



YOUR **THREAD ROLLING** **AND SPLINE ROLLING** SOLUTION



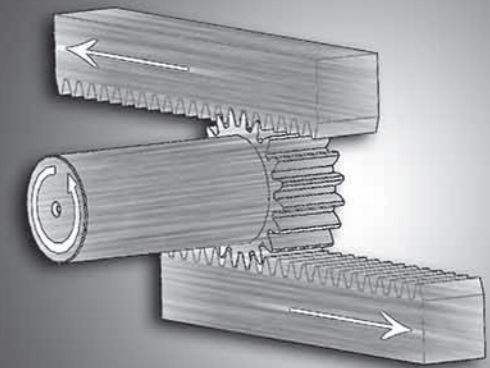
Yieh Chen Machinery was established in 1984 into the market of machinery industry and is dedicated to provide Thread Rolling Machine and Spline Rolling Machine with high quality, durable lifetime and attentive service.

CHIPLESS DURABLE EFFICIENT



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Yieh Chen Thread Rolling machine series are remarkable in terms of workpiece quality requirement, easy to operate & maintain, and durability of machine lifetime. The possibility of connection to an automatic system and output is another brilliant design for customers who have special needs.

The general characteristics of all machines series are:

- A very rigid iron cast frame or modifiable steel plate machine bed.
- Hydraulic type and Cam-Driven rolling type force.
- Rolling force from 4 tons to 100 tons.
- Plunge (in-feed) and through-feed rolling.
- Two and three cylindrical die rolling for various material type (bar, rod and tube).
- Easy to operate, changeover, and maintain.



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COMPANY PROFILE . . .

Gear Specialized

Yieh Chen Machinery Co., Ltd is the affiliate of Six Star Group. Six Star was founded in 1975 by Six brothers and devoted to the manufacturing of precision gear products. Throughout these years, Six Star has become one of the Top Five gear manufacturers in Taiwan. With a focus on precision gears and gearboxes, Six Star offers a broad range of industries, including machine tools, aerospace, agriculture machinery, robotic arms, transmission, hydraulic pumps and industrial machines.

Machine Manufacturer

Based on Six Star's professional and rich experience of manufacturing various precise gears, Yieh Chen Machinery was established in 1984 into the market of machinery industry and is dedicated to produce Thread rolling machine and Spline rolling machine with high quality and durable lifetime.

We offer customer rigid machine with function of precision, durable, simple operation, easy maintenance and competitive price. Moreover, we design fully automation production lines for thread rolling machine, wire forming machine, special purpose machine, entire automation production lines are all in our service areas in order to provide total solution for customers.

Yieh Chen is never slackening off on pursuing the best in the global market. Hence, we wish to achieve higher customer satisfaction and build closer relationship with customers by advancing our quality level.



- CE certificate of YC Thread Rolling Machine series



Heavy Duty Hydraulic Thread Rolling Machine

- The machine frame is fabricated from steel plate, tempered for deformation free performance.
- The hydraulic feed pressure is adjustable to satisfy all applications.
- On some models in-feed rolling cycle times are controlled by adjustable rolling and dwell timer switches. This facilitates the rolling of fine and coarse forms with a simple adjustment.
- Available on request are semi and fully automatic loading systems, foot activated control switches and electrical back stops.
- Oversized coolant tank allows for superior cooling effect. (optional)
- Gear box oil tank ensures maximum stability of oil temperature with recirculating pump.
- Extended universal joint provides smooth operation for big angle of workpiece.
- Powerful spindle motor meets the requirement of demanding product.
- Allen Bradley starters are available (USA market only).



YC-530PS

YC-530PSH

YC-750P

MAIN SPECIFICATION			YC-530PS(H)		YC-750P	
Rolling Size 可加工外徑	Min. O.D. 最小外徑		Ø 6 mm	1/4"	Ø 25 mm	1"
	Max. O.D. 最大外徑		Ø 80 mm	3-1/8"	Ø 100 mm	4"
Max. Length 牙長	In feed and through feed both available					
	Max. Pitch 可加工最大節距		8 mm	3 TPI	10 mm	2.5 TPI
Roll Dies 牙輪	Rolling Speed 轉速		56, 90, 136, 193 rpm		15, 23, 36, 52 rpm	
	Max. Outside Diameter 最大外徑		200 mm		200 mm	
	Inside Diameter 內徑		70 mm		70 mm	
	Max. Width 寬度		150 mm		150 mm	
Max. Center Distance of Die-spindle 牙輪中心最大距離			250 mm		250 mm	
Min. Center Distance of Die-spindle 牙輪中心最小距離			145 mm		145 mm	
Max. Rolling Force 最大滾製壓力			35 TON		55 TON	
Motor 馬達	Rolling Spindle 主軸		15HP (20HP optional)		25HP	
	Hydraulic Pump 油壓		5HP		10HP	
	Coolant Pump 冷卻		1/6HP		1/6HP	
	Gear Box Pump 齒輪箱冷卻		1/8HP		1/8HP	
N.W.	淨重		3000 kg		3300 kg	
G.W.	毛重		3460 kg		3860 kg	
Floor Space	佔地面積		2000 x 1560 mm		1650 x 2320 mm	
Packing Dimension (L x W x H)	包裝尺寸		2200 x 1720 x 1890 mm		2520 x 1810 x 2070 mm	

The designs are subject to modification and improvement without notice.



