Title (en)

METHOD OF MANUFACTURING A SEGMENT RING OF A COMMUTATOR

Publication

EP 0111687 B1 19880107 (DE)

Application

EP 83110669 A 19831026

Priority

DE 3242703 A 19821119

Abstract (en)

[origin: US4667394A] A method of forming flanged commutator segmental rings in a single power stroke by cold-extrusion which assures full formation of the inner ribs which become commutator segments, so that the segments will anchor well and resist centrifugal force at high rotational speed. The extrusion apparatus has an inner rib-forming die (18) and an outer ring-shaped flange-forming die (16). In the first stage of the power stroke, a ring-shaped blank (1) is formed into a flange precursor and a shaft portion (24) with inner ribs. In the second stage of the power stroke, the ring-shaped die (16) forms the flange (4) while the rib-forming die (18) forms a longer shaft (3) with a full complement of inner ribs (5) and a counter-punch (13) maintains pressure.

IPC 1-7

H01R 43/08

IPC 8 full level

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CPC (source: EP US)

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EP 0111687 A2 19840627; **EP 0111687 A3 19860716**; **EP 0111687 B1 19880107**; DE 3242703 A1 19840524; DE 3375260 D1 19880211; JP S59103542 A 19840615; SU 1371512 A3 19880130; US 4667394 A 19870526

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