

Title (en)  
METHOD AND DEVICE FOR PRODUCING FLANGELESS DRAWN PARTS

Title (de)  
VERFAHREN UND VORRICHTUNG ZUR HERSTELLUNG VON FLANSCHLOSEN ZIEHTEILEN

Title (fr)  
PROCÉDÉ ET DISPOSITIF DE FABRICATION DE PIÈCES EMBOUTIES SANS BRIDE

Publication  
**EP 2701861 B1 20160914 (DE)**

Application  
**EP 12716437 A 20120425**

Priority  
• DE 102011050001 A 20110429  
• EP 2012057526 W 20120425

Abstract (en)  
[origin: WO2012146601A1] The invention relates to a method for producing flangeless drawn parts from a flat and/or preformed metal blank (2', 2'') using a drawing punch (1', 1''), a blank holder (5', 5'') and a drawing die (3', 3''), wherein the drawing die (3', 3'') has at least one supporting region (3a', 3a'') and at least one wall region (3b', 3b''), between which rounded run-in portions are provided, and the blank (2', 2'') is trimmed during the drawing operation. In addition, the invention relates to a device for producing flangeless drawn parts from a flat and/or preformed metal blank (2', 2'') comprising a drawing punch (1', 1''), a blank holder (5', 5''), a drawing die (3', 3'') with at least one supporting region (3a', 3a''), at least one wall region (3b', 3b'') and rounded run-in portions, which are provided between the supporting region (3a', 3a'') and the wall region (3b', 3b''). The object of providing a method and a device for producing flangeless drawn parts with which flangeless drawn parts can be produced in a process-integrated manner by drawing and trimming in a single stroke of the press, while nevertheless being trimmed cleanly, is achieved for a method by the blank (2', 2'') being trimmed in the supporting region (3a', 3a''), while the drawing operation has not yet been completed, in such a way that the part of the blank (2', 2'') that remains in the supporting region (3a', 3a'') is completely drawn into the wall region (3b', 3b'') of the drawing die (3', 3'') when the drawing punch (1', 1'') is moved further into the drawing die (3', 3'').

IPC 8 full level  
**B21D 22/20** (2006.01); **B21D 24/16** (2006.01); **B21D 37/08** (2006.01)

CPC (source: EP US)  
**B21D 22/02** (2013.01 - US); **B21D 22/22** (2013.01 - EP US); **B21D 22/30** (2013.01 - EP US); **B21D 24/16** (2013.01 - EP US)

Designated contracting state (EPC)  
AL 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 RS SE SI SK SM TR

DOCDB simple family (publication)  
**DE 102011050001 A1 20121031**; CN 103534046 A 20140122; CN 103534046 B 20160824; EP 2701861 A1 20140305; EP 2701861 B1 20160914; EP 2701861 B8 20161221; JP 2014512275 A 20140522; JP 5801950 B2 20151028; US 2014047891 A1 20140220; WO 2012146601 A1 20121101

DOCDB simple family (application)  
**DE 102011050001 A 20110429**; CN 201280021082 A 20120425; EP 12716437 A 20120425; EP 2012057526 W 20120425; JP 2014506839 A 20120425; US 201314062462 A 20131024