Heavy Duty Hydraulic Thread Rolling Machine



YC-860P

YC-970P

- The heaviest YC thread rolling machine with more than 100 tons rolling pressure.
- Squared slide processed by precise grinding is designed for large workpiece and make the thread rolling quality stable.
- Powerful spindle motor can meet the requirement of bigger material and heavy duty rolling.
- Bigger coolant tank and pump motor make the cooling effect better.
- The innovative machine with PLC control and frequency converter which makes the rolling speed adjustable. (optional)
- Spindle diameter can be revised according to your particular request.
- Allen Bradley starters are available (USA market only).



MAIN SPECIFICATION			YC-860P		YC-970P	
Rolling Size 可加工外徑	Min. O.D. 最小外徑		Ø 25 mm	1"	Ø 25 mm	1"
	Max. O.D. 最大外徑		Ø 120 mm	4-3/4"	Ø 140 mm	5-1/2"
Max. Length 牙長	In feed and through feed both available					
	Max. Pitch 可加工最大節距		2~12 mm	2 TPI	3~16 mm	8-1.5 TPI
Roll Dies 牙輪	Rolling Speed 轉速		20~60 rpm		20~60 rpm	
	Max. Outside Diameter 最大外徑		240 mm		300 mm	
	Inside Diameter 內徑		80 mm		100 mm	
	Max. Width 寬度		220 mm		260 mm	
Max. Center Distance of Die-spindle 牙輪中心最大距離			340 mm		400 mm	
Min. Center Distance of Die-spindle 牙輪中心最小距離			230 mm		230 mm	
Max. Rolling Force 最大滾製壓力			70 TON		100 TON	
Motor 馬達	Rolling Spindle 主軸		30 HP		40 HP (50 HP optional)	
	Hydraulic Pump 油壓		10 HP		15 HP (20 HP optional)	
	Coolant Pump 冷卻		1/2 HP		1/2 HP	
	Gear Box Pump 齒輪箱冷卻		1/4 HP		1/4 HP	
N.W.	淨重		5600 kg		12000 kg	
G.W.	毛重		6200 kg		12200 kg	
Floor Space	佔地面積		2350 x 2100 mm		2600 x 2100 mm	
Packing Dimension (L x W x H)	包裝尺寸		2600 x 2400 x 2550 mm		2800 x 2250 x 2550 mm	

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- The slide travel and feed rate are adjustable.
- The hydraulic feed pressure is also adjustable from 0.5 tons to 30 tons to satisfy all applications.
- On some models in-feed rolling cycle times are controlled by adjustable rolling and dwell timer switches. This facilitates the rolling of fine and coarse forms with a simple adjustment.
- Available on request are semi and fully automatic loading systems, foot activated control switches and electrical back stops.
- Especially suitable for producing long screw threads (E.G. acme lead and ball screws) and precision threaded, splined, worm and serrated components for machinery, hardware, tools, motorcycles, construction, automobiles, etc.
- Allen Bradley starters are available (USA market only).



