

Title (en)  
METHOD AND DEVICE FOR DEEP DRAWING BLANKS MADE OF SHEET METAL INTO FLANGELESS MOLDED BLANKS

Title (de)  
VERFAHREN UND VORRICHTUNG ZUM TIEFZIEHEN VON ROHLINGEN AUS BLECHMATERIAL ZU FLANSCHLOSEN FORMLINGEN

Title (fr)  
PROCÉDÉ ET DISPOSITIF POUR L'EMBOUTISSAGE DE PIÈCES BRUTES DE COULÉE EN TÔLE POUR DONNER DES ÉBAUCHES SANS COLLERETTE

Publication  
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Application  
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Priority

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Abstract (en)  
[origin: WO2008092486A1] The invention relates to method for deep drawing blanks (10) punched out of sheet metal that is painted or coated with film material, for example made of steel or aluminum, into flangeless molded blanks, wherein the blanks are formed to a crucible-shaped part, which has a flangeless cylindrical edge, around a drawing core (18) by means of a drawing bell (20) of a drawing die, and a predetermined spring force is applied to the side of the edge opposite of the drawing bell (20) during the forming of the edge of the blanks (10) by means of a blank holder (22), wherein the spring force applied to the blank holder (22) is spontaneously reduced substantially to zero shortly before the end of the drawing process.

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