

Title (en)

Method to produce a plug chamber for cascade drawing of tubes and device for carrying out the method

Title (de)

Verfahren zur Herstellung einer Stopfenkammer beim Kaskadenziehen von Rohren und Vorrichtung zur Durchführung des Verfahrens

Title (fr)

Procédé pour fabriquer une chambre de mandrin pour le filage en cascade de tubes et dispositif pour sa mise en oeuvre

Publication

**EP 0615794 B1 19961204 (DE)**

Application

**EP 94101369 A 19940131**

Priority

DE 4306181 A 19930227

Abstract (en)

[origin: EP0615794A1] Use is made of a device (15) with a clamping and denting unit (16) and with an end-expansion and ironing unit (17). A starting tube (1) is first of all fixed locally by means of the clamping and denting unit (16). An ironing ring (30) is then moved along a freely projecting end section (31) of the starting tube (1) with the aid of an ironing cylinder (22) of the end-expansion and ironing unit (17), and a mandrel (26) is then driven into the end section (31) with the aid of a mandrel cylinder (21) of the end-expansion and ironing unit (17). Once the mandrel (26) has reached its end position, in which the inside diameter and the outside diameter of the end section (31) are enlarged, the ironing ring (30) is drawn over the end section (31), the outside diameter being reduced to the original outside diameter of the starting tube (1). Following this, the mandrel (26) too is withdrawn from the end section (31) and two dents are produced on the outer circumference of the end section (31) of the starting tube (1) with the aid of the clamping and denting unit (16). Together with a drawing point produced by forming the free end of the starting tube (1), these dents form a plug chamber into which are embedded a plurality of drawing plugs that interact with drawing dies during the cascade drawing.

<IMAGE>

IPC 1-7

**B21C 1/24**

IPC 8 full level

**B21C 1/24** (2006.01); **B21C 3/16** (2006.01)

CPC (source: EP US)

**B21C 1/24** (2013.01 - EP US)

Cited by

EP0857529A1; FR2759309A1

Designated contracting state (EPC)

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

DOCDB simple family (publication)

**US 5467631 A 19951121**; AT E145843 T1 19961215; AU 5640594 A 19940901; AU 664943 B2 19951207; BR 9400688 A 19940927; CA 2115858 A1 19940828; CA 2115858 C 19980714; DE 4306181 A1 19940901; DE 59401175 D1 19970116; EP 0615794 A1 19940921; EP 0615794 B1 19961204; ES 2095688 T3 19970216; FI 108005 B 20011115; FI 940910 A0 19940225; FI 940910 A 19940828; GR 3021911 T3 19970331; JP 3313870 B2 20020812; JP H06315715 A 19941115; MX 9401270 A 19940831; ZA 941245 B 19950124

DOCDB simple family (application)

**US 20314694 A 19940228**; AT 94101369 T 19940131; AU 5640594 A 19940225; BR 9400688 A 19940225; CA 2115858 A 19940217; DE 4306181 A 19930227; DE 59401175 T 19940131; EP 94101369 A 19940131; ES 94101369 T 19940131; FI 940910 A 19940225; GR 960403111 T 19961205; JP 2820894 A 19940225; MX 9401270 A 19940218; ZA 941245 A 19940223