YC-310



MAIN SPECIFICATION		YC-310		YC-420		YC-530	
Workpiece Range 工件	Outside Diameter 外徑	2 - 16 mm	1/16" - 5/8"	6 - 35mm	1/4" ~ 1-3/8"	6 - 60mm	1/4" ~ 2-3/8"
	Thread Pitch 牙距	0.4 - 2.0P	60 - 11 TPI	0.75 - 4.0P	40 - 6TPI	0.75 - 6.0P	40 - 4TPI
	Max. Length 牙長	In feed and through feed both available					
	Rolling Speed 轉速	54 rpm		24, 38, 52, 78 rpm		15, 23, 36, 52 rpm	
Roll Dies 牙輪	Max. Outside Diameter 最大外徑	100 mm		150 mm		180 mm	
	Inside Diameter 內徑	50.5 mm		54 mm		54 mm	
	Max. Width 寬度	30 - 40 mm		100 mm		150 mm	
	Max. Center Distance of Die-spindle 牙輪中心最大距離	120 mm		170 mm		220 mm	
	Min. Center Distance of Die-spindle 牙輪中心最小距離	90 mm		120 mm		145 mm	
	Rolling Force (Max.) 最大滾製壓力	4 TON		17 TON		35 TON	
	Output (Meter/Min.) REF. 參考滾製速度 (米/分鐘)	1.2		1.5		1.8	
Motor 3Ph A.C. 馬達	For Spindle 主軸	2HP		7.5HP		10HP	
	For HYD. Pump 油壓泵	2HP		3HP		5HP	
	For Coolant Pump 冷卻泵	1/8HP		1/8HP		1/8HP	
	Floor Space 佔地面積	1400 x 940 mm		1800 x 1350 mm		2000 x 1560 mm	
Machine Body 機體	Net Weight (Approx.) 淨重	480 kg		1650kg		2700kg	
	Gross Weight (Approx.) 毛重	650 kg		2000kg		3160kg	
	Shipping Measurement (L x W x H)	1575 x 1030 x 910 mm		2030 x 1490 x 1510 mm		2200 x 1720 x 1700 mm	

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**YC-420
YC-530**

YC-530P

- YC-530P is the basic model in Yieh Chen for producing square thread and scaffolding parts (e.g. Tie rod and Props) by its solid structure and powerful feature.
- Extra small rolling dies for rolling scaffolding props thread, providing much better performance than normal 3 rolling die structure.



EXCLUSIVE DESIGN
for Scaffolding Props Threading



MAIN SPECIFICATION		YC-530P	
Workpiece Range 工件	Outside Diameter 外徑	6 - 80mm	1/4" ~ 3-1/8"
	Thread Pitch 牙距	0.75 - 8P	40 - 3TPI
	Max. Length 牙長	In feed and through feed both available	
	Rolling Speed 轉速	15, 23, 36, 52 rpm	
Roll Dies 牙輪	Max. Outside Diameter 最大外徑	200 mm	
	Inside Diameter 內徑	70 mm	
	Max. Width 寬度	150 mm	
	Max. Center Distance of Die-spindle 牙輪中心最大距離	250 mm	
	Min. Center Distance of Die-spindle 牙輪中心最小距離	145 mm	
	Rolling Force (Max.) 最大滾製壓力	35 TON	
	Output (Meter/Min.) REF. 參考滾製速度 (米/分鐘)	0.5~2	
Motor 3Ph A.C. 馬達	For Spindle 主軸	15HP	
	For HYD. Pump 油壓泵	5HP	
	For Coolant Pump 冷卻泵	1/8HP	
	Floor Space 佔地面積	2000 x 1560 mm	
Machine Body 機體	Net Weight (Approx.) 淨重	2800kg	
	Gross Weight (Approx.) 毛重	3300kg	
	Shipping Measurement (L x W x H)	2200 x 1720 x 1700 mm	

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The Quality Thread Rolling Machine with Automatic Bar Feeder or Feeding System

- Yieh Chen provides customized service of design Auto-Feeding system for a wide variety of workpiece. Long as 1M to 12M rod material; short as 10mm item, there is no problem for us to design a fully automatic feeding and un-loading system.
- Based on customer's specific requirements, R&D team is capable to develop the unique device for high speed, fully automatic production of a wide variety of threads, such as single thread, double thread, triple thread, UNC, UNF, etc.
- Yieh Chen thread rolling machine is heavily constructed for high stability. Extremely powerful spindle motor allows high speed thread rolling with ease. The combination of thread rolling machine and auto-feeding system provides great saving of labor cost, upgrades productivity, and a necessity for competitive edge.



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YC-30A
W/VIBRATION BOWL FEEDER



YC-530
W/HOPPER FEEDER



YC-420
W/MAGAZINE FEEDER



YC-530S
W/AUTOMATIC BAR LOAD AND UN-LOAD SYSTEM



YC-TM3/4
W/CONVEYER FEEDER



YC-30A

- Incorporates hydraulic operation and can be applied to through and infeed rolling up to 32mm diameter components.



YC-60A

YC-60AP

YC-120A



- Incorporates hydraulic operation for mass production of many types of thread forms on hollow sections for oil pipe connectors, electric fan shafts, automobile and motorcycle parts, jacks and props, cycle hubs, closures, etc.



YC-3T

- Incorporating eccentric cam feed, smart and simple design and ease of operation for producing fine quality small screws for sewing machines, bicycles, automobiles, motorcycles, hardware, tools and precision machinery.



YC-20/YC-30

- Incorporating gear speed reduction and cam operated rolling slide for convenient and precise production of a large range of threaded parts. These machines are equipped with lubricating systems to increase the durability of the slides.



