

Title (en)

Manufacturing process of cylinder plug pins for electric connection and plug pins manufactured in this process

Title (de)

Herstellungsverfahren von zylindrischen Steckerstiften für elektrische Steckverbindungen und durch dieses Verfahren hergestellte Steckerstifte

Title (fr)

Procédé de fabrication de broches de prise cylindriques pour connexion électrique et broches de prise fabriquées selon ce procédé

Publication

EP 2037547 B1 20111026 (EN)

Application

EP 08014031 A 20080805

Priority

CN 200710071130 A 20070911

Abstract (en)

[origin: EP2037547A1] A manufacturing process of cylinder plug pins for electric connection on plugs and plug pins manufactured in this process. Said process mainly comprises the following steps: sorting, selecting a copper stripe with the width of 21#1/425mm and the thickness of 0.4#1/40.6mm and put it on a feeder; stamping, sending the copper strip with the sender to a drawing cavity die for multiple times of drawing till the cylinder plug pin blank conforming to the specification is achieved; cutting, evenly cut the end of a semi-finished cylinder plug pin conforming to the specification; extrusion forming, place a semi-finished cylinder plug pin with cut end breadthwise on a collet of the auto lathe with the rotating speed of 5000-6000 rpm for extrusion into finished products. This invention adopts the technology combining drawing progressive die and extrusion forming by auto lathe to produce the finished plug pin conforming to the specification, which can not only greatly reduce the production cost and save materials, but also ensure fine mechanical strengthen and conducting performance, after tests, multiple parameters of the plug pins made in this process, including the mechanical strength and the current capacity, have achieved or even exceeded the performances of solid copper bar plug pins by auto lathe.

IPC 8 full level

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CPC (source: EP)

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Cited by

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