



Induction Technology

AICHELIN Group

# Vertical Induction Hardening Machines – universally applicable



**Type KM**  
**for large-scale Batches**

**RELIABILITY AT WORK**

# Vertical Indexing Table Hardening Machine Type KM designed for large-scale Batches

Designed for the efficient processing of small parts in medium-sized to large-scale batches. The easy-to-install conception distinguishes this machine from others by its universal adaptability as well as its flexibility; it offers easy and reliable operation. The vertical feeding path of the inductor and the turning of the indexing table are effected via NC drives, the horizontal feeding is done manually. This method offers very short secondary processing time. Owing to the use of tunnel or multi-station inductors and the fact that the quenching and re-cooling processes are shifted to the subsequent cycle of the indexing table, the process time is reduced. There is only little need for space because of the compact construction. Ready for immediate use, only shortly after delivery.

## Basic equipment of the universally applicable machine

- CNC control, type Siemens 840D sl
- User-friendly, comprehensible operation
- Visualisation and documentation of all parameters relative to the process via a coloured operation panel
- Vertical inductor guide way designed as CNC axis
- Cross adjustment, engine-driven
- Working space equipped with stainless material

Connections to network, Ethernet, Internet, modem and automation interfaces are possible.

Quality control packages round out the range of the services we offer.

Technical Data	
Base	2,620 x 1,620 mm
Height	2,250 mm
Feed range vertical inductor feed axis	300 mm
Speed of feed axis	30 bis 10,200 mm/min
Feed range horizontal inductor in-feed axis (manual)	+/- 15 mm
Feed range horizontal inductor traverse adjustment (manual)	+/- 15 mm
Number of revolutions of circular axis	0.05-400 min <sup>-1</sup>
Number of revolutions of work piece rotary center sleeves	50-400 min <sup>-1</sup>
24 stations rotary table (reference diameter 350 mm) with 4 driven stations	
Maximum weight of work piece for 24 stations rotary table	1 kg
Maximum diameter of work piece relating to 24 stations rotary table	up to 30 mm
Converter types	HF converter 150-350 kHz from 20 to 75 kW MF converter 10-20 kHz from 20 to 80 kW

Any indications of sizes are to be understood as circa sizes.  
Subject to any kind of alterations, errors excepted.

## Special Equipment

Diverse models of partition of indexing plate
Diverse models of indexing table holding fixtures
Frequency-controlled rotary drive for indexing table holding fixtures with rotation control
Automatic discharge of work pieces



Certified according to DIN EN ISO 9001:2000 and VDA 6.4

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