

Title (en)

Forming method for crank journals having cross holes.

Title (de)

Verfahren zum Walzen von Querbohrungen aufweisende Zapfen.

Title (fr)

Méthode de formage pour tourillons ayant des orifices transversals.

Publication

**EP 0253907 B1 19940706 (DE)**

Application

**EP 86109930 A 19860719**

Priority

EP 86109930 A 19860719

Abstract (en)

[origin: US4782680A] The milling of work pieces having at least one bore in the surface to be milled by roller action, is performed by controlling the size of the force applied to the work piece surface in accordance with the rotation of the work piece and in accordance with the location of the bore. The control is such that the rolling force or pressure applied when the roller contacts the bore is smaller than the rolling force or pressure when the roller contacts the work piece surface outside the bore. The rolling force may even be applied in a pulsating manner in the zone of a bore. A minimum of the applied rolling force is reached at the latest when the roller passes over the bore diameter. In this manner undesirable deformations of the work piece surface, especially in a ring zone around the bore, are avoided.

IPC 1-7

**B24B 39/04**

IPC 8 full level

**B21H 1/00** (2006.01); **B21H 1/14** (2006.01); **B24B 39/04** (2006.01)

CPC (source: EP US)

**B24B 39/04** (2013.01 - EP US)

Cited by

DE102018126185A1; WO2020083425A1

Designated contracting state (EPC)

DE FR GB IT

DOCDB simple family (publication)

**EP 0253907 A1 19880127; EP 0253907 B1 19940706; DE 3689955 D1 19940811; JP S6330137 A 19880208; US 4782680 A 19881108**

DOCDB simple family (application)

**EP 86109930 A 19860719; DE 3689955 T 19860719; JP 19827386 A 19860826; US 4965987 A 19870513**