

Title (en)
Casted forged parts without ejector traces

Title (de)
Gegossene Schmiedeteile ohne Auswerferspuren

Title (fr)
Pièces coulées forgées sans traces d'éjecteurs

Publication
EP 1375026 A2 20040102 (FR)

Application
EP 03356082 A 20030527

Priority
FR 0206873 A 20020531

Abstract (en)
Ejection of workpieces obtained by casting and forging of light metals, e.g., aluminum and its alloys, involves moving the receiving areas of the ejector pins from the body of the preform (2) to the side peripheral edge. During forging, the zones allowing ejection of the preform are (2b) located in the burr of the forged workpiece and are cut and removed at the same time as the burr. Preferred Features: Along the side peripheral edge of the preform and outside the piece to be produced, there are one or more continuous or spaced projecting zones that can constitute base planes that can make contact with an ejector pin assembly for lifting the preform out of its die. The invented process is applied in a COBAPRESS procedure (outlined in EP119365A) involving successive operations of casting and forging of workpieces.

Abstract (fr)
Le procédé d'éjection de pièces obtenues par coulage forgeage de pièces en alliage léger, en aluminium ou alliage aluminium, ou tous autres matériaux, est remarquable en ce qu'il consiste à déporter les zones réceptrices des éjecteurs hors du corps de la préforme considérée, en les implantant sur la bordure périphérique latérale (2a) de la préforme, et en ce que pendant la phase de forgeage, lesdites zones (2b) permettant l'éjection de la préforme se retrouvent dans la bavure de la pièce forgée et sont découpées et évacuées en même temps que la bavure. <IMAGE>

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