

Title (en)

MANUFACTURING COMMUTATOR SHELLS FOR ROTATING ELECTRIC MACHINES

Publication

**EP 0019472 B1 19840229 (EN)**

Application

**EP 80301610 A 19800516**

Priority

GB 7917477 A 19790518

Abstract (en)

[origin: EP0019472A2] Shells for commutators are made by performing a number of forming operations on stock metal strip before the strip is cut into lengths and rolled into a cylinder. A roller (14) forms parallel transverse grooves (18) and ribs (19) in one side of the strip. Punches (26) cut slots (27) in alignment with the grooves (18) to form fingers along one edge of the strip. Knives (32) skive under the ribs (19) to form anchors (41). Then the strip is cropped into lengths by a punch (43), bent into a cylinder by a two-stage press and forced through a tapered sizing die (61). All operations are performed in automatic sequence on a multi-stage slide press machine.

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IPC 8 full level

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Cited by

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