

LARGE FORGING

Gestión de Compras develops large forging for any type of part according customer's specifications.

PROCESS:

Large forging parts are normally manufacturing by open die forging which can produce forgings from a few pounds up to more than 150 tons. So, this method is used when forgings are very large and the parts cannot be made by other processes.

The process of open die forging is carried out in large hydraulic presses or power hammers. Since in open die forging the workpiece is usually larger than the tool, at any point of time, deformation is confined to a small portion of the workpiece. Numerous squeezes or blows are applied to different portions of the workpiece to bring it to the final desired shape. During the process, to present new material under the hammer, the workpiece is suitably moved in between; in fact the movement of the workpiece is the key to this method. Final shaping is thus gradual and step by step. The resultant forged part is rough when machined is followed by finishing machine to final dimensions.

PRODUCTION:

In **Gestión de Compras** we have the capability and production capacity to generate components by forging in a wide variety of sizes utilizing common or specialty metals and metal alloys efficiently and economically.



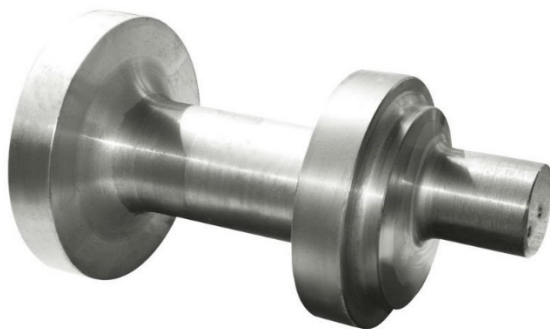
MATERIALS AND PRODUCTS:

Practically all forgeable ferrous and non-ferrous alloys can be open die forged, the most common forging alloys include:

- carbon steel
- stainless steel
- aluminium
- copper
- brass
- bronze
- iron
- nickel
- cobalt
- titanium
- etc.

Nowadays, remarkable large forgings have been more and more required to meet industries demand such as defence, fossil-fuel power generation, hydropower generation, mineral processing and mining, marine equipment, petrochemical, industrial equipment, aerospace, shipbuilding and other general industries.

By this method we can produce for example shaft, rolled rings, pressure vessels, gun tubes, generators, turbine rotors, discs, couplings and jackshafts, rock crushers, drum shafts, draglines, shafts, hubs, blocks, sleeves, cylinders, flats, hexes, rounds, plates, bars, pot die products, gear blanks, ...



TOLERANCES:

Dimensional tolerance depends of material and size of the forged part. By this method is difficult obtain narrow tolerances because, generally, the part is produced by hot forging and part by part. For this reason, usually needs finishing machining operations to get the desired final dimensions.

STANDARD AND CERTIFICATES:

We have the means to ensure our products comply the general regulation and the specific certificated regulations in manufacturing products that requires them.

- ISO 9001, TS 16949 and ISO 14001.
- QS 9000, AS 9100.
- EN 10243, EN 10254, EN 10222...
- OHSAS 18001



CONTACT:

In **Gestión de Compras** work with a wide range of customers from different sectors but have in common the search for products that suit your needs at the best Price and the guaranteed maximum quality. Check with us about any product. We have a qualified staff who will advise you.

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PRODUCTOS:

