

CONTENTS

Chapter 1	On Hammers	01
1. 1	Development of Hammers For Accuracy	03
1. 2	Development of Drop Hammers	05
1. 3	Development of Power Hammers	06
1. 4	Determination of Blow Energy Using Lead	07
1. 5	About Piston Head and Rod in Drop Hammer	08
1. 6	About Piston Head and Rod in Power Hammers	09
1. 7	Modern Hammers With Mechanization	11
1. 8	High Strain Rate Hammers & Rotary Swage Hammers	12 – 14
1. 9	Horizontal Forging Machine	14
1. 10	Roll Forging Equipment	15
1. 11	Hydraulic Primary Forging Presses	16
1. 12	Hydraulic Primary Extrusion Presses	18
Chapter 2	Controls in Hammers	19
2. 1	Objectives	20
2. 2	Self Regulating Valve	21
2. 3	Controls in Pneumatic Hammers	22
2. 4	Controls in Modern Oil Hydraulic Hammers	24
2. 5	Sabre Lever Control for infinitesimal suspension	25
2. 6	Mechanical Control of a Slip Drive Belt Drop Hammer	26
2. 7	Pneumatic Control of a Slip Drive Belt Drop Hammer	26
2. 8	Electro –Pneumatic-Mechanical Control of Board Drop Hammer	27
2. 9	Mechanical Control For a Board Drop Hammer	28
2. 10	Special Control For Short Stroke Hammer	29
2. 11	Special Hydraulic Control For Counter Blow Hammer	30
2. 12	Mechanization in Hammers	31
2. 13	Programmed Travel Control For Drop Hammer	32
2. 14	Programmed Travel –Time Control for Drop Hammer	32
2. 15	Programmed Time Control For Power hammer	33
Chapter 3	Swage Hammers	34
3. 1	Classification and Types	35
3. 2	Principles in the Die	36
3. 3	Principles of Stages in Wedge Type Swager	38
3. 4	On Lobes Design	40

3. 5	Dimensioning the Dies and Load Estimation	41
3. 6	Various Design Features of Mandrels	41
3. 7	Typical Parts Made by Swaging	44
3. 8	Economical Aspects (Examples)	46
3. 9	Swage Temperatures for Certain Special Materials	47
Chapter 4	On Screw Presses	48
4. 1	Development of Friction Screw & Screw Presses	49
4. 2	Description of Different Screw Presses	50
4. 3	ibid	51 – 53
4. 4	Time - Speed Diagrams to enumerate Slip Losses	54
4. 5	Energy Enumeration	55
4. 6	Wedge Press	57
Chapter 5	On Mechanical Presses (Stroke Bound)	59
5. 1	Multiple Point Geared Mechanical Eccentric Press	60
5. 2	About Force – Stroke Velocity Kinematics Importance	61
5. 3	Principles of Varying the Eccentric in Eccentric Presses	66
5. 4	Extended Crank Lever Press (Sub Group)	67
5. 5	Different Extended Drives	68
5. 6	Pictorial Views of Stroke Bound Presses	70
5. 7	View of the Horizontal Forging Machine	71
5. 8	Wedge Press	73 – 74
Chapter 6	Clutches For Presses	75
6. 1	Positive/Impact/Instant Clutches	76
6. 2	Friction/Smooth/Gradual Clutches	76
6. 3	The Algebra of Clutch Transmission	77
6. 4	Slide Bolt Clutch	78
6. 5	Rolling Key Clutch	78
6. 6	Clutches For Permanent Operations	79
6. 6. 1	Mechanical Friction Clutch	79
6. 6. 2	Electromagnetic Friction Clutch	79
6. 6. 3	Electromagnetic Threaded Sleeve Clutch	80
6. 6. 4	Pneumatic Friction Clutch	80
6. 6. 5	Hydraulic Friction Clutch	81

Chapter 7	Safety Devices For Presses and Operators	82
7. 0	General Definitions	83
7. 1	Safety Devices for the Operators	83
7. 2	Specific Definitions of Accidents	84 – 88
7. 3	Safety Devices For the Presses	89
7. 4. 1	Articulated Lever	90
7. 4. 2	Key Spring Device	90
7. 4. 3	Hydraulic Safety Device	91
7. 4. 4	Shear Plate below the Tool	92
7. 4. 5	Safety Device on The Press Frame	92
7. 4. 6	Force Indicating Instruments	92
7. 4. 6. 1	Conversion of Pressure into Electrical Signal	92
7. 4. 6. 2	Strain Gages at The Press Frame	92
7. 4. 7	Mechanical Measurement of The Frame Elongation	93
7. 4. 8	Hydraulic Safety Device for Multiple Point Drives	94
7. 4. 8	Overload Torque Protection in Screw Presses	95
7. 4. 9	Using Light Barriers and Photo cells	95
Chapter 8	Feeding Devices	97
8. 1	Feeding Devices for Sheet Metal Forming	97
8. 2	Feeding Devices for Bulk Forming	97
8. 1.	Roll Feed	97
8. 1. 1	Single Action Feed in Type	97/102
8. 1. 2	Single Action Feed out Type	97/102
8. 1. 3	Double Action Type	97/102
8. 1. 4	Hook Feed	97/105
8. 1. 5	Wedge & Roll Feed Type	97/105
8. 2. 1	Bunkers with Special Tooling Techniques	106/107
8. 2. 2	Transfer to Tools	106/108
8. 2. 3	To the Tool Post in the Press	106/108
8. 2. 4	Reciprocating Slide	106/108
8. 2. 5	Reciprocating Hook	106/108
8. 2. 6	Wedge and Knife Device	106/108
8. 3	Dial Feed	109
8. 4 to 8. 6	Unloading and Transfer Devices	111/114
Chapter 0X	Data Sheets for Section Modulus, Bending Moment etc	115 – 128

Chapter 9 (A)	Applications of Fluid Power in Metal Forming (an Overview)	PVA-PVC
Chapter 9	On Hydraulic Presses	129
9. 1	View of Hydraulic Extrusion Presses (Side Extrusion)	130
9. 2	Schematic of Hot Extrusion Processes	130
9. 3	Extrusion Hydraulic Primary Presses	131
9. 4	Columns and Multi Cylinders	135
9. 5	Shift Tables and Manipulators	136
9. 6	Forging Hydraulic Presses	137
9. 7	Hydraulic Presses For Secondary Processes	142
9. 8	Ideal Power Variation of Pump and that of Deformation Process	143
9. 9	Traditional Hydraulic Circuit for FF, SW & FR Cycle	144
9. 10	With Variable Displacement	145
9. 11	Wedge Presses	150
9. 12	Summary	152