

Title (en)  
METHODS OF MANUFACTURING A RESILIENT RAIL CLIP

Title (de)  
VERFAHREN ZUR HERSTELLUNG EINER NACHGIEBIGEN SCHIENENKLEMME

Title (fr)  
PROCÉDÉS DE FABRICATION D'UN SERRE-RAIL ÉLASTIQUE

Publication  
**EP 2528702 A1 20121205 (EN)**

Application  
**EP 10796315 A 20101203**

Priority  
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• EP 2010068893 W 20101203

Abstract (en)  
[origin: GB2477282A] The method comprises bending a rod into a predetermined shape and then applying a cold setting process to induce a predetermined amount of permanent set (S). One cold setting process comprises applying a first load (Fo) to part of the bent rod so as to cause a first amount of deflection, which first load (Fo) is a predetermined load having a value equal to or greater than that required to reach the yield point of metal having the highest hardness value in the range, measuring the first amount of deflection (dx) of the part of the bent rod achieved by applying the predetermined first load (Fo), determining, on the basis of the measured deflection amount (dx), either (i) a second load (Fo + AFx), which, when applied to the bent rod part, will cause it to acquire the predetermined amount of permanent set (S), or (ii) a second amount of deflection (dx + Adx) of the bent rod part required in order to bring about the predetermined amount of permanent set (S), and applying the second load (Fo+ AFx ) to the bent rod part or deflecting it by the determined second amount of deflection (dx + Adx). An alternative cold setting process comprises deflecting part of the bent rod by a predetermined first amount (do) by applying a first load (Fx) having a value equal to or greater than that required to reach the yield point of metal having the highest hardness value in the range, measuring the amount of the first load (Fx) required to achieve the predetermined first amount of deflection (do), determining, on the basis of the measured load, either (i) a second deflection amount (do + Adx) required in order to bring about in the bent rod the predetermined amount of permanent set (S), or (ii) a second load (Fx + LFX), which, when applied to the bent rod part, will cause it to acquire the predetermined amount of permanent set (S), and deflecting the bent rod part by the determined second deflection amount (d) + Adx) or applying the determined second load (Fx + LIFx) to the bent rod part.

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