MAIN SPECIFICATION		YC-30A		YC-60A		YC-60AP		YC-120A	
Workpiece Range 工件	Outside Diameter(blank) 素材外徑	8 - 30 mm	5/16" - 1-1/8"	15 - 60mm	5/8" ~ 2-1/4"	15 - 75mm	5/8" ~ 3"	30 - 120 mm	1-1/8" ~ 4-3/4"
	Thread Pitch 牙距	0.5 - 2.5P	40 - 11 TPI	0.75 - 3.0P	40 - 8TPI	0.75 - 6.0P	40 - 4TPI	0.75 - 3.0P	40 - 8TPI
Roll Dies 滾牙輪	Max. Length 牙長			In feed and through feed both available					
	Rolling Speed 轉速	250 rpm		46, 65, 85, 120 rpm		46, 65, 85, 120 rpm		82, 131, 196, 278 rpm	
	Max. Outside Diameter 最大外徑	80 mm		140 mm		140 mm		140 mm	
	Inside Diameter 內徑	25.4 mm		40 mm		40 mm		40 mm	
Max. Center Distance of Die-spindle 牙輪中心最大距離	Max. Width 寬度	20, 30, 40 mm		50 mm		50 mm		50 mm	
	Min. Center Distance of Die-spindle 牙輪中心最小距離	130 mm		210 mm		210 mm		270 mm	
Rolling Force (Max.) 最大滾製壓力	Output (Pcs/Min.) 滾製速度 (數量/分鐘)	50 mm		75 mm		75 mm		105 mm	
	For Spindle 主軸	4 TON		18 TON		18 TON		19 TON	
Motor 3Ph A.C. 馬達	For Spindle 主軸	9 - 35		9 - 35		Quote by sample		Quote by sample	
	For HYD. Pump 油壓泵	2HP		5HP		7.5HP		7-1/2HP	
	For Coolant Pump 冷卻泵	1/8HP		3HP		3HP		3HP	
	Floor Space 佔地面積	1/8HP		1/8HP		1/8HP		1/8HP	
Machine Body 機體	Net Weight (Approx.) 淨重	1120 x 930 mm		1360 x 1250 mm		1360 x 1250 mm		1360 x 1280 mm	
	Gross Weight (Approx.) 毛重	550 kg		1150kg		1200kg		1300kg	
	Shipping Measurement (L x W x H) 包裝尺寸 (長 x 寬 x 高)	720 kg		1380kg		1400kg		1500kg	
		1320 x 1130 x 1570 mm		1560 x 1450 x 1650 mm		1560 x 1450 x 1650 mm		1560 x 1450 x 1650 mm	

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MAIN SPECIFICATION		YC-3T		YC-20		YC-30	
Workpiece Range 工件	Outside Diameter 外徑	0.8 - 12.5 mm	1/32" - 1/2"	5 - 22 mm	3/16" - 7/8"	5 - 40 mm	5/16" - 1-9/16"
	Thread Pitch 牙距	0.4 - 1.5P	60 - 16 TPI	0.75 - 2.5P	40 - 9 TPI	0.75 - 3.0P	40 - 8 TPI
Roll Dies 滾牙輪	Max. Length 牙長	30 (40) mm	1-1/8" (1-9/16")	48 mm	1-7/8"	150 mm	6"
	Rolling Speed 轉速		40 rpm		40 rpm		40 rpm
	Max. Outside Diameter 最大外徑		100 mm		120 mm		150 mm
	Inside Diameter 內徑		50.5 mm		40 mm		54 mm
Max. Center Distance of Die-spindle 牙輪中心最大距離	Max. Width 寬度		30 (40) mm		50 mm		150 mm
	Min. Center Distance of Die-spindle 牙輪中心最小距離		130 mm		140 mm		187 mm
Output (Pcs/Min.) 滾製速度 (數量/分鐘)	For Spindle 主軸		90 mm		100 mm		140 mm
	Motor 3Ph A.C. 馬達		20 - 40		9 - 30		7 - 20
Machine Body 機體	For Spindle 主軸		1HP		3HP		7-1/2HP
	For Coolant Pump 冷卻泵		1/8HP		1/8HP		1/8HP
	Floor Space 佔地面積		800 x 600 mm		1090 x 740 mm		1220 x 810 mm
	Net Weight (Approx.) 淨重		300 kg		970 kg		1300 kg
Shipping Measurement (L x W x H) 包裝尺寸 (長 x 寬 x 高)	Gross Weight (Approx.) 毛重		395 kg		1130 kg		1480 kg
			940 x 700 x 910 mm		1240 x 850 x 1220 mm		1365 x 925 x 1295 mm

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Standard Thread Rolling Dies:

