

GATWICK FULLY AUTOMATIC ENGINE VALVE ELECTRICAL UPSETTING MACHINE



EUM32 with automatic part feeding and robotic removal of welded components

EUM 32 Specification

Power	32 kVA
Maximum Upsetting Force .	4,000 Kg
(Hydraulic control)	
Capacity	75mm Top Anvil
	Retraction Stroke
	250mm gathering
	stroke
Maximum length of input bar	
with backstop	500mm
Option: Special forge clamp	Maximum length
	of input bar
	unlimited
	(special forge
	clamp)
Upsetting Cycle (Standard)	1.) Initial Heating
	2.) Retraction of
	Die
	3.) Forming and
	shaping
Product range	5mm to 14mm
	steel

Advantages of Upsetting:

- Only heats the portion to be upset, remaining portion is still cold and can be handled without surface damage or marking.
- No burning or scale is produced due to fine control of heat.
- Ideal grain structure without kinks, drift or surface folds.
- Savings in material costs compared to turning from solid.
- Improved quality over forging which requires multiple operations.
- Unskilled operators, upsetting cycle is fully automatic.
- Clean process without special installation and protection requirements.
- Open or anvil plate upsetting process produces a variety of shape for subsequent finishing in a press.
- Closed or die upsetting process produces a smooth cylindrical head with close tolerance suitable for further processing without machining.
- Optional automatic loading from magazines/hoppers.
- Engine valve upsetting generally used to create a pre-form bulb prior to stamping



Example upset engine valves. Before stamping / after stamping



Upsetting in progress