

Title (en)
METHOD AND BENDING PRESS FOR BENDING THE EDGE STRIPS OF A METAL SHEET TO BE SHAPED INTO AN OPEN SEAM TUBE

Title (de)
VERFAHREN UND ANBIEGEPRESSE ZUM ANBIEGEN DER RANDSTREIFEN EINES ZU EINEM SCHLITZROHR ZU FORMENDEN BLECHES

Title (fr)
PROCÉDÉ ET PRESSE À PLIER DESTINÉS À PLIER LES BANDES LATÉRALES D'UNE TÔLE À FORMER SOUS FORME DE TUBE FENDU

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Application
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Abstract (en)
[origin: WO2008110132A1] The invention relates to a method for bending a plane metal sheet to be shaped into an open seam tube, in a bending press (11) comprising an upper tool fixed in the press frame (4) and having a contour corresponding to the bending contour to be achieved, and a vertically mobile lower tool (3) arranged opposite the upper tool (1). The edge strip (3) of the metal sheet fixed in the press frame (4) is bent between said tools in a working step in order to create the desired edge contour. At the beginning of the bending process, the working surface of the lower tool (3), which comes into contact with the lower side of the edge strip (3), takes its bearing in a flat manner in the form of a Hertzian compression. In order to prevent the formation of ridges and plastic deformations or crushing, said flat contacting is to be maintained at a minimal distance from the edge of the metal sheet, at a constant distance therefrom in relation to the point of application of force (P), during the entire bending process, by means of a co-ordinated horizontal and vertical movement of the lower tool (3). The bending press (11) provides a constructive solution for carrying out said method.

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