

Title (en)

METHOD AND DEEP-DRAWING DEVICE FOR THE DEEP DRAWING OF SHEET METAL

Title (de)

VERFAHREN SOWIE TIEFZIEHVORRICHTUNG ZUM TIEFZIEHEN VON METALLBLECHEN

Title (fr)

PROCEDE ET DISPOSITIF D'EMBOUTISSAGE POUR L'EMBOUTISSAGE DE TOLES METALLIQUES

Publication

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Application

**EP 07703887 A 20070116**

Priority

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Abstract (en)

[origin: WO2007085550A1] Method and deep-drawing device for the deep drawing of sheet metal (8) by means of a press (6), a table (2), a drawing punch (3), and a drawing die (5) and a counterpressure plate (4) interacting with the drawing die (5), which together form a flow path (F) for the sheet metal (8), wherein at least one drawing strip (7) movable relative to the counterpressure plate (4) is pushed transversely through the flow path (F) of the sheet metal (8) in order to deflect the sheet metal (8) during a drawing phase (first deflection stage) and the drawing strip (7), for a stopping phase, is pushed by a further short distance transversely through the flow path (F) (second deflection stage), wherein a deflection increased once again during the second deflection stage inhibits the flow of the sheet metal (8), and wherein the sheet metal (8) is essentially plastically formed at the end of the deep-drawing operation, wherein the degree of deflection required during the first deflection stage is set by means of an interchangeable distance piece (14) which is arranged between the counterpressure plate (4) and the drawing strip (7) and serves as a stop. Independently thereof, the degree of deflection required during the second deflection stage can be set by further distance elements (15) which are arranged between the table (29) and the drawing strips (7).

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