

NEW dimensions in hot shearing: BCGS_300

Building hot shearing systems since several decades, VALDARNO provides extensive know-how and experience in hot shearing equipment. Numerous systems featuring induction, gas or mixed gas/induction heating, for shearing round, square or even rectangular bars are successfully operating at customer plants in Italy and abroad.

VALDARNO has completed factory testing a BCGS_300 hot shear, ordered by a western European manufacturer of forged aeronautical and medical components. This equipment supposedly is the largest hot shear in the forging industry today. As a matter of fact, it is designed for shearing round bars of high alloy steel grades up to 300mm diameter; maximum shearing length of 1.000mm also represents a quite remarkable feature.

The BCGS_300 is the paramount of VALDARNO's hot shear series; whenever square or round bar materials are

either not suitable for cold shearing, or the combination of large bar section and high production volume makes sawing unpractical, hot shearing at forging temperature (typically 1.250°C) often turns out to be the most efficient technique.

By a unique billet presser design, an electronically controlled length gauge and special shearing blade techniques, VALDARNO shears ensure highest shearing length and billet weight precision, smallest orthogonal deviation and deformation of the sheared billet, with highest repeatability.

Fully automated lines include automatic bar magazine, roller-way, hot bar reject magazine, induction coil or gas furnace support frame and roller-way and integration of the chosen heater type. The supply program is completed by customized solutions for handling the billet after shearing, such as chutes, shuttles, robots etc. as well as weighing systems.



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Rebuilding of large presses: warranty as NEW

Decades of experience as a reliable designer and manufacturer of VALDARNO brand presses for the forging industry and the new, highly performing infrastructure featuring hoisting capacities up to 100t are convincing arguments. Most recently, VALDARNO has completed full rebuilding of mechanical, electrical, hydraulic and lubrication systems on a National 2.500t Maxipress.



An important design modification was made by replacing the original brake with a new hydraulic brake system. An as NEW warranty is given on all rebuilt systems and rebuilding works. Over the past few years VALDARNO has rebuilt several large equipment from makers like Smeral, National, Farina and others, while overhauling works on a 4.000t Eumuco forging press are ongoing at present.

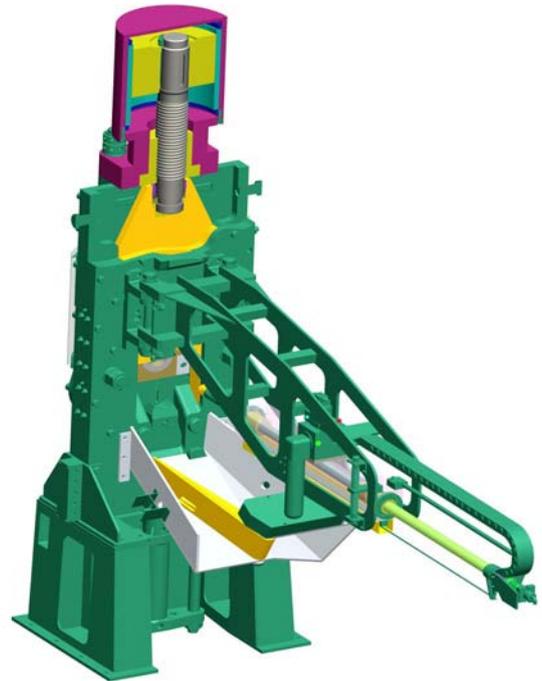


NEW developments in Hot Shearing

Constantly working on design improvements and new technologies, VALDARNO delivers some new responses to evolving market requirements.

Traditionally, hot shears are driven hydraulically; the proximity of high pressure hydraulic oil and high temperature billets is a constant safety concern in the forging industry. To overcome these concerns, VALDARNO has developed and is now offering an alternative hot shear with electric drive. The technology is available for the entire range of bar sections commonly hot sheared. Latest generation water hydraulic drive systems were developed for the auxiliary systems such as billet presser and length gauge.

Hot shearing of stainless steel at forging temperature is traditionally considered to be unviable due to the formation of cracks and poor quality of the cut. On behalf of state of the art simulation tools and shop floor testing, VALDARNO has developed and is now offering a new generation of blades for shearing stainless steel grades such as 1.4307, 1.4404, 1.4435 etc., reaching comparable results as with high alloy steel grades.



Mechanical coining and trimming presses VPS 2/P series

VALDARNO's VPS 2/P press series is the ideal equipment for trimming and piercing of large forgings under the same press. The welded monobloc press frame, the extremely sturdy double crankshaft drive, double pitman design and the long ram guide ways ensure a high precision and permissible off-centre load, with pressing force rated at 30° before LDC.

Motorized ram height adjustment, electro pneumatic clutch and brake, pneumatic balancing cylinders, centralized grease lubrication system with progressive distributors, PLC control and touch screen operator panel are standard features.

Hydraulic ram and/or bedplate knockouts, bearings overheating monitoring, pressing force monitoring and hydraulic overload protection are available options.

The VPS 2/P series comprises a full range of pressing forces from 300 to 1.200t.



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Forging solutions since 1949

Established 1949, VALDARNO develops, designs, builds and supplies machines, equipment and lines mainly for the closed die forging industry.

During many years of close and daily contact with companies and industry operators, in Italy and abroad, VALDARNO acquired knowledge and competences which enable it's specialists and engineers to study, realize and propose manufacturing solutions expressively designed for specific fields, such as for example, the production of leaf springs, helical springs, high resistance bolts, motor valves, pipe fittings by hydro-forming.

VALDARNO is an associate member of UNISA, the national steel forgers association of Italy.

New office buildings

VALDARNO staff has moved into new spacious and modern office buildings. All development, design, purchasing, marketing & sales, after-sales services and financial accounting functions are located here, and take now advantage from a dynamic and motivating work atmosphere.

