

Title (en)
PROGRESSIVE METHOD AND DIE FOR PUNCHED PARTS

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EP 0325947 A3 19900905 (DE)

Application
EP 89100405 A 19890111

Priority
DE 3802247 A 19880127

Abstract (en)
[origin: EP0325947A2] A progressive method for the production of punched parts in a plurality of steps, such as shaping steps, catching step and punching out. In punching out, the punched part is cut out by a punch in conjunction with a die in accordance with the outline of the punched part. The technical problem is to provide a progressive method which supplies stamped parts with virtually negligible drawing in. In a stamping step before punching out, an impression is made to a depth which is a fraction of the thickness of the strip to be punched, with an outline somewhat larger than the outline of the punched part, and the drawn-in portion formed during the stamping step is caused to flow in the punching out step, with the result that a sheared edge with straight outlines is obtained. A progressive tool comprises a stamping punch with larger cross-sectional dimensions than the punched part. <IMAGE>

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IPC 8 full level
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CPC (source: EP)
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Citation (search report)
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