

Title (en)

Method and device for embossing a drum cover

Title (de)

Verfahren und Vorrichtung zum Prägen eines Trommelmantels

Title (fr)

Procédé et dispositif destinés à imprégner une enveloppe de tambour

Publication

EP 1872880 A1 20080102 (DE)

Application

EP 07109947 A 20070611

Priority

- DE 102006029952 A 20060629
- DE 102006052429 A 20061107

Abstract (en)

The procedure for introducing an embossing structure (3) into a metallic drum casing (1) of a washing drum, comprises positioning the drum casing, operationally locking the drum casing, and embossing the drum casing. The embossing pressure producing the embossing structure in the drum casing is exercised between the embossing structure consisting of a pressure drive and a supporting element. The supporting element is provided at a bearing surface with a die consisting of the counter structure. The cylindrically curved drum casing is held in a fixed position during the embossing process. The procedure for introducing an embossing structure (3) into a metallic drum casing (1) of a washing drum, comprises positioning the drum casing, operationally locking the drum casing, and embossing the drum casing. The embossing pressure producing the embossing structure in the drum casing is exercised between the embossing structure consisting of a pressure drive and a supporting element. The supporting element is provided at a bearing surface with a die consisting of the counter structure. The cylindrically curved drum casing is held in a fixed position during the embossing process. The drum casing is brought by turning and/or axially shifting into the intended embossing positions. The pressure forces exercised in the embossing on the drum casing mutually repeal themselves in the sum. Different embossing structures are produced in controlled manner. The drum casing is positioned over recesses, which has a typical function for the drum casing. The pressures produced for locking and embossing on one side from inner or outer radially aligned are on the drum casing. An independent claim is included for a device for introducing an embossing structure into a metallic drum casing of a washing drum.

Abstract (de)

Um bei einem Verfahren zum Einbringen einer Prägestruktur in einen metallischen Hohlzylinder, insbesondere in die Trommelmantel 1 einer Wäschetrommel, auf lange Sicht reproduzierbar genaue Prägestrukturen und mit einfachen Mitteln eine lange Standzeit der Werkzeugteile zu erhalten, wird der die Prägestruktur im Trommelmantel erzeugende Prägedruck zwischen einem die Prägestruktur 3 aufweisenden Druckbaustein 4 und einem Stützelement 2 ausgeübt. Erfindungsgemäß wird der zylindrisch gebogene Trommelmantel 1 während des Prägevorgangs in einer festen Position gehalten. Dazu wird der Trommelmantel 1 nacheinander bearbeitet durch Positionieren, betriebssicheres Arretieren und Prägen, wobei die Prägunen 3 in mehreren Arbeitsschritten in den Trommelmantel 1 eingebracht werden und der Trommelmantel 1 durch Drehen und / oder durch axiales Verschieben nacheinander in die vorgesehenen Prägepositionen gebracht wird. Als Besonderheit weist das Stützelement anstelle einer Prägestruktur einen elastischen Belag auf.

IPC 8 full level

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CPC (source: EP)

B21D 13/02 (2013.01)

Citation (applicant)

- DE 19954027 C2 20030123 - MIELE & CIE [DE]
- DE 10021456 C2 20030327 - MIELE & CIE [DE]

Citation (search report)

- [XY] EP 1214991 A2 20020619 - FRATTINI COSTR MECC [IT]
- [XY] US 741914 A 19031020 - KIRSCHBAUM JOHN [US]
- [DA] EP 1151811 A2 20011107 - MIELE & CIE [DE]
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ITMC20090059A1; EP4316683A1; DE102020215849A1; WO2024028057A1; EP1872881B1

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