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CEMSA International

Interesting and up to date applications for electrical upsetting**Abstract**

Electrical upsetting machines are well known in India since many years.

Our machines today working in India are mainly to produce engines valves with automatic equipment including forging press too and great machines used to obtain from a steel bar pre-forms to be forged and obtain rear axles shafts (RAS).

For engines valves today it's in the average to obtain from an automatic production cell, a production of 800 pcs/h.

To have a rational use of forging press normally the upsetting machines for Rear Axle Shafts are equipped with 2 horizontal upsetting heads. The most popular arrangement for Rear Axle Shafts production, foresees 2 upsetters, one left, one right, with a screw press in between.

There are different size of machines to pre-form rear axles shafts. This configuration is chosen according to the production rate required and/or the bars diameter.

The above concerning free upsetting technology and process.

On the other hand today there is great interest for upsetting in dies, in fact the output of these machines are parts ready for machining without forging by press.

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The upsetting in dies of solid bar is a traditional application and allow to prepare parts close to the final shape.

But “In-dies upsetting” can be applied also to pipes, that is actually a relatively new solution, developed during the last years with very important applications in the oil and aeronautic industries.

The pipe upsetters must have very sophisticated adjustment systems for all the important cycle parameters, this allow to reach a very good fibering and grain sizing that are at the base of the end users quality demand.

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