

Title (en)
METHOD OF MAKING AN EXTRUDED FITTING FOR PANEL RADIATORS

Publication
EP 0173785 B1 19881207 (DE)

Application
EP 84710030 A 19840901

Priority
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Abstract (en)
[origin: EP0173785A1] 1. Method for the fabrication of an extruded connecting piece to panel heaters with cylindrical connecting sockets formed for onwardly transmitting connection, the connecting piece being formed for establishing a pressure-weld connection with the panel heater and manufactured from a length of solid steel wire having a 0.04 to 0.07 C content, wherein a prepared solid wire (2) is first upset and cylindrically precupped, wherein, in pursuance of the extrusion process, a foot (3) of the connecting piece (1) to be manufactured is given by respective shaping of the tool to be received an about square shape extending beyond the diameter of the dimension of upset (4) which, while the precupping dimensions (5) and the diameter of the base upset (6) are maintained, forms a cube (7) with a socket-shaped cup neck (8) extending in opposite direction of the base (6), wherein, by a subsequent step of operation, the volume (9) of the cubic part (7), as a rule with simultaneous widening of the diameter thereof to the key width (10) of the square cross-section and its lengthening into a connecting socket (11), is displaced from the latter with the outer shape being maintained, and wherein at least one face (7.1) of the cube (7) is vertically opened by machining whilst, with simultaneous lowering of the cube face (7.1), an end (12) intended for welding connection, being of annular bulge shape, suitable for pressure-weld connection, is formed.

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B21K 1/14

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Citation (examination)
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Cited by
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