- Single-Thread
- 60° V-Type Teeth, Pitch 0.5 - 5.0mm
- 55° V-Type Teeth, 40TPI - 5TPI
- 90° Knurling Thread, and 40TPI - 18TPI
- Parallel Thread

Special Thread Rolling Dies:

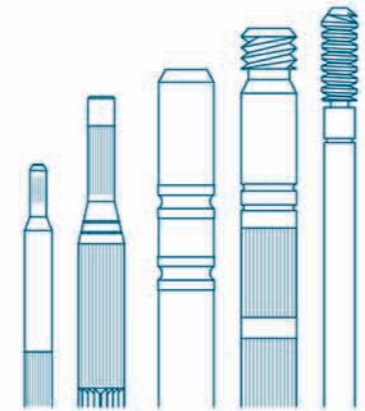
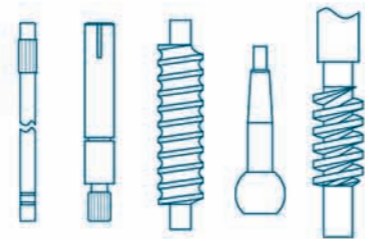
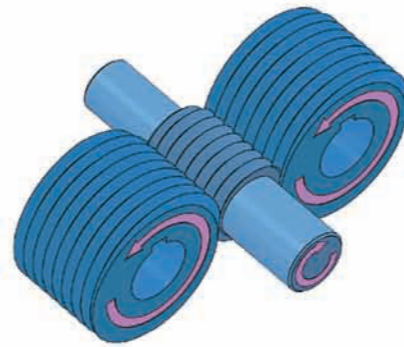
- Over than Single-Thread
- 60° V-Type Teeth, Pitch Out of 0.5mm - 5.0mm
- 55° V-Type Teeth, Out of 40TPI-5TPI
- 90° Knurling Thread and metric size pitch
- Spline
- Worm Thread, ACME Thread, Buttress, Cycle Thread, Bottle Closure Thread, and..etc.
- Taper thread
- For rolling special material, Ex. SUS, Alloy Steel and hardness over than RC20

How to Order Thread Rolling Dies:

Please Offer Below Data:

- Machine Model or Rolling Die dimension (O.D., I.D., Keyway)
- Shape of Workpiece (Thread Length, thread Profile, Pitch or Thread per Inch, Thread Major Dia., Pitch dia., Material).
- Please specify through or in-feed rolling.

Infeed Rolling (Plunge Type):

