

Title (en)  
BENDING TOOLS FOR PRE-BENDING AND HEMMING

Title (de)  
BIEGEWERKZEUGE ZUM VORBIEGEN UND ZUDRÜCKEN

Title (fr)  
OUTILS DE CINTRAGE PERMETTANT LE CINTRAGE PRÉLIMINAIRE ET LE SERRAGE

Publication  
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Application  
**EP 14723672 A 20140327**

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Abstract (en)  
[origin: WO2014153586A1] The invention relates to a bending die (2) and a bending punch (3) for pre-bending and hemming a workpiece section (6), wherein the bending die (2) comprises a die section (7) with a slot (8) for partially receiving the bending punch (3) during hemming, said slot (8) leading from a bearing surface (5) into the interior of the bending die (2), and a hemming section (9), arranged laterally with respect thereto, with a hemming surface (10), and the bending punch comprises a punch section (12) extending from a punch base surface (32) and a hemming section (14), arranged laterally thereto, with a hemming surface (15). In this case, the hemming surface (10) on the bending die (2) is set back in a step-like manner with respect to a bearing surface (5) of the die section (7), with the result that a stop surface (25) extending from the bearing surface (5) to the hemming surface (10) is formed and the hemming section (14) on the bending punch (3) protrudes with respect to the punch base surface (32) in the direction of the punch tip (13), with the result that the hemming surface (15) protrudes in a step-like manner with respect to the punch base surface (32).

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