

Title (en)

METHOD FOR PRODUCING CODING SURFACES FROM A BLANK

Title (de)

VERFAHREN ZUR HERSTELLUNG VON KODIERFLÄCHEN AUS EINEM ROHTEIL

Title (fr)

PROCÉDÉ DE FABRICATION DE SURFACES DE CODAGE À PARTIR D'UNE PIÈCE BRUTE

Publication

EP 3038770 A1 20160706 (DE)

Application

EP 14744346 A 20140728

Priority

- DE 102013109320 A 20130828
- EP 2014066192 W 20140728

Abstract (en)

[origin: WO2015028226A1] The invention relates to a method for coding a key part and a shoulder stop for a lock for a locking system, wherein a blank is separated into two coding parts by a separating cut guided perpendicularly to the longitudinal axis and in the direction of the longitudinal axis of the blank, which coding parts each have a coding surface, and wherein the two coding parts are then processed further in order to form the key and the shoulder stop. According to the invention the post-processing of each of the two coding parts in order to form the key or the shoulder stop includes the following steps: the coding part is encased with a material that is dimensionally stable and has a higher melting point than the coding part, wherein the encasing process is incomplete, such that a free area in which the coding part is free of the casing remains, the coding part is heated to a temperature that is above the melting temperature of the coding part and at which the casing is still dimensionally stable, the material of the coding part is removed from the casing through the free area in a molten or gaseous state, the mold cavity now provided by the casing is filled with the material provided for the coding surface provided on the key or the shoulder stop.

IPC 8 full level

B22C 7/02 (2006.01); **B22C 9/04** (2006.01); **B22D 25/02** (2006.01); **E05B 15/16** (2006.01); **E05B 17/00** (2006.01); **E05B 19/00** (2006.01)

CPC (source: EP US)

B22C 7/02 (2013.01 - EP US); **B22C 7/023** (2013.01 - EP US); **B22C 9/04** (2013.01 - US); **B22C 9/043** (2013.01 - EP US); **B22C 9/046** (2013.01 - EP US); **B22C 9/18** (2013.01 - US); **B22C 9/22** (2013.01 - US); **B22D 25/02** (2013.01 - EP US); **E05B 15/16** (2013.01 - EP US); **E05B 17/0004** (2013.01 - EP US); **E05B 19/00** (2013.01 - EP US)

Citation (search report)

See references of WO 2015028226A1

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

Designated extension state (EPC)

BA ME

DOCDB simple family (publication)

WO 2015028226 A1 20150305; CN 105531052 A 20160427; CN 105531052 B 20180112; DE 102013109320 A1 20150305; EP 3038770 A1 20160706; EP 3038770 B1 20170802; US 2016167114 A1 20160616; US 9527130 B2 20161227

DOCDB simple family (application)

EP 2014066192 W 20140728; CN 201480047285 A 20140728; DE 102013109320 A 20130828; EP 14744346 A 20140728; US 201615047663 A 20160219