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ABSTRACT

This paper presents the improved TR-Method of forging crankshafts, which makes possible to obtain solid crankshaft forgings of a new design characterized by large protrusions on the main journal sides of the crankwebs. In the improved TR-Method asymmetrical initial upsetting according to UPRP Nr P-311892 was used instead of symmetrical one. The special mechanism, designed for removing the preanvil form the forging device working space without the necessity of lifting the crankshaft, has been applied. Layout of forging operations was described. Studies and investigations the improved method, concerning the influence of the parameters of preupsetting forming on the crank web shape accuracy, have been carried out.