

Title (en)
METHOD OF PRODUCING BIMETALLIC CONTACT RIVETS

Publication
EP 0062243 B2 19890111 (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end surface of the guide bush while pushing forward the ejector pin in the guide bush, the abutment is simultaneously withdrawn away from the guide bush, the velocity of the abutment being smaller than that of the ejector pin thereby upsetting the wire segments in accordance with the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.

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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)

Cited by
CN106862930A; DE4126220A1; WO9303490A1; WO9303511A1

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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

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