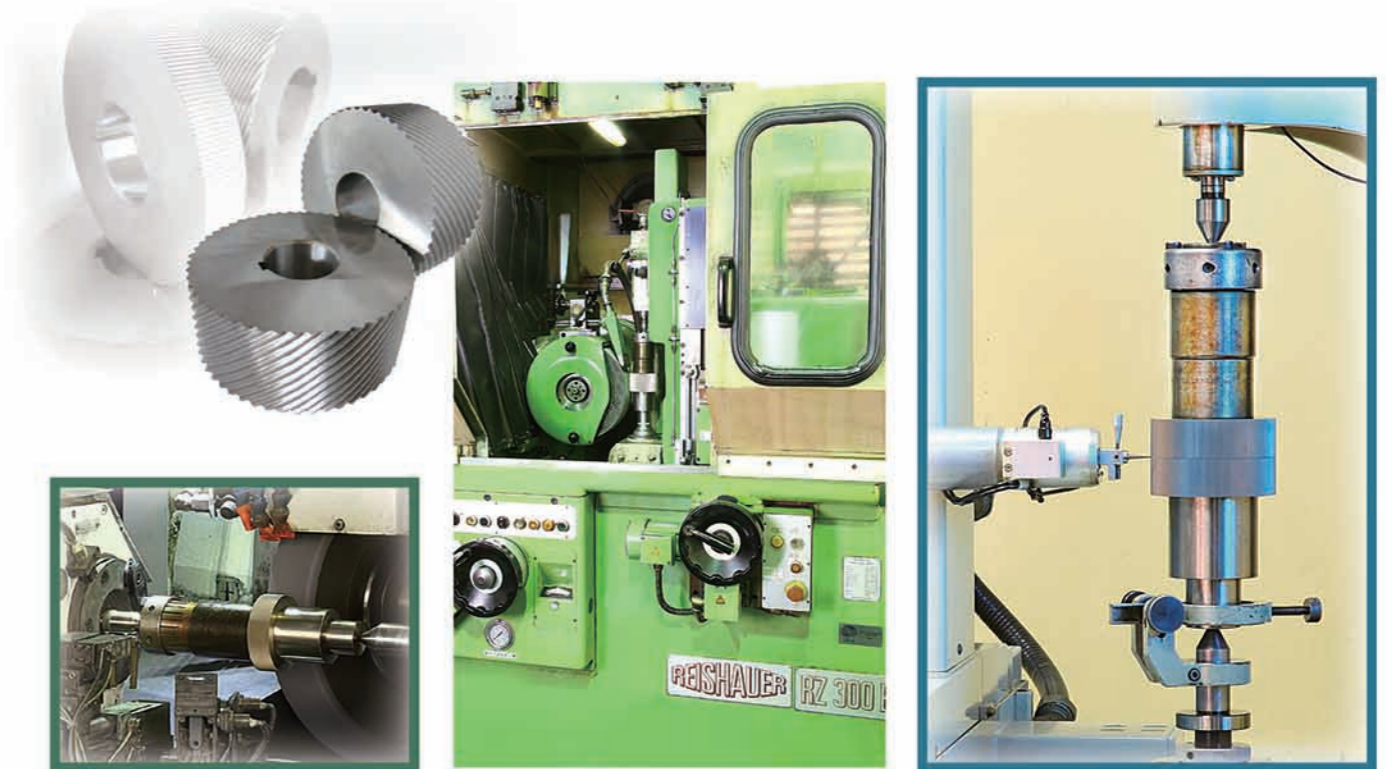


Through Feed Rolling:



Any Kind of Thread can be made such as UNC, UNF, BSW, Metric, ACME, Ball Screw, even Tube Thread.

Professional Fabrication of Thread Rolling Dies



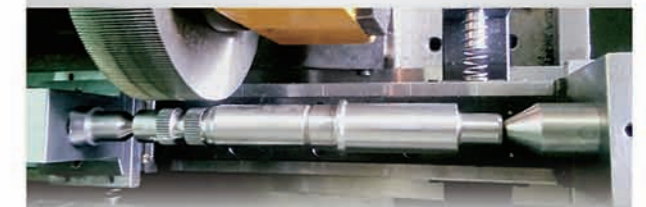
Adjustable Work Rest Seat



Work Piece Centering Device



Work Rest Blade



The centering device can help stabilize the work piece especially when rolling splines with high precision requirement.

Linear Scale



Codeout Unit



By the data shown on digital displayer, user can easily know the position of hydraulic slide and adjust to desired position swiftly. The internal memory function of Liner encoder can record the roller location for easy roller replacement and adjusting.

Monitoring System (for on-line inspection)



Touch Screen



Magnetic Iron Scrap Separator



Frequency Converter



Cooling System



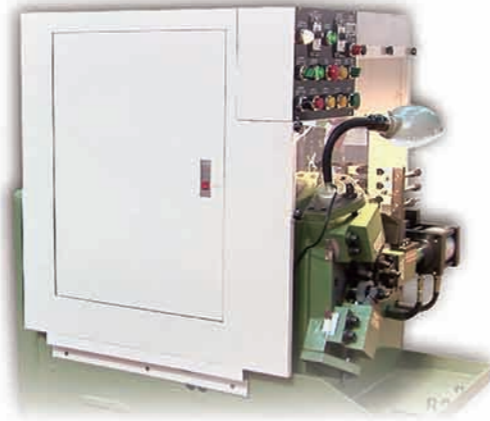
Oil Cooling System



Safety Cover (CE)



Safety Cover and Working Area Light



Spiral Tube Forming Machine

YC-201

- It can machine a series of thin metal tubes (spiral forming) which is widely used for heat exchange and cooling.
- We can design the machine according to your request of full range specifications.

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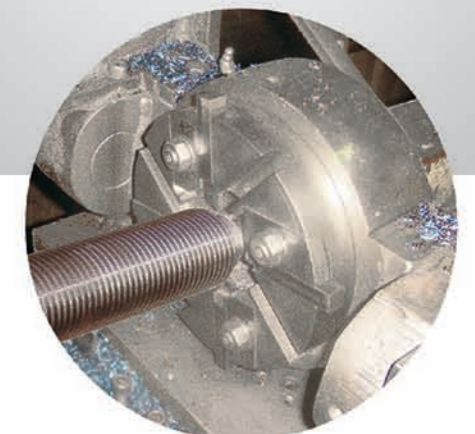
Thread Cutting Machine

YC-425

- Cutting the thread with high precision and good stability.
- It's easy to get the disposable cutter and not necessary to change the whole mold to save the cost.
- It can machine the material with high hardness.
- The machine spindle is driven by servo motor, and it's easy to adjust the pitch and length; therefore, it can meet the requirement of different size products.



