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54 A method for improving the backward extrusion rate of brass billets and the like, and an apparatus for the implementation thereof.

57 To improve the rate of backward extrusion of brass billets and the like, a horizontal extrusion press is provided with two parallel tubular headers (25,26) to which respective extrusion dies (29,30) are affixed permanently and which are mounted on slides (27,28) adapted to be driven in a guided fashion perpendicularly to the extrusion axis (X-X) of the press; one header (25) is set at an operative position for extrusion aligned to the extrusion axis (X-X), and

the other header (26) set at an inoperative position laterally of the axis (X-X), and a billet is extruded with said one header (25) to form a residual brass jacket (36) around the header; on completion of the extrusion step, the positions of the headers (25,26) are reversed, and said one header (25) is cleared of the residual brass jacket (36) in the inoperative position, while another billet is simultaneously extruded with said other header (26).

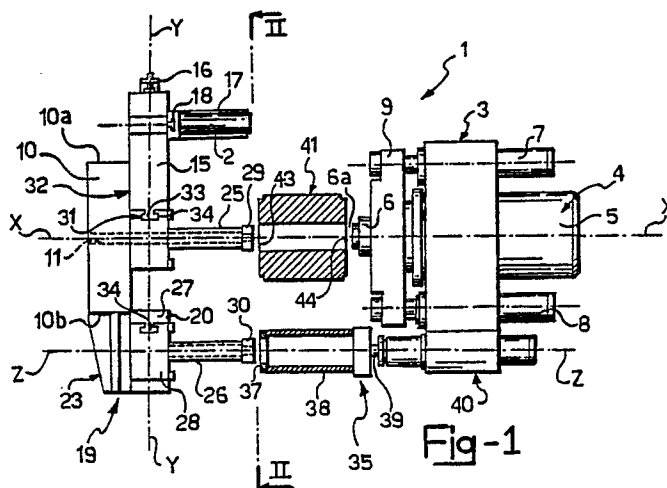


Fig-1



EP 89 10 0817

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.4)
Y	US-A-4459837 (HIROMASA HAYASHI) * column 5, line 36 - column 5, line 49; figures * ---	1, 2	B21C23/20 B21C23/21
Y	US-A-3182478 (AKIRA ASARI) * column 2, line 52 - column 2, line 60 * ---	1, 2	
A	* claim 1; figures 8-13 * ---	6, 7	
A	GB-A-897040 (HYDRAULIK GMBH) * page 1, line 83 - page 2, line 11; claims 1, 2; figures 1-5 * ---	1, 5, 7-9	
A	FR-A-2148704 (TREFIMETAUX) -----	-	
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			B21C
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 07 AUGUST 1990	Examiner BARROW J.
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			