

Title (en)  
UPSETTING METHOD AND UPSETTING DEVICE

Title (de)  
STAUCHVERFAHREN UND STAUCHVORRICHTUNG

Title (fr)  
PROCÉDÉ ET DISPOSITIF DE REFOULAGE

Publication  
**EP 1925381 A1 20080528 (EN)**

Application  
**EP 06797694 A 20060908**

Priority  

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Abstract (en)  
An upsetting method capable of manufacturing an upsetting manufactured product having a bent expanded portion under a lighter load is provided. A bar-shaped raw material 1 is loaded to the receiving die 11 in an axial movement prevented state, and the expansion scheduled portion 2 of the raw material 1 is arranged in the insertion hole 21 for holding the expansion scheduled portion 2 of the raw material 1 in a buckling prevented state. Subsequently, the guide 20 is moved in a direction opposite to a moving direction of the punch 30 while pressurizing the expansion scheduled portion 2 of the raw material 1 with the punch 30 in an axial direction, to thereby radially outwardly expand the expansion scheduled portion 2 of the raw material 1 exposed between a tip end portion of the guide 20 and the receiving die 11. In this upsetting method, the expansion scheduled portion 2 is bent while expanding the expansion scheduled portion 2 of the raw material 1.

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