Title (en)
Method for forming a bottom-profiled cup

Title (de)
Verfahren zum Herstellen eines Behälters mit profiliertem Boden

Title (fr)
Procédé pour former une coupelle avec un fond profilé

Publication
EP 1036607 A2 20000920 (EN)

Application
EP 99113803 A 19990714

Priority
US 26355099 A 19990309

Abstract (en)
An apparatus and method for forming a cup (10) having a profiled bottom generally includes a draw die (20) disposed at a first level of a double acting press. The draw die (20) cooperates with a draw pad (22) and a cut edge (24) to form and hold a blank (28) formed from a sheet of material (M). A punch assembly (30) is configured to travel through the draw die (20), thereby drawing the blank (28) over the draw die (20) into a cup (60). The punch assembly (30) transports the cup (60) to a second level of the press where it bottoms out on a die core (50) and a ring pad (51). One element of the punch assembly (30) continues to move beyond the second level of the press, thereby drawing a portion of the cup (60) over the die core (50) and profiling the bottom of the cup (60). The profiled cup (10) is then returned to the second level of the press where it is removed from the punch assembly (30) and transferred. The bottom profile insures that the cup will retain its shape during the transfer operation. <IMAGE>

IPC 1-7
B21D 22/30

IPC 8 full level
B21D 22/26 (2006.01); **B21D 22/06** (2006.01); **B21D 22/30** (2006.01); **B21D 24/00** (2006.01)

CPC (source: EP)
B21D 22/06 (2013.01); **B21D 22/30** (2013.01)

Cited by
ITMO20090142A1; US9296033B2; US10022774B2; EP3219402A1

Designated contracting state (EPC)
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU MC NL PT SE

DOCDB simple family (publication)
EP 1036607 A2 20000920; **EP 1036607 A3 20030108**; **EP 1036607 B1 20041117**; AT E282489 T1 20041215; DE 69921961 D1 20041223; DE 69921961 T2 20051222; JP 2000254736 A 20000919

DOCDB simple family (application)
EP 99113803 A 19990714; AT 99113803 T 19990714; DE 69921961 T 19990714; JP 34412199 A 19991203