

Title (en)  
METHOD FOR PRODUCING A TOOTHED HUB

Title (de)  
VERFAHREN ZUR HERSTELLUNG EINER VERZAHNTEN NABE

Title (fr)  
PROCÉDÉ DE FABRICATION D'UN MOYEU DENTÉ

Publication  
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Application  
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Abstract (en)  
[origin: WO2019076473A1] The invention relates to a method for producing a hub with an inner toothing from a sheet blank made of thin sheet metal, the method comprising the following steps: - deep drawing a cup-shaped indentation with a round base surface in the sheet blank in a number of drawing steps, in such a way that the thickness of the sheet blank increases in the region of the base surface; - producing a collar in the region of the base surface by means of collar drawing; - stabilising the collar by a mould resting flush against the outer surface thereof; - introducing a die having a negative of the inner toothing into the collar; and - subsequently performing bulk sheet-metal forming by axially upset forging the collar until the material in the region of the collar lies in the die. The invention also relates to a method for producing a hub having an outer toothing.

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