Title (en)

METHOD OF BINDING METAL SHEET SECTIONS

Publication

EP 0370956 A3 19910502 (DE)

Application

EP 89810882 A 19891120

Priority

AT 284288 A 19881121

Abstract (en)

[origin: EP0370956A2] The method of bending metal sheet sections is carried out with a bending punch and a bending die (27) which has an adjustable base (28). The die holder (26), with an elastic table plate (25) in between, rests on a number of plungers (13, 14), arranged side-by-side, of plunger-cylinder units (12, 13, 14) which can be individually pressure-loaded. Before the bending process, the plunger-cylinder units (12, 13, 14) are loaded with a pressure which is greater than the air-bending force required for the bending. As a result, the said plungers (13, 14) strike a stop (17). After the air bending is complete, the bending force increases and the plungers (13, 14) located in the area of the metal sheet section to be bent are forced back. The metal sheet section is uniformly shaped along the elastic line of the punch edge. Here, the two outermost plunger-cylinder units on the left and right strike stops which compensate for the metal sheet thickness lacking at these locations provided the metal sheet section to be worked is shorter than the length of the die. <IMAGE>

IPC 1-7

B21D 5/02

IPC 8 full level

B21D 5/02 (2006.01)

CPC (source: EP US)

B21D 5/0209 (2013.01 - EP US); **B21D 5/0236** (2013.01 - EP US); **B21D 5/0272** (2013.01 - EP US)

Citation (search report)

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Designated contracting state (EPC)

AT BE CH DE ES FR GB GR IT LI LU NL SE

DOCDB simple family (publication)

EP 0370956 A2 19900530; **EP 0370956 A3 19910502**; **EP 0370956 B1 19930908**; AT 392023 B 19910110; AT A284288 A 19900715; AT E94095 T1 19930915; DE 58905534 D1 19931014; ES 2043097 T3 19931216; JP 2518512 Y2 19961127; JP H02160120 A 19900620; JP H08537 U 19960326; US 5097694 A 19920324

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