

Title (en)

METHOD FOR PRODUCING POT-SHAPED COMPONENTS IN A SHAPING PROCESS

Title (de)

VERFAHREN ZUR HERSTELLUNG VON TOPFFÖRMIGEN BAUTEILEN IN EINEM UMFORMPROZESS

Title (fr)

PROCÉDÉ DE FABRICATION DE PIÈCES EN FORME DE POT DANS UN PROCESSUS DE FORMAGE

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Application

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Abstract (en)

[origin: WO2013149938A1] The invention relates to a method for producing a pot-shaped component (80, 100) from a flat blank (1). The pot-shaped component (80, 100) has a substantially flat bottom area (82, 102) and a circumferential frame (81, 101) extending up from the bottom area (82, 102) in the manner of a collar, which frame is connected to the bottom area. The blank (1) has a first material thickness (D) substantially over the entire area of the blank and the bottom area (82, 102) has a second material thickness (D9), which is greater than the first material thickness (D). According to the invention, the method is characterized by at least the following steps: a) shaping the flat blank (1) in at least one deep-drawing step to form a pot-shaped raw component (17, 30, 50) having a substantially flat bottom area (15, 32, 52) and a circumferential frame (16, 31, 51) extending up from the bottom area (15, 32, 52) in the manner of a collar, which frame is connected to the bottom area, b) shaping said pot-shaped raw component (17, 30, 50) in a tool having a conically tapered die (71) and a preferably travel-controlled thrust element (75) that applies thrust to the circumferential surface of the frame (16, 31, 51) of the raw component (17, 30, 50) in the axial direction against the conically tapered die (71). In step b), the bottom area (15, 32, 52) of the raw component (17, 30, 50) is clamped at least in some areas between an ejector (72) and a hold-down means (70) and the conically tapered die (71) surrounds the bottom area (15, 32, 52) of the raw component (17, 30, 50) radially on the outside and extends in a diameter-reducing manner in the tool stroke.

IPC 8 full level

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