

Title (en)

Method and apparatus for deep drawing metal blanks for making stepped articles

Title (de)

Verfahren und Vorrichtung zum Tiefziehen von Metallrohlingen zur Hertsellung von gestuften Artikeln

Title (fr)

Procédé et dispositif d'emboutissage d'ébauches métalliques pour la production d'articles étagés

Publication

EP 1598126 A1 20051123 (EN)

Application

EP 04356077 A 20040519

Priority

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Abstract (en)

The apparatus (1) comprises : a) a cut edge (2) able to cut blanks (7) from a metal strip (6), b) a pair of blank holders (3), an upper punch (30) and a lower draw ring (31), c) a lower tool (4), typically in a fixed position, comprising a die core ring (40) and a die core (42), said die core ring (40, 40') having a shaped profile (400) and a sloped stepped part (41) having at least one step (410), d) an upper tool (5) and a punch core (51), and actuating means, and is characterised in that said punch core (51) includes at least one upper pressure sleeve (52, 52') able to cooperate axially with said step (410) so as to form said ledge (920, 920'), and a said "small" punch core (53) able to cooperate axially with said die plate (42). <?? >Advantages : stepped drawn articles exhibiting no pleats. <IMAGE>

IPC 1-7

B21D 51/44

IPC 8 full level

B21D 51/44 (2006.01)

CPC (source: EP)

B21D 51/44 (2013.01)

Citation (search report)

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DOCDB simple family (publication)

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