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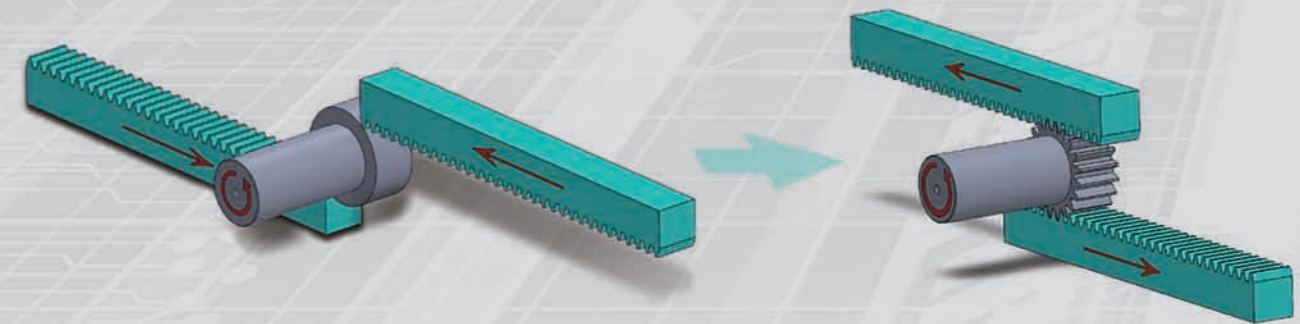
YC-800 / YC-1225

- Special for precision parts of vehicle, motorcycle, agricultural machine, filter, pneumatic, hydraulic 7 various hardware tools...etc. splines, serrations, oil grooves, worm gears, screws, knurl, threads and similar forms. "Chipless" forming to achieve excellent mass-productivity.
- This machine meets our group policy "Give organization vitality; Give system life; Give company development and Give customers satisfaction."

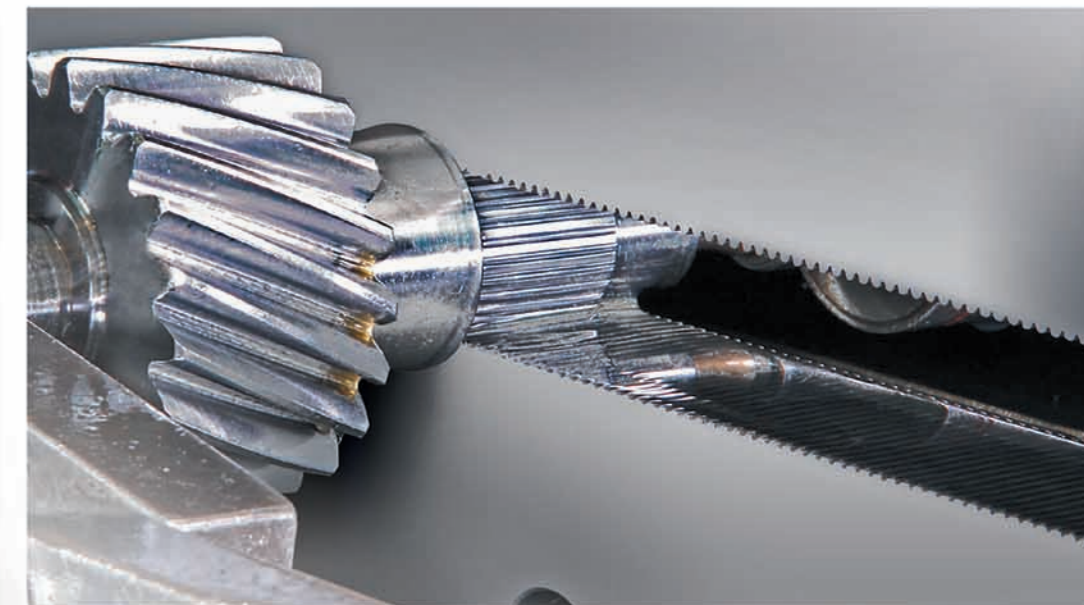
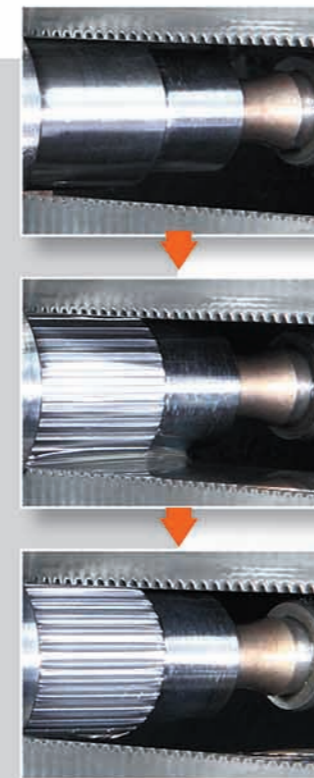


- Spline Rolling Machine is using Rack die/cutter instead of Cylinder thread rolling die; many different types of splines, serrations, oil grooves, worm gears, screws, knurls, threads and similar forms can be rolled in individually or in combination in just 3 to 7 seconds.
- The concept of Spline Rolling Machine (Cold form rolling machine of splines) was conceived more than 10 years ago. YIEH CHEN R&D team takes around 3 years to develop this model.

