

Title (en)
METHOD FOR PRODUCING CUTLERY AND A CUTLERY BLANKING TOOL

Title (de)
VERFAHREN ZUR HERSTELLUNG VON BESTECK UND BESTECKSTANZWERKZEUG

Title (fr)
PROCÉDÉ DE PRODUCTION DE COUVERTS ET UN OUTILLAGE DE POINÇONNAGE DE COUVERTS

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Application
EP 15815823 A 20150703

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Abstract (en)
[origin: WO2016003362A1] The present invention is directed to a method of producing cutlery and a blanking tool to be used in said method of producing cutlery. In the method a sheet metal (17) is placed on a die (3). The sheet metal (17) is held fixed on the die (3) by means of a holder (2). In a blanking stroke a punch (1) cooperates with the die (3) to form at least a part of a circumference of a cutlery blank (20) in the sheet metal (17) while the holder holds the sheet metal (17) fixed on the die (3). Thereafter the sheet metal (17) is released from the die (3). The blanking tool comprises an upper part in the form of a punch (1), an intermediate part in the form of a holder (2) and a lower part in the form of a die (3). The blanking tool further comprises means to move the punch (1) and the holder (2) together as one unit towards the die (3) during a first part of a blanking stroke for the punch (1). The punching tool comprises means to move the punch (1) in relation to the holder (2) during a second part of the blanking stroke for the punch (1). The holder (2) abuts the sheet metal (17) placed on the die (3) during said second part of the blanking stroke for the punch (1).

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Citation (examination)
• US 4267753 A 19810519 - BENNETT EDWARD D
• US 2005211032 A1 20050929 - LIU ZHI-DA [CN]
• CN 202701091 U 20130130 - WEI JIAER

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CN110640045A

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