

PROGRAMMABLE FORGING HAMMERS for the 21st Century



Die
Forgers

Die Forger
Conversion
Units

Power
Forgers

AjaxCECO

A ParkOhio Company

The Leader in Forging Since 1875

HOT, WARM AND COLD FORGING MACHINERY





21CDF - Converted from a 4000 LB CECO-Drop

Our forging hammers offer users and their customers

- INCREASED PRODUCTIVITY
- CONSISTENT BLOW CONTROL
- FLEXIBLE PROGRAMMING - Energy, Number of Blows, Blow Rate
- IMPROVED PRODUCT QUALITY
- RELATIVE EFFICIENCY
- REDUCED MAINTENANCE COST

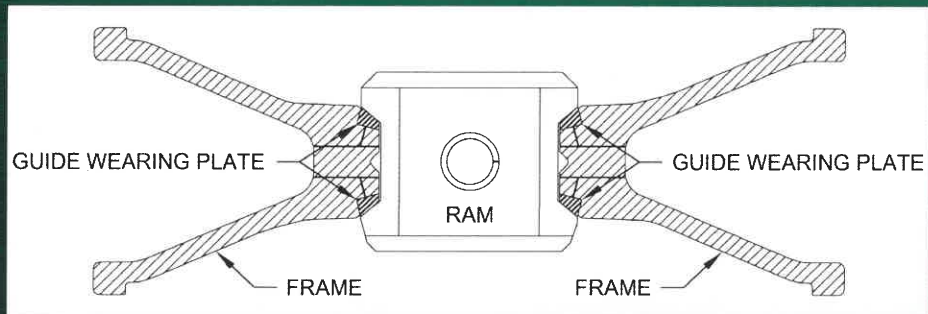
The Die Forger and Die Forger Conversion Units feature construction typical of gravity fall hammers like the CECO-Drop.

High blow rates increase productivity 20-30% over conventional gravity fall hammers of comparable size.

Fewer moving parts results in lower maintenance costs.

Poppet type valves, controlled by solenoid pilot valves, have zero leakage. Their precise timing results in efficient conversion of input energy into impact energy.

Die Forgers and Upperworks Conversions incorporate Radial Guides that eliminate clearance adjustments. Users report that radial guides also result in improved forging quality.



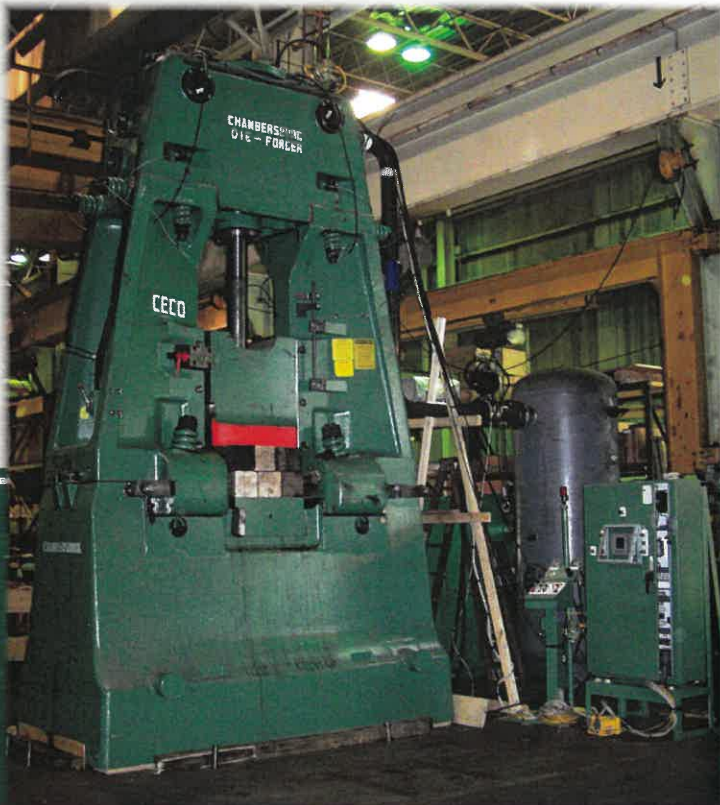
Radial Guide Frames



Custom engineered programmable control packages are available to suit user needs. This might include machine diagnostics and trouble-shooting, uptime/downtime log, job data bank, and computer networking.

Clóser Tolerance Forgings

PLC Controls provide high reliability and are easily maintained. The entire forging sequence is programmable, thus reducing operator skill requirements. Achieve job-for-job production increases of up to 30% and significant die life improvements.



The electrical controls are housed in a shock mounted control panel, located adjacent (but not attached) to the Die Forger.

SEQ	BLOW	ENERGY (FT-LB)	EXH	MODE	DEL
-	-	-	-	-	-
1	4	9750	200	0	100
2	4	18000	50	0	100
3	2	32000	0	0	100
4	1	38000	0	0	0
5	0	4000	0	0	0
6	0	4000	0	0	0

Blow Energy is automatically regulated based on striking air pressure before each blow. Each sequence can be preset with a different intensity to suit the forging shape and material requirements.

Die Forger Sizes

Size of Die Forger	Equivalent Gravity Fall Hammer (Nominal Falling Weight)		Maximum Blow Energy	
	Lbs.	Kg.	Ft-Lb.	KJ
4	1,000	450	4,000	5.42
8	2,000	900	8,000	10.85
14	3,200	1,455	14,400	19.25
23	5,000	2,270	23,800	32.27
38	8,000	3,630	38,000	51.52
66	13,000	5,900	66,000	89.48

Die Forger Conversion Unit Sizes

Size of Die Forger	Equivalent Power Hammer Size (Nominal Falling Weight)		Maximum Blow Energy	
	Lbs.	Kg.	Ft-Lb.	KJ
4	1,000	450	4,200	5.75
6	1,500	680	6,460	8.76
9	2,000	900	9,720	13.18
12	2,500	1,140	12,500	16.95
15	3,000	1,360	15,600	21.15
21	4,000	1,820	21,300	28.88
27	5,000	2,270	27,200	36.88
33	6,000	2,730	33,000	44.74



A #45 Power Forger in Operation

Power Forger and Power Forger Conversion Sizes (Air Operation Only)

Size of Power Forger or Conversion	Equivalent Power Hammer Size (Nominal Falling Weight)		Maximum Blow Energy	
	Lbs.	Kg.	Ft-Lb.	KJ
9	1,000	450	9,000	12.20
13	1,500	680	13,000	17.63
18	2,000	900	18,000	24.40
23	2,500	1,140	23,000	31.18
27	3,000	1,360	27,000	36.61
36	4,000	1,820	36,000	48.81
45	5,000	2,270	45,000	61.01
54	6,000	2,730	54,000	73.21
72	8,000	3,640	72,000	97.62
90	10,000	4,545	90,000	122.02
108	12,000	5,455	108,000	146.43
144	16,000	7,273	144,000	195.23
180	20,000	9,090	180,000	244.04
225	25,000	11,364	225,000	305.06
315	35,000	15,910	315,000	427.08

Nominal Falling Weight does not include dies.
 Impact velocity is approximately 21.5 ft./sec., assuming a die weighing 25% of nominal falling weight.
 Specifications subject to change. Visit us on the web: www.ajax-ceco.com



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