)	2820x1620	3800x2150	3800x2400	4160x2510
Clearance between slides	G (mm)	870	1180	1250	1300
Height above ground level	H1 (mm)	5080	5700	6020	6630
Depth under ground level	H2 (mm)	2810	3350	3480	3600
Total height of dies	max. A (mm)	585	800	800	900
	without dovetails min. A (mm)	385	560	600	600
Die holder dimensions	width B (mm)	530	630	630	630
	length L (mm)	1200	1650	1850	2150
in the rams Die length	depth C (mm)	70	100	100	100
	min. (mm)	800	1000	1100	1300
	max. (mm)	1600	2000	2400	2500

**DÍOSGYŐRI
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