

Title (en)

Apparatus and method for calibrating cut surfaces of punched or fineblanked parts having burr

Title (de)

Vorrichtung und Verfahren zum Kalibrieren von Grat aufweisenden Schnittflächen an Stanz- oder Feinschneidteilen

Title (fr)

Appareil et méthode pour calibrer des surfaces de coupe avec bavure des pièces d'emboutissage ou des découpage de précision

Publication

EP 2987566 B1 20191204 (DE)

Application

EP 14002887 A 20140820

Priority

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Abstract (en)

[origin: US2016052039A1] A device and a method for shaping sheared edges on stamped or fine-blanked parts having a burr include at least one cutting stage and at least one forming stage. The forming stage includes a shaping punch which has a shaping region for smoothing the sheared edge of the outer or inner contour of the workpiece to the net shape and an embossing shoulder for mashing the burr of the outer or inner contour. The shaping punch is configured so that the shaping region initially bends the burr on the outer or inner contour away from the sheared edge, then seizes the sheared edge for widening, wherein the embossing shoulder of the shaping punch mashes the burr on the outer or inner contour when the widening on the workpiece has ended and flattens the embossing bead, created during mashing, during separating of the shaping punch from the workpiece.

IPC 8 full level

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CPC (source: CN EP US)

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Cited by

CN114160662A; CN112775290A; DE102017123745A1

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