

Title (en)

METHOD AND DEVICE FOR THE NON-CUTTING PRODUCTION OF AN OUTSIDE THREAD ON HOLLOW METAL WORK PIECES

Title (de)

VERFAHREN UND VORRICHTUNG ZUR SPANLOSEN HERSTELLUNG EINES AUSSENGEWINDES AUF HOHLFÖRMIGEN WERKSTÜCKEN AUS METALL

Title (fr)

PROCÉDÉ ET DISPOSITIF POUR RÉALISER UN FILETAGE EXTÉRIEUR SANS ENLÈVEMENT DE MATIÈRE SUR DES PIÈCES CREUSES EN MÉTAL

Publication

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Application

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Priority

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Abstract (en)

[origin: WO2010037551A2] The invention relates to a method for the non-cutting production of an outside thread on hollow metal work pieces for use as hollow screws, hollow shafts, threaded sleeves or fittings as stable connecting or fastening elements, and to a device suited for carrying out the method. Based on the disadvantages of the known prior art, a method is to be presented which is particularly suited for thin-walled work pieces and characterized by improved economic efficiency. Furthermore a device suited for carrying out the method is to be provided. As a proposed solution, within a multistage press (20) comprising a displaceable carriage (21) and a stationary work piece carrier unit (22), a wire section (27) as the base material is reshaped in one or more reshaping stages I to V into a finished hollow blank (4b). In the multistage press (20), the pre-fabricated hollow blank (4b) is inserted in a further stage VI into a multipart split tool (1, 8) having a cavity, the inside wall of which is provided with a negative threaded profile. In the closed state of the split tool (1, 8), at least one mandrel (6) is inserted into the central opening of the blank (4b) and the blank (4b) is widened, wherein the contours of the threaded profile is filled by a radial material flow and subsequently the finished work piece (4) is removed.

IPC 8 full level

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