

Title (en)

Method of producing bimetallic contact rivets.

Title (de)

Verfahren zur Herstellung von Bimetallkontaktnieten.

Title (fr)

Méthode de fabrication de rivets de contact bimétalliques.

Publication

EP 0062243 A1 19821013 (DE)

Application

EP 82102480 A 19820325

Priority

DE 3112453 A 19810328

Abstract (en)

[origin: ES8301705A1] A process for the production of bi-metallic contact rivets with especially thin precious metal layers. The process includes the insertion of two wire segments of congruous diameter but of different length and different composition into a guide bush which fits these arranging the wire segments between an ejector pin displaceable lengthwise in the guide bush, and an abutment with a cross-sectional surface which is larger than the cross-sectional surfaces of the wire segments, which abutment is arranged coaxially to the ejector pin outside the guide bush and initially abutting the adjacent one end surface of the guide bush while pushing forward the ejector pin in the guide bush, the abutment is simultaneously withdrawn away from the guide bush, the velocity of the abutment being smaller than that of the ejector pin thereby upsetting the wire segments in accordance with the decreasing distance between the adjacent surfaces of the ejector pin and of the abutment, and forming a blank of a cylindrical shape the contact rivet head is formed by cold press-working at that end of the blank where the short wire segment is found, the rest of the blank serving as the rivet shaft.

Abstract (de)

Es wird ein Verfahren zur Herstellung von Bimetallkontaktnieten mit besonders dünner Edelmetallaufgabe beschrieben. Im Verlauf des Verfahrens wird aus zwei Drahtabschnitten unter stetiger plastischer Verformung (Stauchung) zunächst ein i.w. zylindrischer Rohling mit vergrößertem Durchmesser gebildet und diesem Rohling sodann durch Umformung an dem mit Edelmetall belegten Ende ein Kopf angeformt.

IPC 1-7

H01H 11/04

IPC 8 full level

H01H 11/04 (2006.01)

CPC (source: EP US)

H01H 11/042 (2013.01 - EP US); **Y10T 29/49218** (2015.01 - EP US)

Citation (search report)

- [A] DE 1427350 B
- [A] FR 1472908 A 19670317 - RENZ
- [A] GB 1079080 A 19670809 - EUGEN DURRWACHTER, et al
- [A] GB 1198803 A 19700715 - JOHNSON MATTHEY CO LTD [GB]

Cited by

CN106862930A; DE4126220A1; WO9303490A1; WO9303511A1

Designated contracting state (EPC)

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DOCDB simple family (publication)

EP 0062243 A1 19821013; EP 0062243 B1 19850130; EP 0062243 B2 19890111; DE 3112453 A1 19830428; DE 3112453 C2 19850808; DE 3262097 D1 19850314; ES 510767 A0 19830201; ES 8301705 A1 19830201; US 4446618 A 19840508; YU 67582 A 19870630

DOCDB simple family (application)

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