

Title (en)

Method and device for the straight-drawing of material in several steps

Title (de)

Verfahren und Vorrichtung zum Geradeausziehen langen Ziehgutes in mehreren Schritten

Title (fr)

Procédé et dispositif d'étirage droit de matériau à étirer en plusieurs étapes

Publication

**EP 0774306 B1 20010725 (DE)**

Application

**EP 96250248 A 19961031**

Priority

DE 19544383 A 19951115

Abstract (en)

[origin: EP0774306A1] The drawing units comprise two alternately moved tension slides, which draw the workpiece continuously through a drawing ring in a holder in each drawing unit. At least one drawing ring holder (3,4) of a drawing unit (A,B) is provided with a measurement device (5,6) for permanent assessment of the drawing force. The drawing ring holder in each case, dependent upon the measurement value, is movable or clampable, with force or torque regulated, in the longitudinal direction (7,8) of the workpiece. The measurement device comprises a force measurement box arranged between the drawing ring holder and the drawing ring (1,2).

IPC 1-7

**B21C 1/30; B21C 1/20**

IPC 8 full level

**B21C 1/20** (2006.01); **B21C 1/30** (2006.01)

CPC (source: EP US)

**B21C 1/20** (2013.01 - EP US); **B21C 1/30** (2013.01 - EP US)

Cited by

CN110153207A; CN111515319A

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**US 5771727 A 19980630**; AT E203434 T1 20010815; DE 19544383 C1 19970410; DE 59607353 D1 20010830; EP 0774306 A1 19970521; EP 0774306 B1 20010725; ES 2158237 T3 20010901

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