

Title (en)  
STAMPING METHOD

Title (de)  
STANZVERFAHREN

Title (fr)  
PROCÉDÉ D'ESTAMPAGE

Publication  
**EP 2411168 B1 20150225 (DE)**

Application  
**EP 10717503 A 20100324**

Priority  
• DE 2010000353 W 20100324  
• DE 102009014217 A 20090325

Abstract (en)  
[origin: WO2010108486A2] The invention provides a stamping method, by which a flange can be produced on either side of a workpiece, and the corresponding workpiece, wherein in the 1st step a contact pressure plate (3) and a counter pressure plate (2), each having cylindrical recesses with identical inside contours having beads facing each other around the recesses, enclose the workpiece (6) and depress a groove therein on either side, wherein a lower die (1) and an upper die (4), each having inside contours that have the same cylindrical cross-sections and agree with the inside contours of the recess, are guided in said groove, said contours likewise enclosing the workpiece (6) such that behind the groove (11) a first peripheral thickened region of the workpiece (6) is created on either side, in the 2nd step the lower die (1) and counter pressure plate (2) are moved up, wherein the counter pressure plate (2) remains back in relation to the lower die (1) and the contact force between the contact pressure plate (3) and counter pressure plate (2) is maintained such that the distance between the lower die (1) and upper die (4) is reduced and the volume located in between is pressed outward, thereby enlarging the peripheral thickened region on either side, and in the 3rd step, while maintaining the pressing force of the contact pressure plate (3) and the counter pressing force of the lower die (1), the upper die (4) first presses part of the volume of the workpiece (6) downward and enlarges the peripheral thickened region on either side to the final dimension thereof, and subsequently the workpiece (6) is punched out in the same step.

IPC 8 full level  
**B21D 28/08** (2006.01); **B21D 28/26** (2006.01); **B21D 28/30** (2006.01); **B21D 28/32** (2006.01); **B21J 5/02** (2006.01); **B21K 1/26** (2006.01); **B21K 23/04** (2006.01)

CPC (source: EP)  
**B21D 28/08** (2013.01); **B21D 28/265** (2013.01); **B21D 28/30** (2013.01); **B21D 28/32** (2013.01); **B21K 1/26** (2013.01); **B21K 23/04** (2013.01)

Citation (examination)  
FR 2550110 A1 19850208 - MARCHAL EQUIP AUTO [FR]

Designated contracting state (EPC)  
AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO SE SI SK SM TR

DOCDB simple family (publication)  
**WO 2010108486 A2 20100930; WO 2010108486 A3 20110317; WO 2010108486 A4 20110505**; DE 102009014217 A1 20100930;  
DE 102009014217 B4 20101209; EP 2411168 A2 20120201; EP 2411168 B1 20150225; ES 2536751 T3 20150528; PL 2411168 T3 20150831

DOCDB simple family (application)  
**DE 2010000353 W 20100324**; DE 102009014217 A 20090325; EP 10717503 A 20100324; ES 10717503 T 20100324; PL 10717503 T 20100324