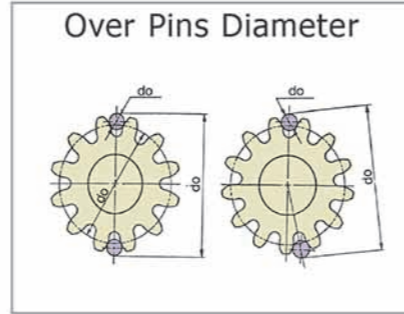
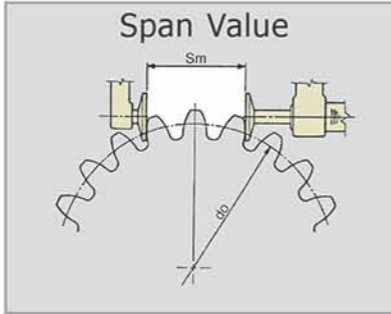
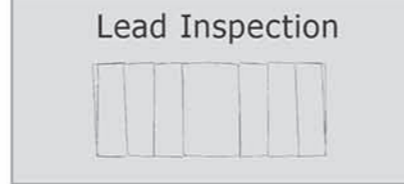
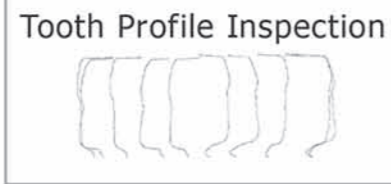
▼ The demonstration of spline rolling by upper and lower forming racks.



▼ Actual rolled spline by Yieh Chen spline rolling machine.



- The Spline Rolling Machine is inherently accurate, with surface finishes of 3 to 6 micro-inches obtainable.
- Spline Rolling is best suited for long production runs or intermittent runs of a variety of parts.
- It's the fastest and most economical method of producing involute toothed forms.



MAIN SPECIFICATION		YC-800	YC-1225	YC-1225P
Min. Component Diameter (mm)	工件最小外徑	13 (0.51")	13 (0.51")	13 (0.51")
Max. Spline Diameter (mm)	花鍵最大外徑	30 (1.18")	40 (1.57")	50 (1.97")
Max Spline Length (mm)	花鍵最大長度	110 (4.33")	110 (4.33")	110 (4.33")
Min. Component Length (mm)	工件最小長度	100 (3.94")	100 (3.94")	100 (3.94")
Max. Component Length (mm)	工件最大長度	1000 (39.37")	1200 (47.24")	1200 (47.24")
Max. Spline Module	花鍵最大模數	1.25	1.5	1.75
Standard Length of Spline Forming Rack	花鍵刀具長度	24"	36"	48"
Standard Length of Thread Forming Rack	螺紋刀具長度	13"	13"	13"
Hydraulic Motor	油壓馬達	40HP	50HP	50HP (6P)
Cooler Capacity	冷卻能力	5 TON	7.5 TON	7.5 TON
PLC Control System	PLC控制器	Mitsubishi	Mitsubishi	Mitsubishi
Floor Space (LxWxH)	佔地面積(長x寬x高)	2700 x 4200 x 2100mm	3700 x 4200 x 2100mm	3700 x 4200 x 2100mm
Packing Measurement (LxWxH)	包裝尺寸(長x寬x高)	4000 x 5000 x 3000mm	5000 x 5000 x 3000mm	5000 x 5000 x 3000mm
Net Weight (Kgs)	淨重	12,000 kgs	15,000 kgs	15,000 kgs
Gross Weight (Kgs)	毛重	12,500 kgs	15,600 kgs	15,600 kgs

The designs are subject to modification and improvement without notice.

Standard Accessories:

- Machine Safety Device
- Parts Setter
- Lubrication System
- Cooling System
- Electrical Control Unit
- Tooling & Tool Box
- Operation & Maintain Manual

Optional Accessories:

- Various Forming Racks
- Auto Loading System
- Special Center
- Customer-made Acceptable



Forming Racks

- Yieh Chen spline rolling machine incorporates the forming racks with the highest quality of steel.
- The surface treatment applied on our forming racks can increase the durability and lifetime of the rack die.
- Regular forming rack sizes ranging from 13", 18", 24", 36" and 48" which is subject to change according to customer's workpiece spline details.

Finished workpiece with excellent surface and accuracy of splines, worms, oil grooves and more, generated by Yieh Chen spline rolling machine:

